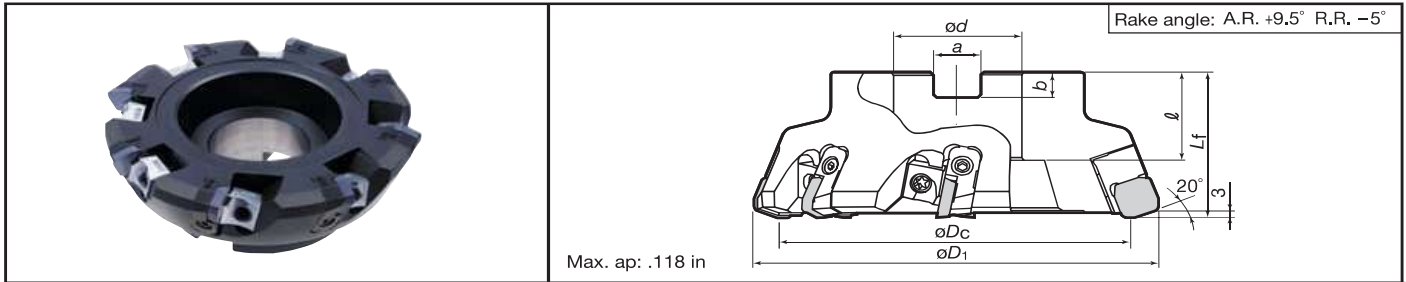


TXD15



For high feed milling of general steels, cast irons, stainless steels and hard materials



Cat. No.	Stock	No. of inserts	Dimensions (in)						Weight (kg)	Mounting details	
			ϕD_c	ϕD_1	ℓ	L_f	ϕd	b			a
TXD15125R	○	6	4.17	4.92	1.50	2.50	1.50	.394	.626	2.4	9-148
TXD15160R	○	8	5.55	6.30			2.00	.433	.748	4.2	
TXD15200R	●	10	7.12	7.87			1.86	.551	25.4	6.7	
TXD15250R	○	12	9.09	9.84						12.3	
TXD15315R		14	11.65	12.40						20.9	

Inserts

Cat. No.	Accuracy	Grades			
		AH120	AH140	T1115	T3130
SDCN1504ZDSR	C				●
SDEN1504ZDSR	E			●	●
SDNN1504ZDSR	N	●	●	●	●

Replacement parts

No.	Parts	Part Cat. No.
		TXD15125R ~ TXD15315R
①	Locator	LD150R
②	Insert locking wedge	WF150R
③	Wedge fixing screw	FDS-8ST-18
④	Locator fixing screw	CM4×0.70
-	T-handle wrench	T-27T

Standard cutting conditions

Work materials	Grades	Cutting speed Vc (SFM)	Feed per tooth fz (in/t)	Depth of cut ap (in)	Width of cut ae (in)	Cutting fluid
Carbon steels (1018,1055) < 300 HB	T3130	500 ~ 920	.039 ~ .078	.118	ϕD_1	Dry (or air-blast)
	AH120	500 ~ 820				
Alloy steels (4140, 4340) < 300 HB	T3130	500 ~ 820	.039 ~ .078			
	AH120	330 ~ 650				
Alloy steels (Prehardened steels etc.) 30 ~ 40 HRC	T3130	330 ~ 650	.020 ~ .039			
	AH120	260 ~ 500				
Stainless steels (JIS SUS304 etc.)	AH140	500 ~ 820	.039 ~ .078			
Cast irons (JIS CLASS 25-40)	T1115	330 ~ 820	.039 ~ .078			
Hard materials 40 ~ 50HRC	AH120	200 ~ 330	.020 ~ .039			

- Note:
- When ap and ae are the higher limit, use the lower limit of feed rate value shown above.
 - The maximum depth of cut for these TAC mills are 3.0 in. For milling the work material with rough outer skin or many interrupted areas, reduce the feed per tooth and the maximum depth of cut to 1/2 to 2/3 of the values shown in the table.
 - The cutting condition is limited by machine rigidity and power. The operation should start at half of the recommended speed. The amount of vibration and machine power should then be evaluated before increasing the cutting speed.
 - When wet machining mild steels, carbon steels and alloy steels, use T3130 at lower cutting conditions.
 - This TAC mill is not designed to cope with the centrifugal force and dynamic balance at high speeds over 3300 SFM. Therefore, the cutting speed in the outer diameter of the mill should not exceed 3300 SFM.

● : Stocked items.

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