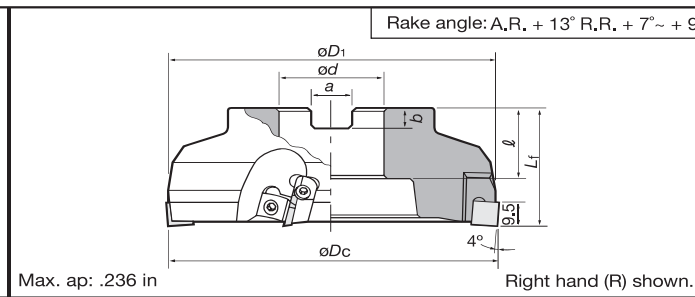




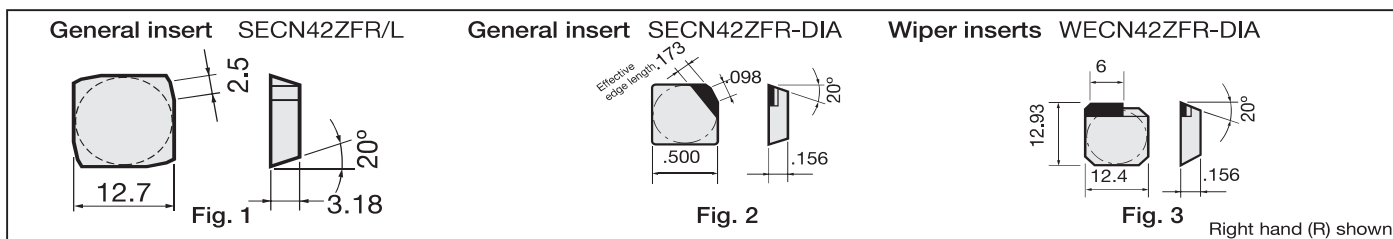
For general purpose milling of aluminum alloys and non-ferrous metals

PCD and PCBN Tools



Cat. No.	Stock	No. of Inserts	Dimensions (in)							Weight (kg)	Mounting Details
			ϕD_c	ϕD_1	ϕd	ℓ	L_f	b	a		
THE4003RIA	○	4	3.15	3.15	1.00	1.02	1.97	.236	.374	1.5	9-148A
THE4004RIA	○	5	3.94	3.90	1.25	1.25	2.48	.315	.500	.083	
THE4005RIA	○	6	4.92	4.88	1.50	1.50			.394	.626	.166

Inserts

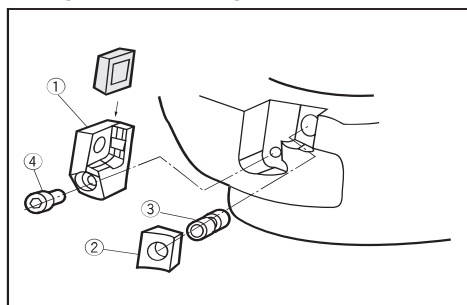


Type	Cat. No. (Inch)	ISO Cat. No. (Metric)	Accuracy	Honing	Grades			Figure
					Uncoated	T-DIA		
					TH10	DX140	DX160	
General	SECN42ZFR	SECN42ZFR	C	Without	○			Fig. 1
	SECN42ZFR-DIA	SECN42ZFR-DIA				○		Fig. 2
	SEEN42ZFR	SEEN42ZFR			○			Fig. 1
Wiper	WECN42ZFR-DIA	WECN42ZFR-DIA	C			○		Fig. 3

Note: T-DIA is trade name for Tungaloy's PCD grade. Available in one-corner type. Inserts can be used for former PS-series TAC mills.

"DX140", "DX160" : Packing Quantity = 1 pcs.

Replacement parts



No.	Parts	Part Cat. No.
①	Locator	LE413R/L
②	Insert locking wedge	WP440R/L
③	Wedge fixing screw	FDS-8S (*FDS-8SS)
④	Locator fixing screw	CM4×0.7×14
-	T-handle wrench	TP-4

Note: * marked part is for THE4003R/LIA.

- No. of revolutions (min⁻¹) = SFM X 3.82 ÷ Cutter diameter ϕ
- Table feed (in/min) = No. of revolutions × Feed per tooth × No. of inserts

Standard cutting conditions

Work materials	Grades	Cutting speed v_c (SFM)	Feed per tooth f_z (ipt)
Aluminum alloys (Si < 13%)	TH10	650 ~ 3300	.002 ~ .008
	DX140		
Aluminum alloys (Si ≥ 13%)	TH10	260 ~ 650	.004 ~ .008
	DX140	650 ~ 400	
Duralumin	TH10	650 ~ 3300	.002 ~ .008
	DX140		
Copper alloys	TH10	650 ~ 1640	

Note : Use of water-soluble cutting fluid is recommended. Maximum depth of cut for SECN42ZFR-DIA is .138 in.

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

○ : Stocked in Japan