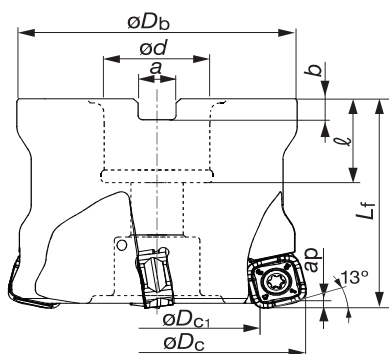


Cutter



Replacement parts

Description	Parts Cat. No.
Clamping screw	CSPB-4
Wrench	Bit
	Handle
	BLD IP15/S7
	H-TBS

Bore type

Max. ap = .079"

Cat. No.	Stock	No. of inserts	Dimensions (in)								Weight (lb)	Air hole	Center bolt	Insert
			ϕD_c	ϕD_{c1}	ϕD_b	ϕd	ℓ	L_f	b	a				
TXQ12R200U0075A03	●	3	2.000	1.362	1.850	.750	.750	1.969	.197	.315	1.12	with	(C0.375X1.125H)	SQMU1206 ZSR-MJ
TXQ12R200U0075A04	●	4	2.000	1.362	1.850	.750	.750	1.969	.197	.315	1.12		(C0.375X1.125H)	
TXQ12R250U0075A04	●	4	2.500	1.862	2.323	.750	.750	1.969	.197	.315	1.76		(C0.375X1.125H)	
TXQ12R300U0100A05	●	5	3.000	2.362	2.835	1.000	1.024	2.480	.236	.374	3.77		(C0.500X1.375H)	
TXQ12R400U0150A06	●	6	4.000	3.362	3.780	1.500	1.457	2.480	.394	.626	5.71		(TMBA-0.750H)	
TXQ12R500U0150A07	●	7	5.000	4.362	3.780	1.500	1.457	2.480	.394	.626	7.01		(TMBA-0.750H)	
TXQ12R600U0200A08	●	8	6.000	5.37	3.937	2.000	1.496	2.48	.433	.748	7.35		(TMBA-M24H)	

Standard cutting conditions

Work material		Hardness	Priority	Grades	Cutting speed Vc (sfm)	Feed per tooth fz (ipt)
High carbon steels (1045, 1055 etc.)		~ 300HB	First choice	AH725	330 - 980	.020 - .080
			For wear resistance	T3130		
			For impact resistance	AH130		
Alloyed steels (4140 etc.)		~ 300HB	First choice	AH725	330 - 660	.020 - .060
			For wear resistance	T3130		
			For impact resistance	AH130		
Prehardened steels (NAK80, PX5, etc.)		30 ~ 40HRC	-	AH725	330 - 660	.020 - .040
Stainless steel (304, 316 etc.)		~ 200HB	-	AH130	330 - 500	.012 - .030
Gray cast iron (No.25, No.30 etc.)		-	-	AH120	330 - 980	.020 - .080
Ductile cast irons (60-40-18, 65-45-12 etc.)		-	-	AH120	260 - 660	.020 - .080
Titanium alloy (Ti-6Al-4V etc.)		~ 40HRC	-	AH725	100 - 200	.012 - .028
Hardened steels	(H13 etc.)	40 ~ 50HRC	-	AH725	260 - 430	.004 - .012
	(D2 etc.)	50 ~ 60HRC			160 - 230	.001 - .003

- Slot or pocket milling is not recommended, since the chip re-cutting easily occurs.
- Tool overhang length must be as short as possible to avoid chatter. When the tool overhang length is long, decrease the number of revolutions and feed.
- Cutting conditions are generally limited by the rigidity and power of the machine and the rigidity of the workpiece. When setting the conditions, start from half of the values of the standard cutting conditions and then increase the value gradually while making sure the machine is running normally.

● : Stocked items.