

TETRAMCUT

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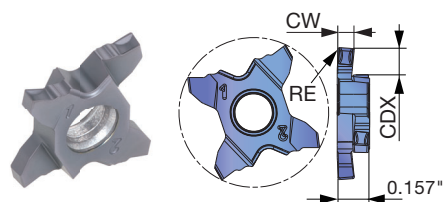
Tungaloy Report No. 416S1-US

Expanded groove width options for **TCL18 and TCG18 inserts**



INDUSTRY 4.0
FEED the SPEED!

TCL18R (3D chipbreaker)



Right-hand (R) shown.

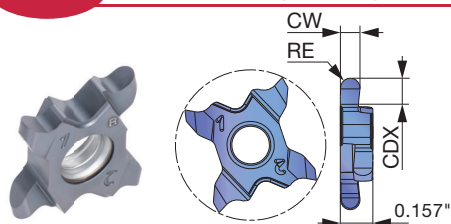
P	Steel	★			
M	Stainless	★			
K	Cast iron	★			
N	Non-ferrous				
S	Superalloys	★			
H	Hard materials				

★ : First choice
☆ : Second choice

Designation		HAND	CW±0.02 (mm)	CW±0.001 (in)	RE (in)	Coated		CDX (in)
						AH7025		
New	TCL18R175-020	R	1.75	0.069	0.008	●		0.138
New	TCL18R250-030	R	2.5	0.098	0.012	●		0.138

5 pieces per package
● : New product

New TCG18R/L (Full R)



Right-hand (R) shown.

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

★ : First choice
☆ : Second choice

Designation	HAND	CW±0.02 (mm)	CW±0.001 (in)	RE (in)	Coated		CDX (in)
					AH7025		
TCG18R100-050	R	1	0.039	0.020	★		0.079
TCG18L100-050	L	1	0.039	0.020	★		0.079
TCG18R158-079	R	1.58	0.062	0.031	★		0.138
TCG18L158-079	L	1.58	0.062	0.031	★		0.138
TCG18R200-100	R	2	0.079	0.039	★		0.138
TCG18L200-100	L	2	0.079	0.039	★		0.138
TCG18R239-120	R	2.39	0.094	0.047	★		0.138
TCG18L239-120	L	2.39	0.094	0.047	★		0.138
TCG18R300-150	R	3	0.118	0.059	★		0.138
TCG18L300-150	L	3	0.118	0.059	★		0.138
TCG18R318-159	R	3.18	0.125	0.063	★		0.138
TCG18L318-159	L	3.18	0.125	0.063	★		0.138

5 pieces per package
★ : To be released in 2020

STANDARD CUTTING CONDITIONS

TCL18R (3D chipbreaker), TCG18R/L (Full R)

ISO	Workpiece materials	Grades	Cutting speed Vc (sfm)	Feed: <i>f</i> (ipr)	
				TCL18	TCG18
P	Low carbon steel 1020, etc.	AH7025	262 - 591	0.001 - 0.005	0.002 - 0.006
	Carbon steels, Alloy steel 1055, 4140, etc.	AH7025	262 - 591	0.001 - 0.005	0.002 - 0.006
	Prehardened steel NAK80, PX5, etc.	AH7025	262 - 591	0.001 - 0.005	0.002 - 0.006
M	Stainless steel 304SS, etc.	AH7025	164 - 394	0.001 - 0.005	0.002 - 0.006
K	Gray cast iron Class 25, Class 30, etc.	AH7025	164 - 591	0.001 - 0.005	0.002 - 0.006
	Ductile cast iron 60-40-18, 80-55-06, etc.	AH7025	164 - 591	0.001 - 0.005	0.002 - 0.006
S	Titanium alloys Ti-6Al-4V, etc.	AH7025	98 - 262	0.001 - 0.005	0.002 - 0.006
	Superalloys Inconel718, etc.	AH7025	66 - 197	0.001 - 0.005	0.002 - 0.006

Standard lineup of TetraMini-Cut grooving inserts

Groove width CW (in)	Groove width CW (mm)	Corner rad. RE (in)	Corner rad. RE (mm)	TCL18R	TCS18R	TCG18R/L	TCP18R/L	TCP18R/L-F
				AH7025	AH7025	AH7025	AH725	SH725
0.013	0.33	0.002	0.05				●	●
0.017	0.43	0.002	0.05				●	●
0.020	0.50	0.002	0.05				●	●
0.030	0.75	0.002	0.05				●	●
0.037	0.95	0.002	0.05				●	●
0.039	1.00	0.002	0.05					●
		0.004	0.1		●	●	●	●
		0.020	0.5			★		
0.047	1.20	0.002	0.05					●
		0.004	0.1		●	●	●	●
0.049	1.25	0.002	0.05					●
		0.004	0.1		●	●	●	●
		0.008	0.2		●	●		
0.051	1.30	0.008	0.2		●	●		
0.055	1.40	0.004	0.1		●	●	●	●
		0.008	0.2		●	●		
0.057	1.45	0.002	0.05					●
		0.004	0.1		●	●	●	●
		0.008	0.2			●		
0.059	1.50	0.002	0.05					●
		0.004	0.1	●	●	●	●	●
		0.008	0.2	●	●	●		
0.062	1.58	0.031	0.79			★		
0.063	1.60	0.008	0.2		●	●		
0.067	1.70	0.008	0.2		●	●		
0.069	1.75	0.002	0.05					●
		0.004	0.1		●	●	●	●
		0.008	0.2	●	●	●		
0.073	1.85	0.008	0.2		●	●		
0.077	1.95	0.008	0.2		●	●		
0.079	2.00	0.002	0.05					●
		0.004	0.1	●	●	●	●	●
		0.008	0.2	●	●	●		
		0.039	1.0			★		
0.089	2.25	0.008	0.2		●	●		
0.091	2.30	0.008	0.2		●	●		
0.094	2.39	0.047	1.2			★		
0.098	2.50	0.004	0.1		●	●	●	●
		0.008	0.2		●	●		
		0.012	0.3	●	●	●		
0.104	2.65	0.012	0.3		●	●		
0.110	2.80	0.012	0.3		●	●		
0.118	3.00	0.004	0.1	●	●	●	●	●
		0.008	0.2	●	●	●		
		0.012	0.3	●	●	●		
		0.059	1.5			★		
0.125	3.18	0.063	1.59			★		

● : New product ★ : To be released in 2020 ● : Line up

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