MillLine

TUNG-TRI

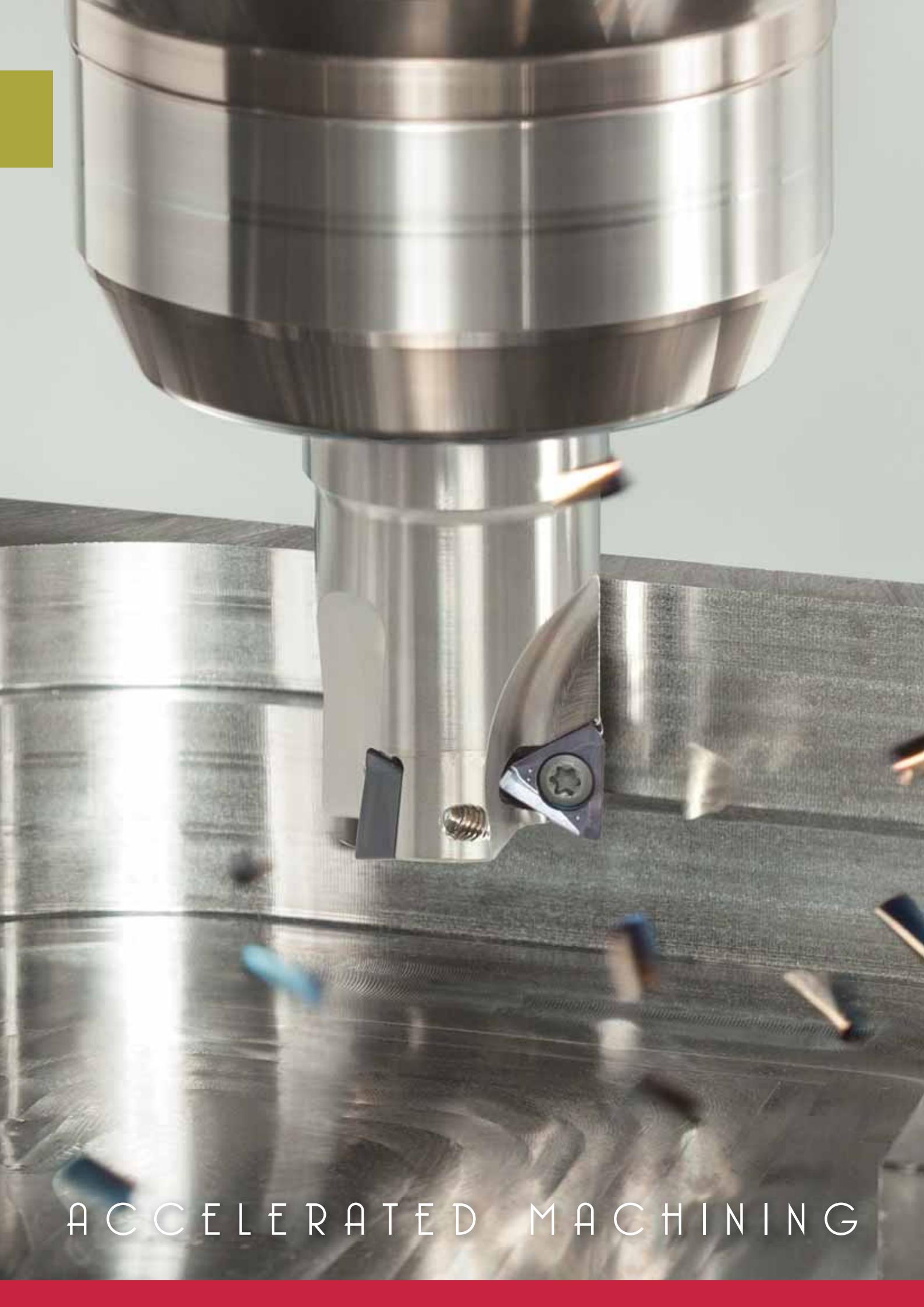
www.tungaloy.com

Tungaloy Report No. 421-G

Economical cutter with **new CVD grades** for longer tool life in high speed milling

INDUSTRY 4.0

FEED the SPEED!


ACCELERATED MACHINING

MillLine

TUNG-TRI

TUNGALOY

TUNG FORCE MILL

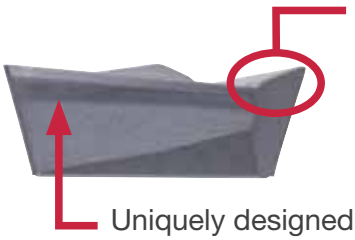
ACCELERATED MACHINING

Shoulder milling cutter with **cost-efficient inserts and outstanding chatter stability**

TUNG-TRI
TUNGALOY

Excellent cutting performance with improved profitability

Economical 3 cutting-edge inserts

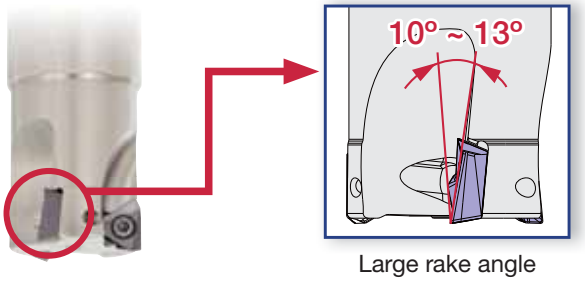


Good surface finish due to positive inclination on wiper edge

Uniquely designed flank face with built-in "margin" that prevents chattering and chipping.

Drastically reduced cutting force

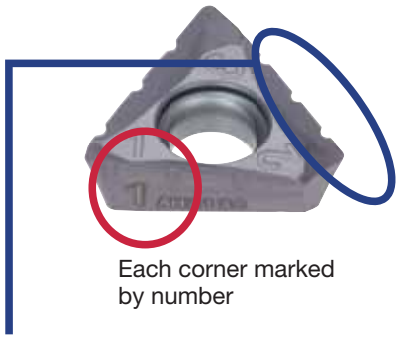
Low cutting force for all depths of cut due to helical cutting edge with large rake angle.



Large rake angle

Excellent chip formation

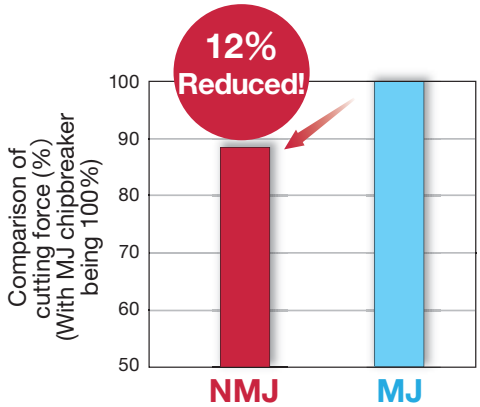
NMJ chipbreaker



Each corner marked by number

Chip splitter help form small chips

- 10% reduction in cutting force compared to MJ chipbreaker due to split chips.
- Suitable for machining with large width of cut due to split chips.



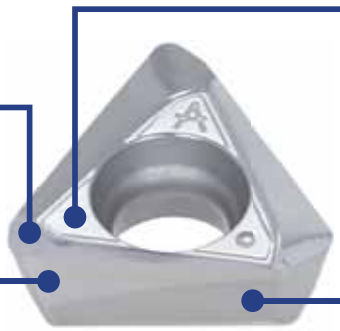
Cutter	: TPA15R080M25.4-06 (ø80 mm, z = 6)
Insert	: TOMT150608PDER-NMJ TOMT150608PDER-MJ
Grade	: AH3135
Workpiece	: SCM440 / 42CrMo4 (200HB)
Cutting speed	: *Vc* = 100 m/min
Feed per tooth	: *fz* = 0.10 mm/t
Depth of cut	: *ap* = 13 mm
Width of cut	: *ae* = 29 mm
Coolant	: Wet
Machine	: Vertical M/C, BT50

Good performance on machining

AJ chipbreaker

Wiper with positive inclination
→ Good surface finish by directing chips away from wall

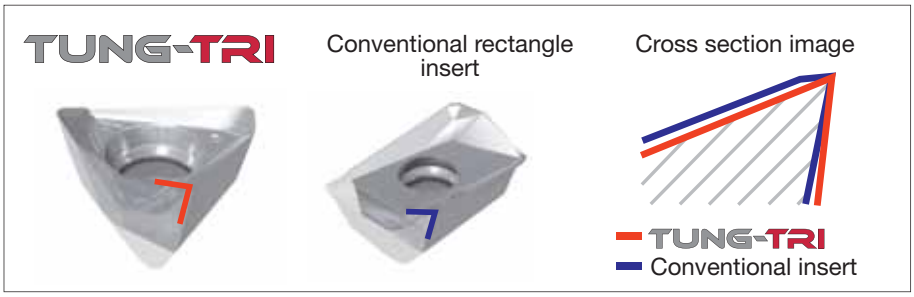
Large rake angle & high inclination cutting edge
→ Low cutting force and smooth cutting



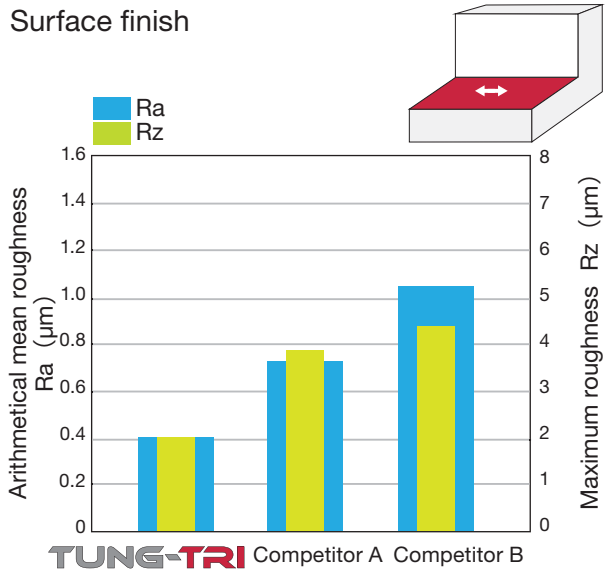
Lapping treatmen
→ Prevent welding on the workpiece material

Anti-chatter design
→ The clearance geometry is optimized to enhance insert robustness and vibration-damping for aluminum machining

■ Cutting edge comparison: cross sections

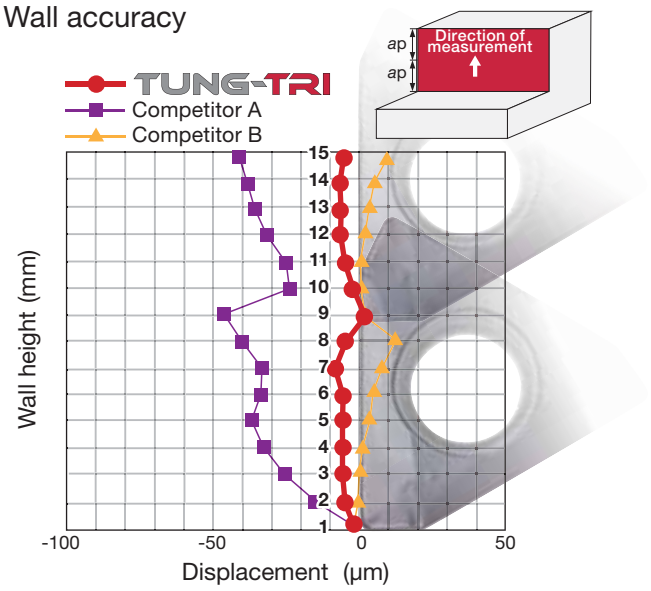


■ Surface finish



Cutter	: EPA10R032M32.0-03N
Insert	: TOGT100408PDFR-AJ
Grade	: KS05F
Workpiece	: A7075 (Alumigo Hard)
Cutting speed	: *Vc* = 900 m/min
Feed per tooth	: *fz* = 0.10 mm/t
Depth of cut	: *ap* = 2 mm
Width of cut	: *ae* = 21 mm
Coolant	: External air
Machine	: Vertical M/C, HSK63A

■ Wall accuracy



Cutter	: EPA10R032M32.0-03N
Insert	: TOGT100408PDFR-AJ
Grade	: KS05F
Workpiece	: A7075 (Alumigo Hard)
Cutting speed	: *Vc* = 900 m/min
Feed per tooth	: *fz* = 0.10 mm/t
Depth of cut	: *ap* = 8 mm x 2 pass
Width of cut	: *ae* = 5 mm
Coolant	: External air
Machine	: Vertical M/C, HSK63A

New coated grade offers long tool life

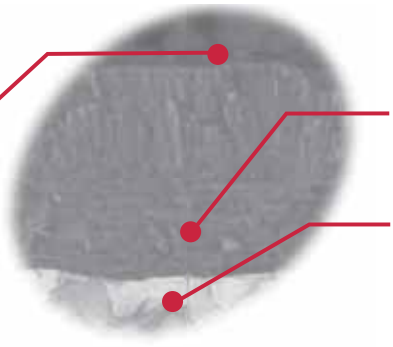
New grade for steel and stainless steel machining
Dramatically improved chipping and fracture resistance

- Multi-layered coating prevents crack expansion which causes chipping and fracture.
- Exclusive carbide substrate with remarkable impact resistance and toughness.

AH3135 P Steel M Stainless

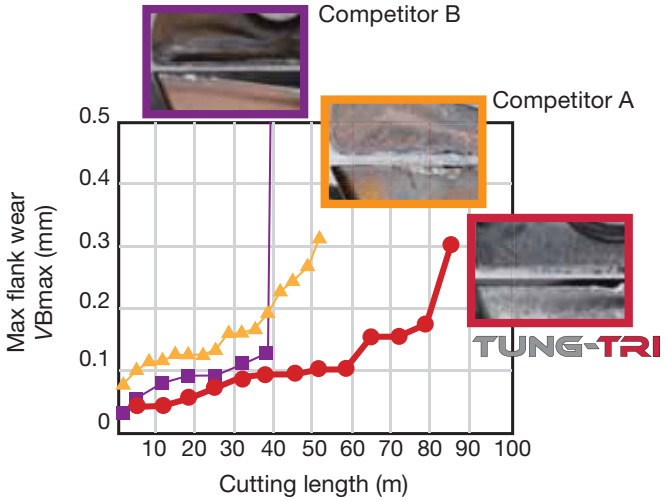
Special Surface Technology
PREMIUMTEC TUNGALOY

Smooth insert surface prevents chip adhesion!



Long tool life due to high wear resistance

■ Tool life



Cutter	: EPA15R040M32.0-03N (ø40 mm, z = 3)
Insert	: TOMT150608PDER-MJ
Grade	: AH3135
Workpiece material	: S55C / C55 (200HB)
Cutting speed	: *Vc* = 200 m/min
Feed per tooth	: *fz* = 0.2 mm/t
Depth of cut	: *ap* = 9 mm
Width of cut	: *ae* = 13 mm
Coolant	: Dry
Machine	: Vertical M/C, BT50

Specification

Application	Grade	Substrate			Coating layer		Features
	Application code	Relative density	Hardness HRA	T.R.S. (GPa)	Main Composition	Thickness (µm)	
P Steel M Stainless	**AH3135** P30 - P40	14.0	89.5	2.8	(Ti, Al)N Multi-layer	4	**First choice for steel and stainless steel** Improved chipping and fracture resistances
K Cast Iron S Superalloys	**AH120** K15 - K30	14.5	90.8	2.8	(Ti, Al)N	3	**General purpose grade for varietis of materials** Well-balanced performance
P Steel M Stainless	**T3225** P20 - P35	14.0	89.5	2.8	TiCN-Al2O3	10	**The latest grade for high speed machining of steel and stainless steel.** Significantly improved wear resistance
K Cast Iron	**T1215** K10 - K25	14.8	91.5	1.7	TiCN-Al2O3	10	**First choice for cast iron** Improved wear resistance
N Non-ferrous	**KS05F** N05 - N15	15	93	2.9	Uncoated	-	**For non-ferrous applications** Excellent chipping resistance and cuttig edge sharpness

Rich grade lineup for every kind of material

- A total of five grades, including new CVD grade

AH3135
P Steel, M Stainless

- PVD grade for high fracture resistance
- Most suitable for steel and stainless steel in general cutting parameters

AH120
P Steel, K Cast Iron

- PVD grade with a well-balanced wear and fracture resistance
- Ideal for general machining of steel and stainless steel

KS05F
N Non-ferrous

- Non-coated carbide grade featuring sharp cutting edge and toughness, while reducing built-up edge formation
- Most suited for non-ferrous materials

New

T3225
P Steel, M Stainless

- CVD grade with superior resistance to chipping and fracture
- Ideal for high speed machining of steel and stainless steel

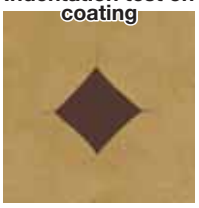
T1215
K Cast Iron

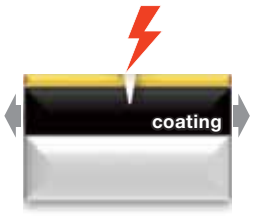
- CVD grade with superior resistance to wear and chipping
- Ideal for high speed machining of cast iron

Special Surface Technology

PREMIUMTEC TUNGALOY

Indentation test on coating

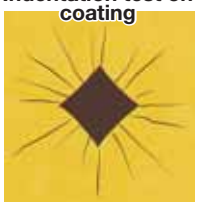


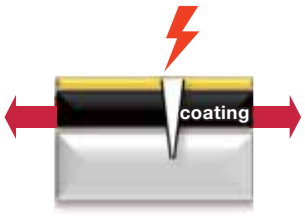


PremiumTec controls tensile residual stress and improves crack resistance.

Conventional item

Indentation test on coating

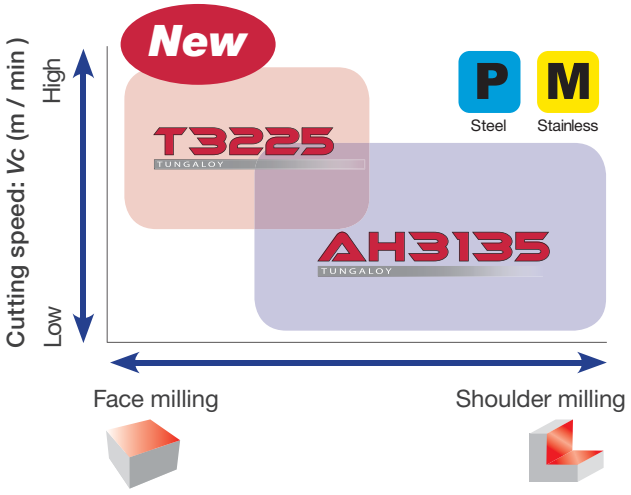


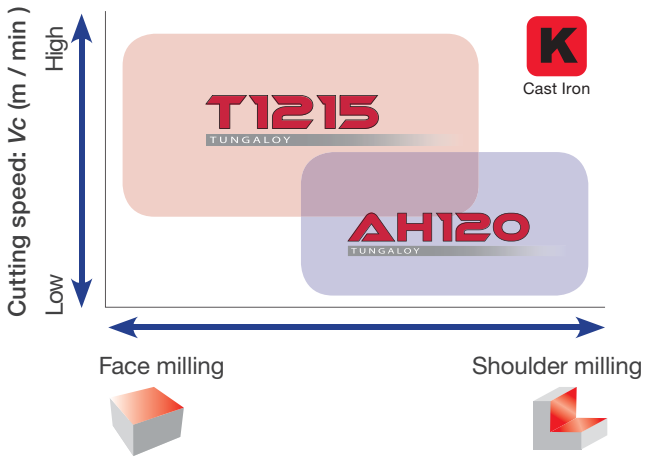


CVD coat by nature has high tensile residual stress allowing crack propagation easily.

PremiumTec technology enhances both smoothness and toughness on coating surface, improving resistance to chipping, build-up edge, and fracture.

Application area

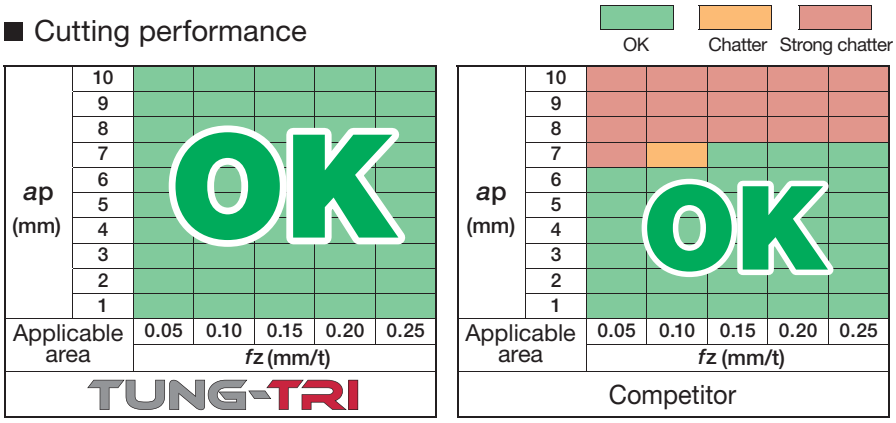




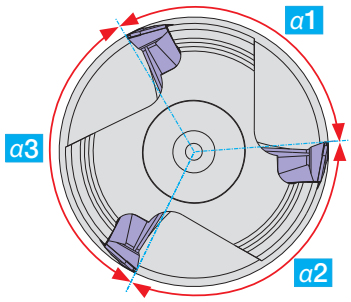
Applicable for a wide range of cutting conditions

Insert positioning in irregular pitch, combined with uniquely designed flank face of inserts, prevents chattering during machining.

■ Cutting performance



Irregular pitch



$\alpha 1 \neq \alpha 2 \neq \alpha 3$

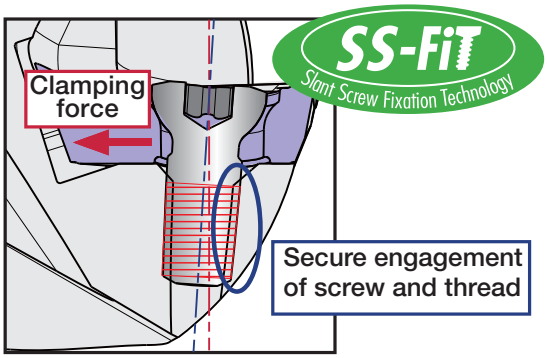
Cutter	: EPA10R032M32.0-03N (ø32 mm, z = 3)
Insert	: TOMT100404PDER-MJ
Grade	: AH3135
Workpiece	: S55C / C55 (200 HB)
Cutting speed	: *Vc* = 150 m/min
Width of cut	: *ae* = 32 mm
Machine	: Vertical M/C, BT50

High reliability

Significant increase in clamping rigidity due to large-sized screws and "SS-FiT" technology

■ Screw size

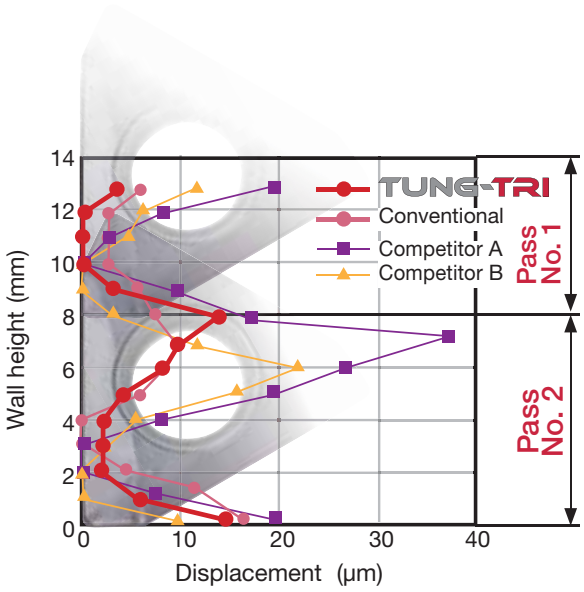
Inserts	TUNG-TRI	Competitor
TOMT06	M2.5	M1.8
TOMT10	M3.5	M2.5
TOMT15	M4.5	M4



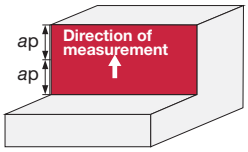
Excellent wall accuracy

High wall accuracy due to helical cutting edge with low cutting force

■ Wall accuracy



Cutter	: EPA10R032M32.0-03N (ø32 mm, z = 3)
Insert	: TOMT100404PDER-MJ
Grade	: AH3135
Workpiece	: S55C / C55 (200HB)
Cutting speed	: *Vc* = 150 m/min
Feed per tooth	: *fz* = 0.1 mm/t
Depth of cut	: *ap* = 8 mm x 2 pass
Width of cut	: *ae* = 5 mm
Machine	: Vertical M/C, BT50



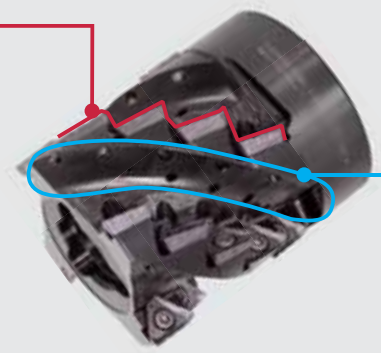
■ Result amount of displacement

TUNG-TRI	: within 15 µm
Conventional	: within 17 µm
Competitor A	: within 22 µm
Competitor B	: within 35 µm

Roughing type

Excellent chattering resistance

- Ideal insert positioning in high helix angle
- Irregular pitch

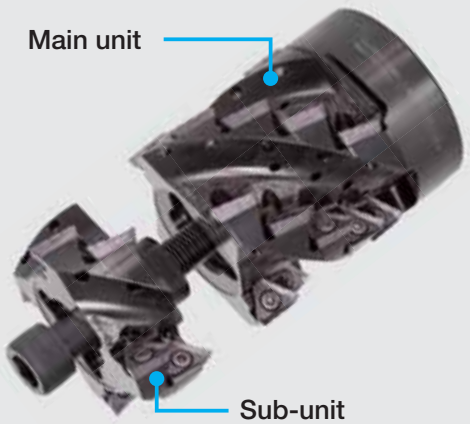


Smooth chip evacuation

- Big chip gullet that is applicable for large width of cut

Main and sub-unit system (TLA15 type)

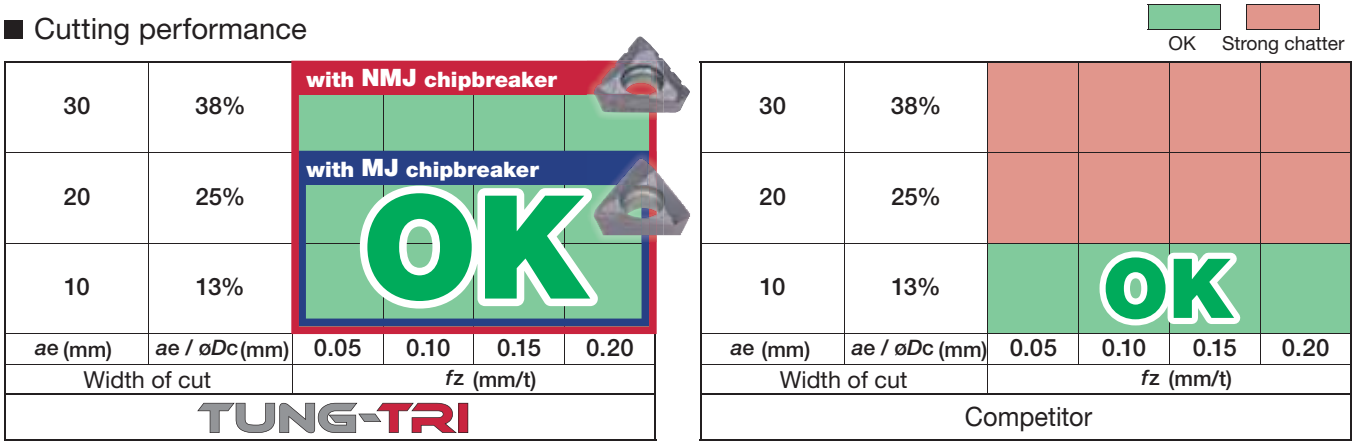
- **Exchangeable sub-units**
  (A main unit can be used without the sub-unit.)
- **Adjustable cutting length**
  Maximum depth of cut can be increased
  (Up to 2 sub-units are applicable on a main unit to increase depth of cut.)



Comparison of application area

- Strong resistance to chattering and low cutting force cover a wide range of applications.
- The application range is remarkably expanded with NMJ chipbreaker.

■ Cutting performance



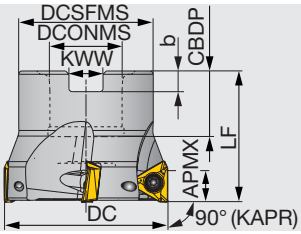
Cutter : TLA15R080L070M31.7-04M (ø80 mm, z = 4)
Insert : TOMT150608PDER-NMJ, TOMT150608PDER-MJ
Grade : AH3135
Workpiece : SCM440 / 42CrMo4 (270HB)

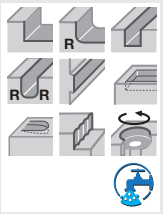
Cutting speed : *Vc* = 100 m/min
Depth of cut : *ap* = 55 mm
Coolant : Wet
Machine : Vertical M/C, BT50

TPA06

High precision square shoulder mill, with screw clamp system, for triangular inserts

GAMP = +8.5°~ +11.5°, GAMF = -5.5°~ -12.5°





Designation	APMX	DC	CICT	DCSFMS	DCONMS	CBDP	LF	b	KWW	WT(kg)	Air hole	Insert
TPA06R032M16.0E05	6	32	5	30	16	18	40	5.6	8.4	0.14	with	TOMT06...
TPA06R040M16.0E06	6	40	6	35	16	18	40	5.6	8.4	0.22	with	TOMT06...
TPA06R050M22.0E08	6	50	8	41	22	20	40	6.3	10.4	0.31	with	TOMT06...

SPARE PARTS

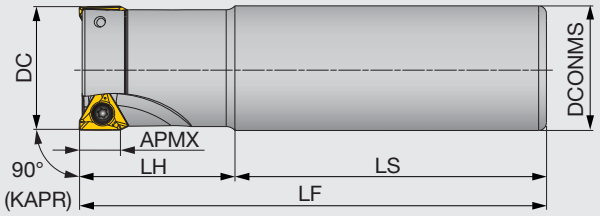
Designation	Clamping screw	Lubricant	Center bolt	Wrench
TPA06R032M16.0E05	CSTB-2.5	M-1000	FSHM8-30H	T-8D
TPA06R040M16.0E06	CSTB-2.5	M-1000	CM8X30H	T-8D
TPA06R050M22.0E08	CSTB-2.5	M-1000	CM10X30H	T-8D

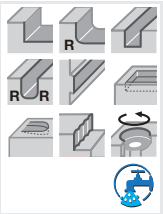
*Recommended clamping torque (N·m):CSTB-2.5=1.3

EPA06

High precision square shoulder endmill, shank type, with screw clamp system, for triangular inserts

GAMP = +8.5°~ +11.5°, GAMF = -5.5°~ -12.5°





Designation	APMX	DC	CICT	DCONMS	LS	LH	LF	WT(kg)	Air hole	Insert
EPA06R012M16.0-01N	6	12	1	16	50	18	68	0.09	without	TOMT06...
EPA06R016M16.0-02N	6	16	2	16	60	24	84	0.12	without	TOMT06...
EPA06R016M16.0-02L	6	16	2	16	105	40	145	0.2	with	TOMT06...
EPA06R018M16.0-02N	6	18	2	16	60	24	84	0.13	without	TOMT06...
EPA06R018M16.0-02L	6	18	2	16	115	30	145	0.21	with	TOMT06...
EPA06R020M16.0-02N	6	20	2	16	60	30	90	0.14	without	TOMT06...
EPA06R020M20.0-02N	6	20	2	20	70	30	100	0.23	without	TOMT06...
EPA06R020M20.0-03N	6	20	3	20	70	30	100	0.22	without	TOMT06...
EPA06R020M20.0-02L	6	20	2	20	135	50	185	0.41	with	TOMT06...
EPA06R022M20.0-02N	6	22	2	20	70	30	100	0.23	without	TOMT06...
EPA06R022M20.0-03N	6	22	3	20	70	30	100	0.23	without	TOMT06...
EPA06R022M20.0-02L	6	22	2	20	145	40	185	0.42	with	TOMT06...
EPA06R025M25.0-03N	6	25	3	25	80	35	115	0.41	without	TOMT06...
EPA06R025M25.0-04N	6	25	4	25	80	35	115	0.41	without	TOMT06...
EPA06R025M25.0-02L	6	25	2	25	150	70	220	0.78	with	TOMT06...
EPA06R028M25.0-03N	6	28	3	25	80	35	115	0.42	without	TOMT06...
EPA06R028M25.0-04N	6	28	4	25	80	35	115	0.42	without	TOMT06...
EPA06R028M25.0-02L	6	28	2	25	180	40	220	0.8	with	TOMT06...

SPARE PARTS

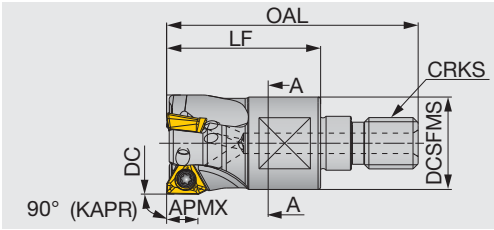
Designation	Clamping screw	Lubricant	Wrench
EPA06R012 - 018M...	CSTB-2.5S	M-1000	T-8D
EPA06R020 - 028M...	CSTB-2.5	M-1000	T-8D

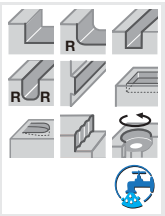
*Recommended clamping torque (N·m):CSTB-2.5S/CSTB-2.5=1.3

HPA06-M

High precision square shoulder endmill, modular type, for triangular inserts (TungFlex)

GAMP = +8.5°~ +11.5°, GAMF = -12.5°~ -5.5°





Designation	APMX	DC	CICT	OAL	LF	H	DCSFMS	CRKS	WT(kg)	Air hole	Insert
HPA06R016MM08-02	6	16	2	42	25	10	13	M8	0.03	with	TOMT06...
HPA06R020MM10-03	6	20	3	49	30	15	18	M10	0.06	with	TOMT06...
HPA06R025MM12-04	6	25	4	57	35	17	21	M12	0.1	with	TOMT06...
HPA06R032MM16-05	6	32	5	63	40	22	29	M16	0.20	with	TOMT06...

• Please see the page **17** for TungFlex modular shank.

SPARE PARTS



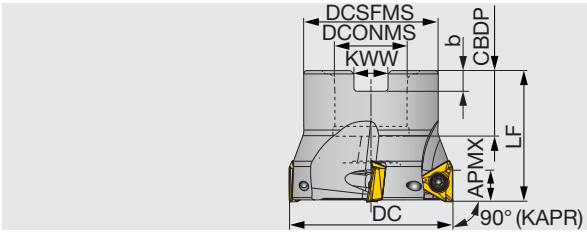
Designation	Clamping screw	Lubricant	Wrench
HPA06R016MM08-02	CSTB-2.5S	M-1000	T-8D
HPA06R020 - 032MM...	CSTB-2.5	M-1000	T-8D

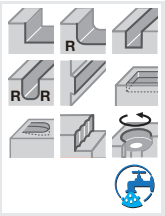
*Recommended clamping torque (N·m):CSTB-2.5S/CSTB-2.5=1.3

TPA10

High precision square shoulder mill, with screw clamp system, for triangular inserts

GAMP = +9.5°~ +11°, GAMF = -4.5°~ -0.5°





Designation	APMX	DC	CICT	DCSFMS	DCONMS	CBDP	LF	b	KWW	WT(kg)	Air hole	Insert
TPA10R040M16.0E04	10	40	4	35	16	18	40	5.6	8.4	0.2	with	TO*T10...
TPA10R050M22.0E04	10	50	4	41	22	20	40	6.3	10.4	0.31	with	TO*T10...
TPA10R063M22.0E06	10	63	6	41	22	20	40	6.3	10.4	0.51	with	TO*T10...
TPA10R080M25.4-07	10	80	7	58	25.4	26	50	6	9.5	1.04	with	TO*T10...
TPA10R080M27.0E07	10	80	7	58	27	22	50	7	12.4	1.04	with	TO*T10...
TPA10R100M31.7-08	10	100	8	70	31.75	32	63	8	12.7	2.02	with	TO*T10...
TPA10R100M32.0E08	10	100	8	60	32	28.5	50	8	14.4	2.02	with	TO*T10...

SPARE PARTS





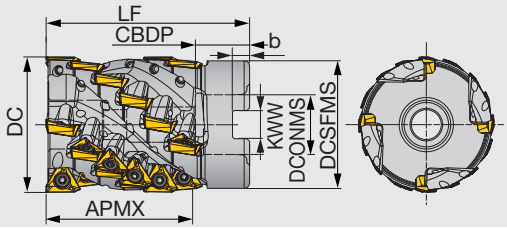
Designation	Clamping screw	Grip	Lubricant	Center bolt	Torx bit
TPA10R040M16.0E04	SR14-562/S	SW6-SD	M-1000	CM8X30H	BLDT10/S7
TPA10R050, 063M...	SR14-562/S	SW6-SD	M-1000	CM10X30H	BLDT10/S7
TPA10R080M...	SR14-562/S	SW6-SD	M-1000	CM12X30H	BLDT10/S7
TPA10R100M...	SR14-562/S	SW6-SD	M-1000	CM16X40H	BLDT10/S7

*Recommended clamping torque (N·m):SR14-562/S=3.5

TLA10

Square shoulder mill for roughing, with screw clamp system, for triangular inserts

GAMP = +9.5°~ +11°, GAMF = -4.5°~ -0.5°



Designation	APMX	DC	ZEFP	CICT	DCSFMS	DCONMS	CBDP	LF	b	KWW	WT(kg)	Air hole	Insert
TLA10R050L054M22.0E04	54	50	4	24	47	22	20	75	6.3	10.4	0.64	with	TO*T10...
TLA10R063L054M25.4-04	54	63	4	24	60	25.4	26	80	6	9.5	1.26	with	TO*T10...
TLA10R063L054M27.0E04	54	63	4	24	60	27	22	80	7	12.4	1.25	with	TO*T10...

Note: Coolant needs to be supplied from the end of the arbor inlay. Coolant cannot be supplied from the set bolt.

SPARE PARTS

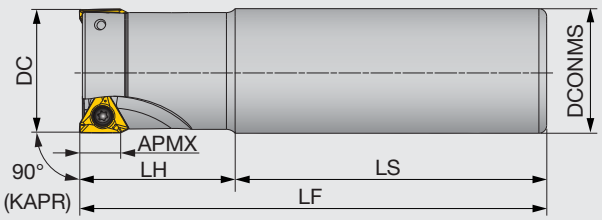
Designation	Clamping screw	Lubricant	Center bolt	Center bolt 1	Wrench
TLA10R050L054M22.0E04	SR14-562	M-1000	CAP-CM10X1.5X55-H	-	T-10D
TLA10R063L...	SR14-562	M-1000	-	CAP-CM12X1.75X50	T-10D

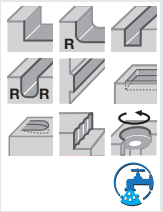
*Recommended clamping torque (N·m):SR14-562=2.5

EPA10

High precision square shoulder endmill, shank type, with screw clamp system, for triangular inserts

GAMP = +9.5°~ +11°, GAMF = -4.5°~ -0.5°





Designation	APMX	DC	CICT	DCONMS	LS	LH	LF	WT(kg)	Air hole	Insert
EPA10R025M25.0-02N	10	25	2	25	80	35	115	0.38	without	TO*T10...
EPA10R025M25.0-02L	10	25	2	25	150	70	220	0.75	with	TO*T10...
EPA10R028M25.0-02N	10	28	2	25	80	35	115	0.39	without	TO*T10...
EPA10R028M25.0-02L	10	28	2	25	185	35	220	0.78	with	TO*T10...
EPA10R032M32.0-02N	10	32	2	32	80	40	120	0.66	without	TO*T10...
EPA10R032M32.0-03N	10	32	3	32	80	40	120	0.65	without	TO*T10...
EPA10R032M32.0-02L	10	32	2	32	175	80	255	1.46	with	TO*T10...
EPA10R035M32.0-02N	10	35	2	32	80	40	120	0.7	without	TO*T10...
EPA10R035M32.0-03N	10	35	3	32	80	40	120	0.68	without	TO*T10...
EPA10R035M32.0-02L	10	35	2	32	215	40	255	1.52	with	TO*T10...
EPA10R040M32.0-03N	10	40	3	32	80	40	120	0.72	without	TO*T10...
EPA10R040M32.0-04N	10	40	4	32	80	40	120	0.73	without	TO*T10...
EPA10R040M32.0-02L	10	40	2	32	205	50	255	1.57	with	TO*T10...

SPARE PARTS

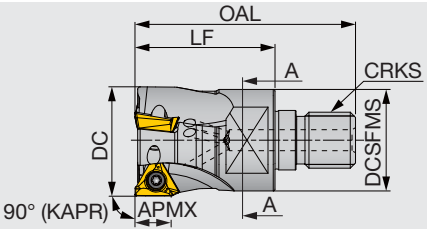
Designation	Clamping screw	Grip	Lubricant	Torx bit
EPA10...	SR14-562/S	SW6-SD	M-1000	BLDT10/S7

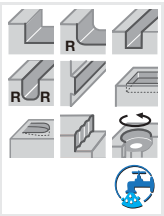
*Recommended clamping torque (N·m):SR14-562/S=2.5

HPA10-M

High precision square shoulder endmill, modular type, for triangular inserts (TungFlex)

GAMP = +9.5°~ +11°, GAMF = -4.5°~ -0.5°





Designation	APMX	DC	CICT	OAL	LF	H	DCSFMS	CRKS	WT(kg)	Air hole	Insert
HPA10R025MM12-02	10	25	2	57	35	17	21	M12	0.08	with	TO*T10...
HPA10R032MM16-03	10	32	3	63	40	22	29	M16	0.18	with	TO*T10...

• Please see the page 17 for TungFlex modular shank.

SPARE PARTS



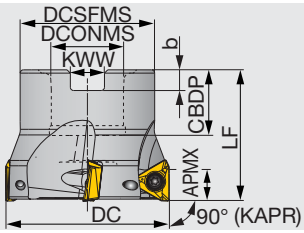

Designation	Clamping screw	Grip	Lubricant	Torx bit
HPA10...	SR14-562/S	SW6-SD	M-1000	BLDT10/S7

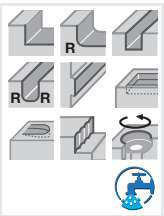
*Recommended clamping torque (N·m):SR14-562/S=2.5

TPA15

High precision square shoulder mill, with screw clamp system, for triangular inserts

GAMP = +12°~ +13.5°, GAMF = -6°~ -3.5°





Designation	APMX	DC	CICT	DCSFMS	DCONMS	CBDP	LF	b	KWW	WT(kg)	Air hole	Insert
TPA15R050M22.0E04	15	50	4	41	22	20	40	6.3	10.4	0.27	with	TOMT15...
TPA15R063M22.0E05	15	63	5	41	22	20	40	6.3	10.4	0.41	with	TOMT15...
TPA15R080M25.4-06	15	80	6	46	25.4	26	50	6	9.5	0.83	with	TOMT15...
TPA15R080M27.0E06	15	80	6	50	27	22	50	7	12.4	0.86	with	TOMT15...
TPA15R100M31.7-07	15	100	7	60	31.75	32	50	8	12.7	1.3	with	TOMT15...
TPA15R100M32.0E07	15	100	7	60	32	28.5	50	8	14.4	1.27	with	TOMT15...
TPA15R125M38.1-08	15	125	8	80	38.1	38	63	10	15.9	2.7	with	TOMT15...
TPA15R125M40.0E08	15	125	8	71	40	32	63	9	16.4	2.47	with	TOMT15...
TPA15R160M40.0E10N	15	160	10	100	40	32	63	9	16.4	4.77	without	TOMT15...
TPA15R160M50.8-10N	15	160	10	100	50.8	46	63	11	19	4.4	without	TOMT15...

SPARE PARTS





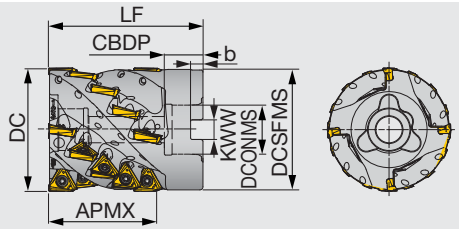

Designation	Clamping screw	Grip	Lubricant	Center bolt	Center bolt 1	Torx bit
TPA15R050M22.0E04	TS45120I	H-TB2W	M-1000	-	FSHM10-40H	BT20S
TPA15R063M22.0E05	TS45120I	H-TB2W	M-1000	-	CM10X30H	BT20S
TPA15R080M...	TS45120I	H-TB2W	M-1000	-	CM12X30H	BT20S
TPA15R100M...	TS45120I	H-TB2W	M-1000	TMBA-M16H	-	BT20S
TPA15R125M...	TS45120I	H-TB2W	M-1000	TMBA-M20H	-	BT20M
TPA15R160M...	TS45120I	H-TB2W	M-1000	-	-	BT20M

*Recommended clamping torque (N·m):TS45120I=5

TLA15-M

Square shoulder mill for roughing, with screw clamp system, for triangular inserts

GAMP = +12°~ +13.5°, GAMF = -6°~ -3.5°



Designation	APMX	DC	ZEFP	CICT	DCSFMS	DCONMS	CBDP	LF	b	KWW	WT(kg)	Air hole	Insert
TLA15R080L070M31.7-04M	70	80	4	20	78	31.75	32	100	8	12.7	2.29	with	TOMT15...
TLA15R080L070M32.0E04M	70	80	4	20	78	32	25	100	8	14.4	2.38	with	TOMT15...
TLA15R100L083M38.1-05M	83	100	5	30	98	38.1	38	110	10	15.9	4.24	with	TOMT15...
TLA15R100L083M40.0E05M	83	100	5	30	98	40	32	110	9	16.4	4.26	with	TOMT15...

Note: Coolant needs to be supplied from the end of the arbor inlay. Coolant cannot be supplied from the set bolt.

SPARE PARTS





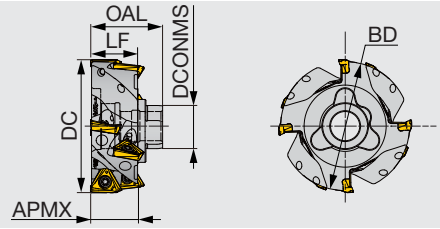
Designation	Clamping screw	Grip	Torx bit	Lubricant	Center bolt
TLA15R080...	TS45120I	H-TB2W	BT20S	M-1000	CM16X75
TLA15R100...	TS45120I	H-TB2W	BT20S	M-1000	CM20X80

*Recommended clamping torque (N·m):TS45120I=5

TLA15-S

Subunit for TLA15-M, square shoulder mill for roughing, with screw clamp system, for triangular inserts

GAMP = +12°~ +13.5°, GAMF = -6°~ -3.5°



Designation	APMX	DC	ZEFP	CICT	BD	DCONMS	OAL	LF	WT(kg)	Air hole	Insert
TLA15R080L028-04S	28	80	4	8	77.6	27	43	28.2	0.65	with	TOMT15...
TLA15R100L028-05S	28	100	5	10	97.2	33	46	28	1.05	with	TOMT15...

Note: Coolant needs to be supplied from the end of the arbor inlay. Coolant cannot be supplied from the set bolt.

SPARE PARTS




Designation	Clamping screw	Grip	Lubricant	Torx bit
TLA15...	TS45120I	H-TB2W	M-1000	BT20S

*Recommended clamping torque (N·m):TS45120I=5

CENTER BOLT

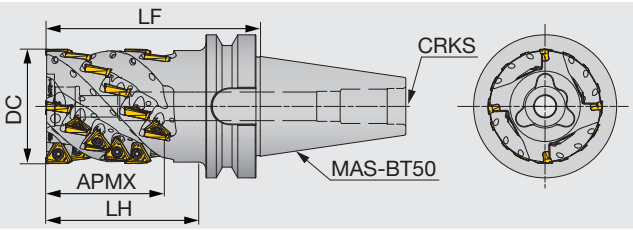
(Optional parts)


No. of subunits	1	2
TLA15R080L028-04S	CM16x120	CM16x140
TLA15R100L028-05S	CM20x120	CM20x150

TLA15-BT

Square shoulder mill for roughing, with BT tapered shank, for triangular inserts

GAMP = +12°~ +13.5°, GAMF = -6°~ -3.5°



Designation	APMX	DC	ZEFP	CICT	LF	LH	WT(kg)	Air hole	CRKS	Insert
TLA15R080L083BT50-04M	83	80	4	24	150	107	6.29	with	M24	TOMT15...
TLA15R100L097BT50-05M	97	100	5	35	165	126.5	8.92	with	M24	TOMT15...

SPARE PARTS

Designation	Clamping screw	Grip	Lubricant	Torx bit	Shell locking bolt
TLA15R080L083BT50-04M	TS45120I	H-TB2W	M-1000	BT20S	CAP-CM16×2.0×55
TLA15R100L097BT50-05M	TS45120I	H-TB2W	M-1000	BT20S	CAP-CM20×2.5×50

*Recommended clamping torque (N·m):TS45120I=5

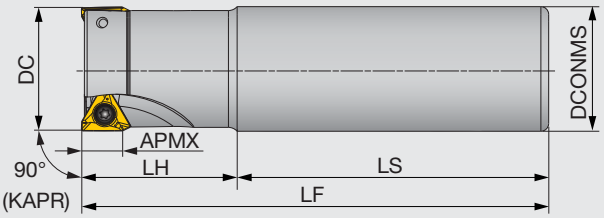
CENTER BOLT
(Optional parts)

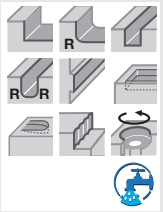
No. of subunits	1	2
TLA15R080L083BT50-04M	CAP-CM16×2.0×55	CM16x120
TLA15R100L097BT50-05M	CAP-CM20×2.5×50	CM20x80

EPA15

High precision square shoulder endmill, shank type, with screw clamp system, for triangular inserts

GAMP = +12°~ +13.5°, GAMF = -6°~ -3.5°





Designation	APMX	DC	CICT	DCONMS	LS	LH	LF	WT(kg)	Air hole	Insert
EPA15R040M32.0-03N	15	40	3	32	80	40	120	0.73	without	TOMT15...
EPA15R040M32.0-02L	15	40	2	32	205	50	255	1.56	with	TOMT15...
EPA15R050M32.0-04N	15	50	4	32	80	40	120	0.83	without	TOMT15...
EPA15R050M42.0-02L	15	50	2	42	310	50	360	3.84	with	TOMT15...

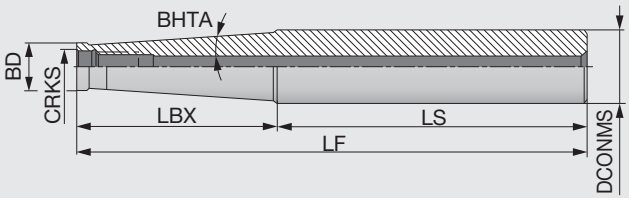
SPARE PARTS

Designation	Clamping screw	Grip	Lubricant	Torx bit
EPA15...	TS45120I	H-TB2W	M-1000	BT20S

*Recommended clamping torque (N·m):TS45120I=5

TungFlex

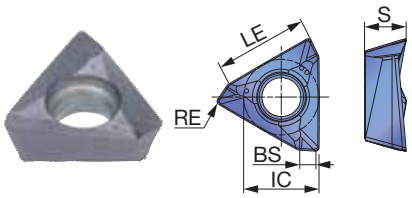
TungFlex modular shank



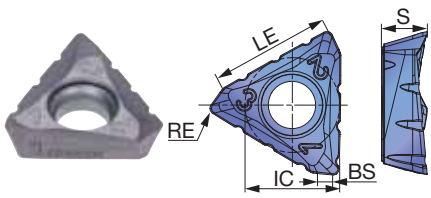
Designation	DCONMS	LF	LS	LBX	BD	CRKS	BHTA	Shank type
SM06-L60C10	10	60	40	20	9.7	M6	0°	Cylindrical
SM06-L105-C12	12	105	45	60	9.7	M6	1.2°	Cylindrical
SM06-L125-C16	16	125	65	60	9.7	M6	3.3°	Cylindrical
SM08-L73C16	16	73	48	25	13	M8	0°	Cylindrical
SM08-L128-C16	16	128	48	80	13	M8	0.9°	Cylindrical
SM08-L170-C20	20	170	103.2	66.8	13	M8	3.3°	Cylindrical
SM10-L80-C20	20	80	50	30	18	M10	0°	Cylindrical
SM10-L130-C20	20	130	50	80	18	M10	0.6°	Cylindrical
SM10-L200-C25	25	200	142.8	57.2	19	M10	3.3°	Cylindrical
SM12-L86-C25	25	86	56	30	21	M12	5.1°	Cylindrical
SM12-L200-C32	32	200	122	78	21	M12	4.4°	Cylindrical
SM16-L95-C32	32	95	60	35	29	M16	1.7°	Cylindrical
SM16-L230-C32	32	230	180	50	29	M16	1.8°	Cylindrical

INSERTS

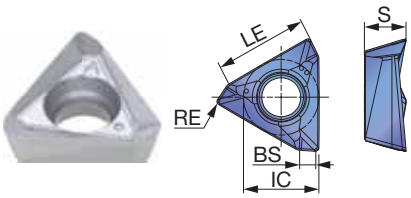
TOMT-MJ



TOMT-NMJ



TOGT-AJ



P	Steel	☆	★		☆		
M	Stainless		★		☆		
K	Cast iron	★		★			
N	Non-ferrous					★	
S	Superalloys	★	☆				
H	Hard materials						

★ : First choice
☆ : Second choice

Designation	RE	APMX	Coated				Un-coated	LE	IC	S	BS
			AH120	AH3135	T1215	T3225	KS05F				
TOMT060302PDER-MJ	0.2	6	●	●				6.2	5.6	3.2	1.4
TOMT060304PDER-MJ	0.4	6	●	●		●		6.2	5.6	3.2	1.2
TOMT060308PDER-MJ	0.8	6	●	●	●	●		6.2	5.6	3.2	0.8
TOMT100404PDER-MJ	0.4	10	●	●		●		10.5	8.6	4.7	1.5
TOMT100408PDER-MJ	0.8	10	●	●	●	●		10.5	8.6	4.7	1.1
TOMT100416PDER-MJ	1.6	10	●	●				10.5	8.6	4.7	0.2
TOMT150604PDER-MJ	0.4	15	●	●		●		15.7	12.7	6	2.2
TOMT150608PDER-MJ	0.8	15	●	●	●	●		15.7	12.7	6	1.9
TOMT150616PDER-MJ	1.6	15	●	●				15.7	12.7	6	1.1
TOMT150620PDER-MJ	2	15	●	●				15.7	12.7	6	0.7
TOMT150608PDER-NMJ	0.8	15	●	●		●		15.7	12.7	6	1.9
TOGT100404PDFR-AJ	0.4	10					●	10.5	8.6	5.2	1.5
TOGT100408PDFR-AJ	0.8	10					●	10.5	8.6	5.1	1.1

●: Line up

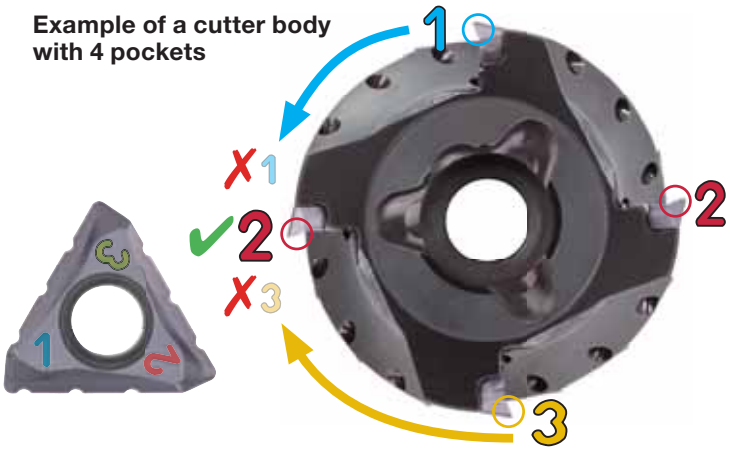
Caution for using NMJ chipbreaker

⚠ Insert with NMJ chipbreaker has a number marked on each corner.
DO NOT place the corners with the same number in adjacent flute as the cutter may be damaged.

For example, if you place the corner #1 in one flute, be sure to use #2 or #3 (and avoid #1) in the next one.

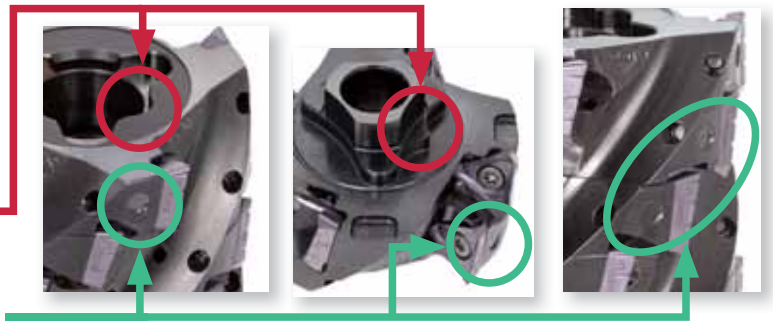
Item: TOMT150608PDER-NMJ

Example of a cutter body with 4 pockets



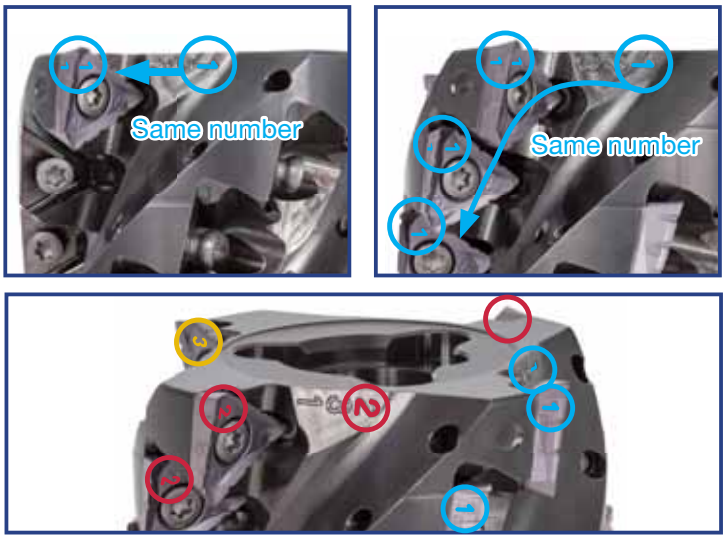
How to set a sub-unit

When setting a sub-unit on the main unit or another sub-unit, be sure to match the markings on the units. Sub-unit has a projection for error-proofing (Poka-yoke) to avoid setting error.



Directions for setting NMJ inserts on roughing type bodies

1. Attach the insert on the cutter body so that the number on the working cutting edge matches the first number marked on the cutter body.
(See the image on the right.)
2. Attach the remaining inserts on the same flute with the same number marked on the working cutting edge.
3. Repeat steps 1 and 2 for the other flutes.
4. Make sure the number on the working cutting edge is different from the number used on the adjacent flutes.

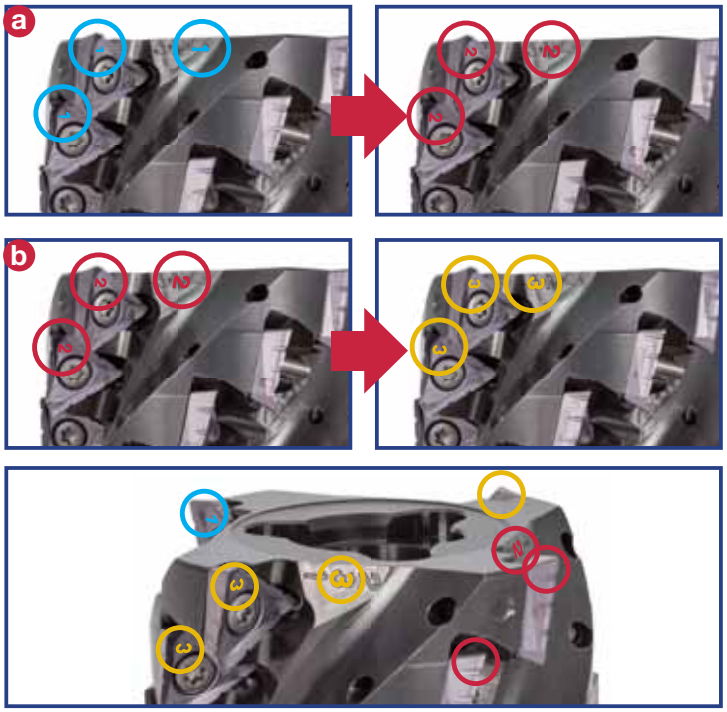


Directions for changing corners for inserts on roughing type bodies

1. a First time to change the corner rotate the insert clock-wise to match the number on the working cutting edge with the second number marked on the cutter body.
(See the image on the right.)
Ex: 1 ➡ 2
2 ➡ 3
3 ➡ 1

   b Second time to change the corner rotate the insert clock-wise to match the number on the working cutting edge with the last number marked on the cutter body.
(See the image on the right.)
Ex: 2 ➡ 3
3 ➡ 1
1 ➡ 2

2. Repeat step 1 for all inserts.
3. Make sure the number on the working cutting edge is different from the number used on the adjacent flutes.



TUNG-TRI
TUNGALOY

STANDARD CUTTING CONDITIONS

TPA/EPA/HPA

ISO	Workpiece materials	Hardness HB	Grades	Cutting speed *Vc* (m/min)			Feed per tooth: *fz* (mm/t)				
							MJ			NMJ	AJ
				T/E/HPA06	T/E/HPA10	T/EPA15	T/E/HPA06	T/E/HPA10	T/EPA15	T/EPA15	T/E/HPA10
P	Low carbon steel (SS400 / E275A, S15C / C15E4, etc.)	- 200	AH3135	100 - 220	100 - 250	100 - 250	0.05 - 0.15	0.08 - 0.2	0.08 - 0.25	0.08 - 0.15	-
	High carbon steel (S45C / C45, etc.)	200 - 300	AH3135	100 - 170	100 - 200	100 - 230	0.05 - 0.12	0.08 - 0.15	0.08 - 0.2	0.08 - 0.15	-
	Alloy steel (SCM440, etc. / 42CrMo4, etc.)	150 - 300	AH3135	100 - 170	100 - 200	100 - 230	0.05 - 0.12	0.08 - 0.15	0.08 - 0.2	0.08 - 0.15	-
	Tool steel (SKD61 / X40CrMoV5-1, etc.)	30 - 40 HRC	AH3135	100 - 120	100 -150	100 - 180	0.05 - 0.12	0.08 - 0.15	0.08 - 0.2	0.08 - 0.15	-
M	Stainless steel (SUS304 / X5CrNi18-9, etc.)	-	AH3135	80 - 150	80 - 200	90 - 200	0.05 - 0.15	0.08 - 0.2	0.08 - 0.2	0.08 - 0.15	-
K	Grey cast iron (FC250 / GG25 / 250, etc.)	150 - 250	AH120	100 - 200	100 - 250	140 - 250	0.05 - 0.15	0.08 - 0.2	0.08 - 0.25	0.08 - 0.15	-
			T1215	150 - 250	150 - 300	200 - 300	0.05 - 0.12	0.08 - 0.15	0.08 - 0.18	-	-
	Ductile cast iron (FCD450 / GGG45 / 450-10S, etc.)	150 - 250	AH120	80 - 150	80 - 200	110 - 200	0.05 - 0.15	0.08 - 0.2	0.08 - 0.25	0.08 - 0.15	-
			T1215	100 - 200	130 - 250	150 - 250	0.05 - 0.12	0.08 - 0.15	0.08 - 0.18	-	-
N	Aluminium (Si < 13%)	-	KS05F	-	300 - 1000	-	-	-	-	-	0.08 - 0.22
	Aluminium (Si ≥ 13%)	-	KS05F	-	100 - 200	-	-	-	-	-	0.08 - 0.22
S	Titanium alloys (Ti-6Al-4V, etc.)	-	AH120	20 - 50	20 - 60	20 - 60	0.05 - 0.1	0.08 - 0.15	0.08 - 0.18	0.08 - 0.15	-
	Heat-resistant alloys (Inconel 718, etc.)	-	AH120	20 - 35	20 - 40	20 - 40	0.03 - 0.08	0.05 - 0.13	0.07 - 0.15	0.07 - 0.15	-

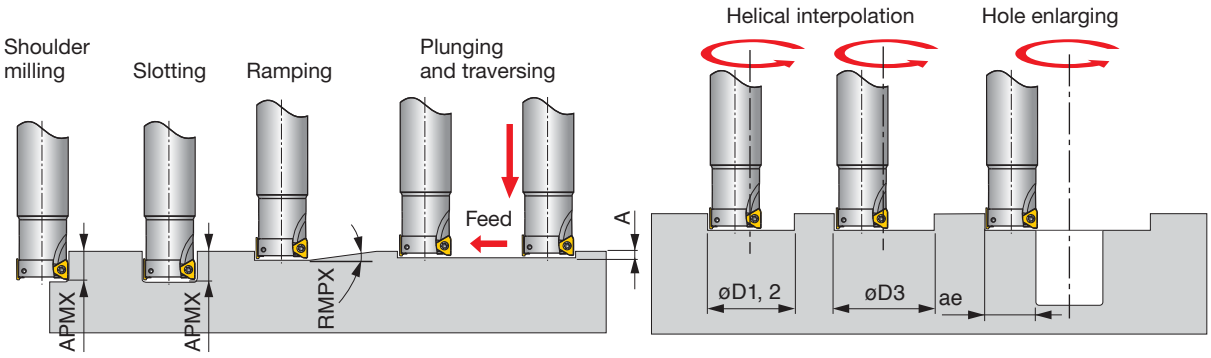
· When you use the NMJ chipbreaker, please set up the feed less than 0.15 mm/t.
· Remove excessive chip accumulation with an air blast.
· For the operation with depth of cut which varies (ex.casting skin) and machining of workpiece materials with interrupted surface, the feed per tooth (*fz*) should be set to the lower recommended value shown in the above table.
· Cutting conditions maybe limited depending on machine power, workpiece rigidity, and spindle output. When the cutting width, depth, or overhang length is large, set *Vc* and *fz* to the lower recommended values and check the machine power and vibration.

TLA (Roughing type)

ISO	Workpiece materials	Hardness HB	Grades	Cutting speed *Vc* (m/min)		Feed per tooth: *fz* (mm/t)			
						MJ		NMJ	AJ
				TLA10	TLA15	TLA10	TLA15	TLA15	TLA10
P	Low carbon steel (SS400 / E275A, S15C / C15E4, etc.)	- 200	AH3135	100 - 250	100 - 250	0.08 - 0.18	0.08 - 0.22	0.08 - 0.15	-
	High carbon steel (S45C / C45, etc.)	200 - 300	AH3135	100 - 200	100 - 270	0.08 - 0.14	0.08 - 0.18	0.08 - 0.15	-
	Alloy steel (SCM440, etc. / 42CrMo4, etc.)	30 - 40 HRC	AH3135	100 - 150	100 - 180	0.08 - 0.14	0.08 - 0.18	0.08 - 0.15	-
M	Stainless steel (SUS304 / X5CrNi18-9, etc.)	-	AH3135	80 - 200	90 - 200	0.08 - 0.15	0.08 - 0.18	0.08 - 0.15	-
K	Grey cast iron (FC250 / GG25 / 250, etc.)	150 - 250	AH120	100 - 250	140 - 250	0.08 - 0.18	0.08 - 0.25	0.08 - 0.15	-
			T1215	150 - 250	150 - 250	0.08 - 0.15	0.08 - 0.18	-	-
	Ductile cast iron (FCD450 / GGG45 / 450-10S, etc.)	150 - 250	AH120	80 - 200	110 - 200	0.08 - 0.18	0.08 - 0.25	0.08 - 0.15	-
			T1215	150 - 250	150 - 250	0.08 - 0.15	0.08 - 0.18	-	-
N	Aluminium (Si < 13%)	-	KS05F	300 - 1000	-	-	-	-	0.08 - 0.22
	Aluminium (Si ≥ 13%)	-	KS05F	100 - 200	-	-	-	-	0.08 - 0.22
S	Titanium alloys (Ti-6Al-4V, etc.)	-	AH120	20 - 60	20 - 60	0.08 - 0.15	0.08 - 0.18	0.08 - 0.15	-
	Heat-resistant alloys (Inconel 718, etc.)	-	AH120	20 - 40	20 - 40	0.05 - 0.13	0.07 - 0.15	0.07 - 0.15	-

· When using NMJ chipbreaker, please set up the feed not to exceed 0.15 mm/t.

APPLICATION RANGE

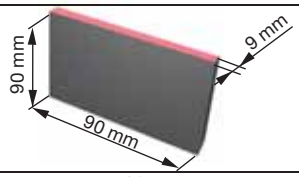


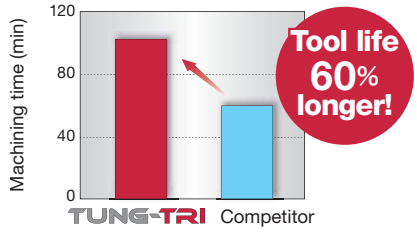
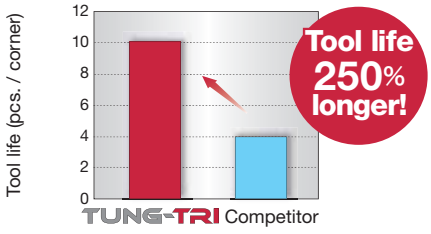
Designation	DC	Max. depth of cut APMX	Max. ramping angle RMPX	Max. plunging depth A	Min. machining depth øD1	Max. machining diameter øD2	Max. machining diameter øD3 *	Max. cutting width in enlarging ae
EPA06R012...	12	6	5°	0.6	18	23.6	21	11.5
E/HPA06R016...	16	6	4.3°	0.6	25	31.6	29	15.5
EPA06R018...	18	6	3.5°	0.6	29.5	35.6	33	17.5
E/HPA06R020...	20	6	2.8°	0.6	33.5	39.6	37	19.5
EPA06R022...	22	6	2.5°	0.6	37.5	43.6	41	21.5
E/HPA06R025...	25	6	2°	0.6	43.5	49.6	47	24.5
E/HPA10R025...	25	10	2°	0.6	42.1	49.6	47	24.5
EPA06R028...	28	6	1.8°	0.6	49.5	55.6	53	27.5
EPA10R028...	28	10	2°	0.6	48.1	55.6	53	27.5
H/TPA06R032...	32	6	1.5°	0.6	57.5	63.6	61	31.5
E/HPA10R032...	32	10	2°	0.6	56.1	63.6	61	31.5
EPA10R035...	35	10	1.7°	0.6	62.1	69.6	67	34.5
TPA06R040...	40	6	1°	0.6	73.5	79.6	77	39.5
E/TPA10R040...	40	10	1.4°	0.6	72.1	79.6	77	39.5
EPA15R040...	40	15	2.3°	0.8	68.5	79.2	75.5	39
TPA06R050...	50	6	0.7°	0.6	94	99.6	97	49.5
TPA10R050...	50	10	0.9°	0.6	92.1	99.6	97	49.5
E/TPA15R050...	50	15	1.7°	0.8	88.5	99.2	95.5	49
TPA10R063...	63	10	0.8°	0.6	118.1	125.6	123	62.5
TPA15R063...	63	15	1.4°	0.8	114.5	125.2	121.5	62
TPA10R080...	80	10	0.6°	0.6	152.1	159.6	157	79.5
TPA15R080...	80	15	1°	0.8	148.5	159.2	155.5	79
TPA10R100...	100	10	0.5°	0.6	192.1	199.6	197	99.5
TPA15R100...	100	15	0.8°	0.8	188.5	199.2	195.5	99
TPA15R125...	125	15	0.6°	0.8	238.5	249.2	245.5	124
TPA15R160...	160	15	0.5°	0.8	308.5	319.2	315.5	159

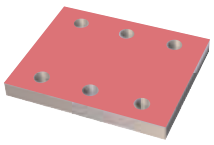
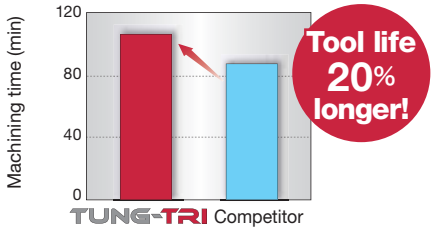
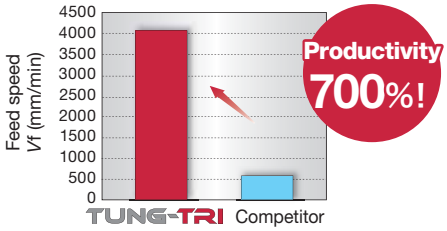
* Flat bottom hole

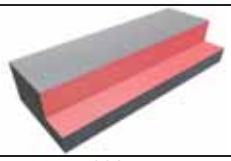
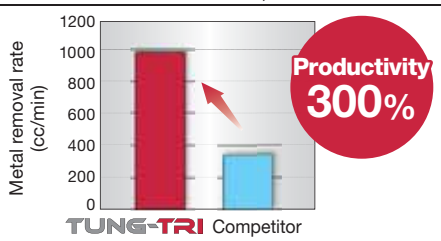
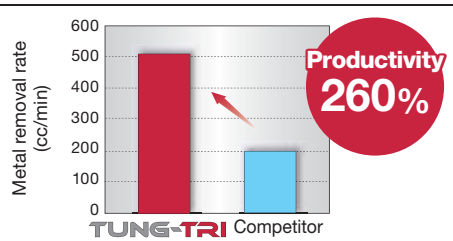
Note: Corner RE for dimensions of øD1, øD2 and øD3: RE = 0.4 for E/TPA06, E/TPA10 and RE = 0.8 for E/TPA15.

PRACTICAL EXAMPLES

	Workpiece type	Plate	Machine part
	Cutter	EPA06R020M20.0-03N (ø20 mm, z = 3)	EPA10R032M32.0-03N (ø32 mm, z = 3)
	Insert	TOMT060304PDER-MJ	TOMT100404PDER-MJ
	Grade	AH3135	AH3135
	Workpiece material	SUS304 / X5CrNi18-9	S45C / C45
		 M	 P
Cutting conditions	Cutting speed: *Vc* (m/min)	125	150
Cutting conditions	Feed per tooth: *fz* (mm/t)	0.083	0.19
Cutting conditions	Feed speed: *Vf* (mm/min)	600	836
Cutting conditions	Depth of cut : *ap* (mm)	1.5	1
Cutting conditions	Width of cut : *ae* (mm)	9	5
Cutting conditions	Machining	Face milling	Shoulder milling
Cutting conditions	Coolant	Dry	Wet (External coolant)
Cutting conditions	Machine	BT40	Turn-Mill center
	Results	 Uniquely designed cutting edge geometry delivers low cutting force and prevents chattering, resulting in highly efficient machining of steel sheet.	Conditions / Burr / Wall surface finish: TUNG-TRI — Small — Better; Competitor — Big — Worse. Due to low cutting force, Tung-Tri leaves a smaller burr and better wall surface finish compared to the competitor.

	Workpiece type	Base	Block
	Cutter	EPA10R032M32.0-03N (ø32 mm, z = 3)	TPA10R063M22.0E06 (ø63 mm, z = 6)
	Insert	TOMT100404PDER-MJ	TOMT100408PDER-MJ
	Grade	AH3135	T1215
	Workpiece material	S50C / C50	FCD700
		 P	 K
Cutting conditions	Cutting speed: *Vc* (m/min)	130	196
Cutting conditions	Feed per tooth: *fz* (mm/t)	0.1	0.15
Cutting conditions	Feed speed: *Vf* (mm/min)	390	900
Cutting conditions	Depth of cut : *ap* (mm)	1.5	2.5
Cutting conditions	Width of cut : *ae* (mm)	25	54.5
Cutting conditions	Machining	Shoulder milling	Face milling
Cutting conditions	Coolant	External air	Dry
Cutting conditions	Machine	Vertical M/C	BT40
	Results	 Due to strong wear resistance of AH3135 grade, tool life is increased by 60%.	 T1215 exhibited a superior wear resistance, extending the tool life well over to 250%.

	Workpiece type	Blank	General machine part
	Cutter	EPA10R040M32.0-04N (ø40 mm, z = 4)	EPA10R025M25.0-02N (ø25 mm, z = 2)
	Insert	TOMT100408PDER-MJ	TOGT100408PDFR-AJ
	Grade	AH3135	KS05F
	Workpiece material	Titanium  S	AC4B  N
Cutting conditions	Cutting speed: *Vc* (m/min)	55	457
Cutting conditions	Feed per tooth: *fz* (mm/t)	0.1	0.3
Cutting conditions	Feed speed: *Vf* (mm/min)	175	4072
Cutting conditions	Depth of cut : *ap* (mm)	2.5	1.27
Cutting conditions	Width of cut : *ae* (mm)	25	-
Cutting conditions	Machining	Face milling	Face milling
Cutting conditions	Coolant	Wet (External coolant)	Wet (External coolant)
Cutting conditions	Machine	Vertical M/C, BT50	Vertical M/C, BT40
	Results	 Sharp cutting edges prevent welding, which extends tool life.	 The AJ chipbreaker exhibited its high fracture resistance even in a demanding cutting condition.

	Workpiece type	Molding machine part	Generator
	Cutter	TLA15R080L070M31.7-04M (ø80 mm) TLA15R080L028-04S	TLA15R100L083M38.1-05M (ø100 mm, z = 5)
	Insert	TOMT150608PDER-MJ	TOMT150608PDER-NMJ
	Grade	AH120	AH3135
	Workpiece material	FCD400 / 400-15S  K	S45C / C45  P
Cutting conditions	Cutting speed: *Vc* (m/min)	180	160
Cutting conditions	Feed per tooth: *fz* (mm/t)	0.2	0.16
Cutting conditions	Feed speed: *Vf* (mm/min)	573.0	407
Cutting conditions	Depth of cut : *ap* (mm)	74	50
Cutting conditions	Width of cut : *ae* (mm)	24	25
Cutting conditions	Machining	Contouring	Shoulder milling (Roughing)
Cutting conditions	Coolant	Dry	Wet (External coolant)
Cutting conditions	Machine	Vertical M/C, BT50	Vertical M/C, BT50
	Results	 NMJ insert reduces cutting force, and dramatically improves efficiency.	 The serrated cutting edges of the NMJ chip-breaker significantly reduced vibration, while outputting a high MMR.

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