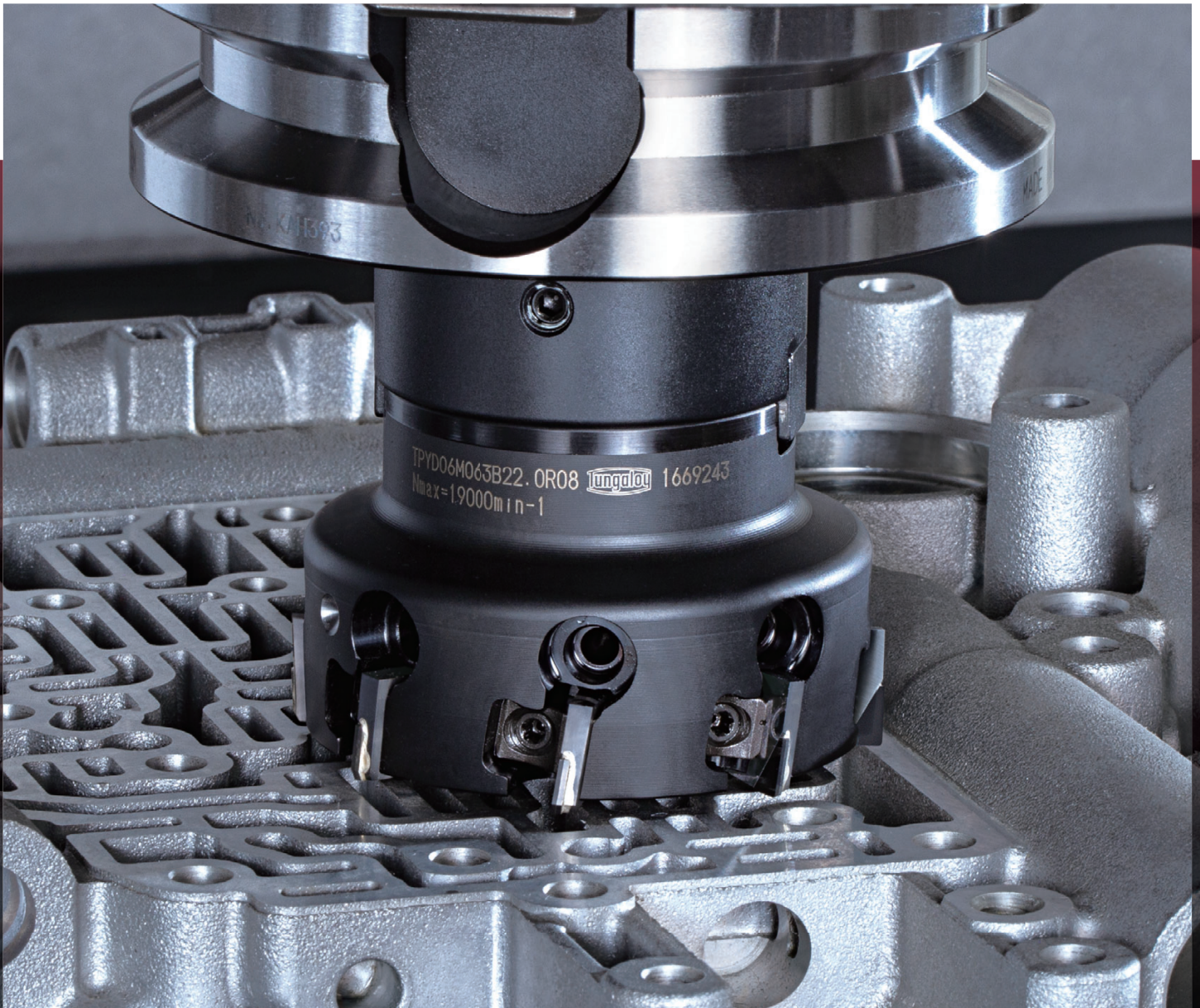


TUNG^{PEED}MILL

Tungaloy Report No. 524S1-US

Expansion of close-pitch cutters and PCD inserts for complete application coverage





New close pitch design is added to extra close pitch cutter line

■ Ideal for face milling wide cutting widths

Fewer number of cutting edges are in the cut, reducing chatter for improved surface finish.

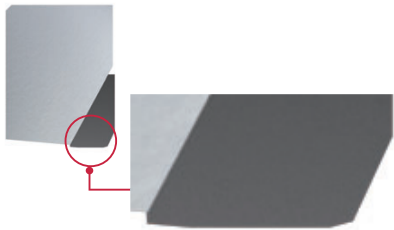
DC (in)	Number of inserts on the cutter	
	New Close pitch	Extra close pitch
2.000	6	8
2.500	8	10
3.000	10	16
4.000	12	22
5.000	14	26
6.000	20	34



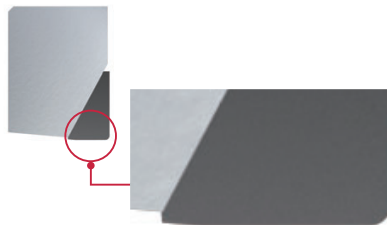
New insert geometries

■ Nose radius (with R0.4 or R0.8)

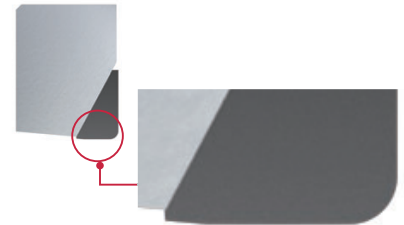
Ideal for applications where corner radius on the workpiece is specified. Rounded nose corner can also protect the edge from fracture during challenging interrupted cutting.



Double-angle design (YDEN0603PDFR-D)



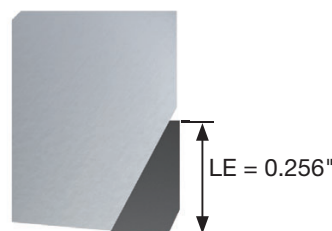
R0.4 (YDEN0603**04**PDFR-D)



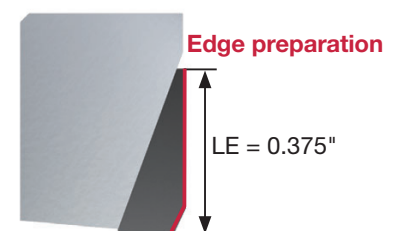
R0.8 (YDEN0603**08**PDFR-D)

■ Long edged insert

Featuring 0.375" in length, the cutting edge can effectively remove gates and risers left on the workpiece without damaging the carbide insert base. The peripheral cutting edge is prepared with chamfer to protect the edge from fracture and also to eliminate burr generation.



Standard geometry
(YDEN0603PDFR-D)

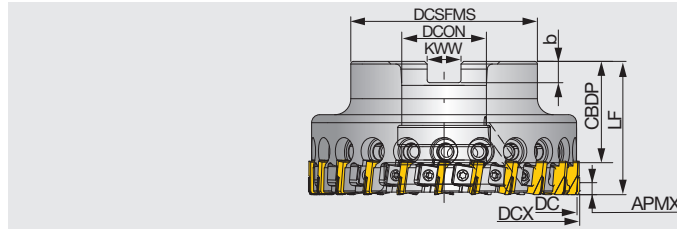


Long edge version
(YDEN0603PDCR-**LD**)

TPYD06

Face milling cutter for non-ferrous applications, bore type, with PCD inserts

GAMP = +9°, GAMF = +4°



Inch	APMX	DC	DCX	CICT	DCSFMS	LF	DCON	CBDP	KWW	b	WT(lb)	Air hole	RPMX(min ⁻¹)	Insert
TPYD06U2.50B0.75R10	0.177	2.500	2.579	10	1.772	1.575	0.750	0.750	0.315	0.197	1.340	With	19,000	YDEN0603...
TPYD06U3.00B1.00R16	0.177	3.000	3.079	16	2.362	1.969	1.000	1.024	0.374	0.236	2.560	With	17,000	YDEN0603...
TPYD06U4.00B1.25R22	0.177	4.000	4.079	22	2.756	1.969	1.250	0.827	0.500	0.315	4.300	With	15,000	YDEN0603...
TPYD06U5.00B1.50R26	0.177	5.000	5.079	26	3.543	2.362	1.500	1.299	0.626	0.394	8.030	With	14,000	YDEN0603...
TPYD06U6.00B1.50R34	0.177	6.000	6.079	34	3.543	2.362	1.500	1.299	0.626	0.394	10.760	With	12,000	YDEN0603...

	Metric	APMX	DC	DCX	CICT	DCSFMS	LF	DCON	CBDP	KWW	b	WT(kg)	Air hole	RPMX(min ⁻¹)	Insert
New	TPYD06M063B22.0R08	4.5	63	65	8	45	40	22	20	10.4	6.3	0.59	With	19,000	YDEN0603...
	TPYD06M063B22.0R10	4.5	63	65	10	45	40	22	20	10.4	6.3	0.57	With	19,000	YDEN0603...
New	TPYD06M080B27.0R10	4.5	80	82	10	60	50	27	22	12.4	7	1.3	With	17,000	YDEN0603...
	TPYD06M080B27.0R16	4.5	80	82	16	60	50	27	22	12.4	7	1.24	With	17,000	YDEN0603...
New	TPYD06J080B25.4R10	4.5	80	82	10	60	50	25.4	26	9.5	6	1.31	With	17,000	YDEN0603...
	TPYD06J080B25.4R16	4.5	80	82	16	60	50	25.4	26	9.5	6	1.26	With	17,000	YDEN0603...
New	TPYD06M100B32.0R12	4.5	100	102	12	70	50	32	25	14.4	8	1.85	With	15,000	YDEN0603...
	TPYD06M100B32.0R22	4.5	100	102	22	70	50	32	25	14.4	8	1.78	With	15,000	YDEN0603...
New	TPYD06J100B31.7R12	4.5	100	102	12	70	50	31.75	32	12.7	8	1.84	With	15,000	YDEN0603...
	TPYD06J100B31.7R22	4.5	100	102	22	70	50	31.75	32	12.7	8	1.76	With	15,000	YDEN0603...
New	TPYD06M125B40.0R14	4.5	125	127	14	90	60	40	32	16.4	9	3.59	With	14,000	YDEN0603...
	TPYD06M125B40.0R26	4.5	125	127	26	90	60	40	32	16.4	9	3.48	With	14,000	YDEN0603...
New	TPYD06J125B38.1R14	4.5	125	127	14	90	60	38.1	38	15.9	10	3.61	With	14,000	YDEN0603...
	TPYD06J125B38.1R26	4.5	125	127	26	90	60	38.1	38	15.9	10	3.56	With	14,000	YDEN0603...
New	TPYD06M160B40.0R20	4.5	160	162	20	90	60	40	32	16.4	9	5.34	With	12,000	YDEN0603...
	TPYD06M160B40.0R34	4.5	160	162	34	90	60	40	32	16.4	9	5.2	With	12,000	YDEN0603...
New	TPYD06J160B38.1R20	4.5	160	162	20	90	60	38.1	38	15.9	10	5.43	With	12,000	YDEN0603...
	TPYD06J160B38.1R34	4.5	160	162	34	90	60	38.1	38	15.9	10	5.29	With	12,000	YDEN0603...

SPARE PARTS

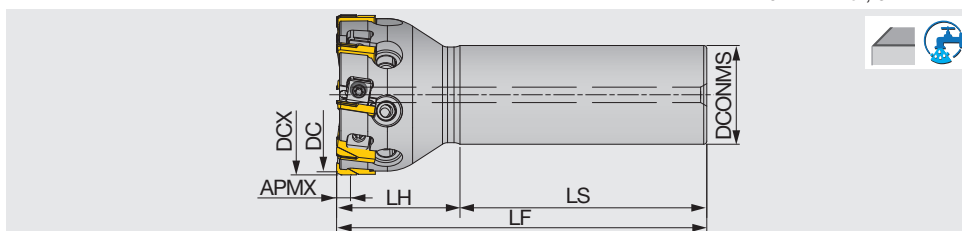


Designation	Insert locking wedge	Wedge fixing screw	Adjusting cam	Torx bit	Cam tightening screw	Wrench	Grip	Shell locking bolt	Shell locking bolt (Optional parts)
TPYD06U2.50B0.75R10	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	-	(C0.375X1.125H)
TPYD06U3.00B1.00R16	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	-	(C0.500X1.375H)
TPYD06U4.00B1.25R22	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	-	-
TPYD06U5.00..., 6.00...	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	-	(TMBA-0.750H)
TPYD06M063B22.0R10	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	CM10X30H	-
TPYD06*080B2*.R16	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	CM12X30H	-
TPYD06*100B32.0R22	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	CM16X40H	-
TPYD06*100B31.7R22	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	TMBA-M16H	-
TPYD06*125B*.R26	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	TMBA-M20H	-
TPYD06*160B*.R34	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	TMBA-M20H	-

EPYD06

Face milling cutter for non-ferrous applications, shank type, with PCD inserts

GAMP = +9°, GAMF = +4°



Inch	APMX	DC	DCX	CICT	DCONMS	LF	LH	LS	WT(lb)	Air hole	RPMX(min ⁻¹)	Insert
EPYD06U2.00C1.25R08	0.177	2.000	2.079	8	1.250	4.500	1.575	2.925	1.920	With	22,000	YDEN0603...

Metric	APMX	DC	DCX	CICT	DCONMS	LF	LH	LS	WT(kg)	Air hole	RPMX(min ⁻¹)	Insert
EPYD06M050C32.0R06	4.5	50	52	6	32	120	40	80	0.91	With	20,000	YDEN0603...
EPYD06M050C32.0R08	4.5	50	52	8	32	120	40	80	0.9	With	20,000	YDEN0603...

New

SPARE PARTS

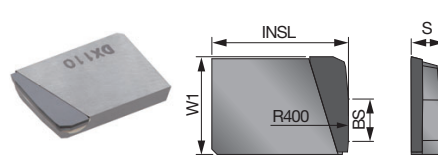
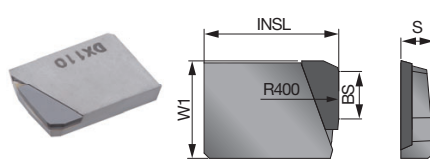
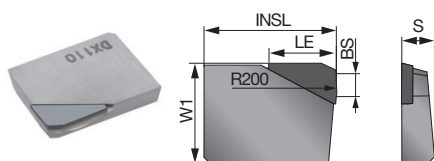
Designation	Insert locking wedge	Wedge fixing screw	Adjusting cam	Torx bit	Cam tightening screw	Wrench	Grip
EPYD06...	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W

 INSERT

YDEN0603PD(F/S)R-D

YDEN0603PDFR-WD

YDEN0603PDFR-BD

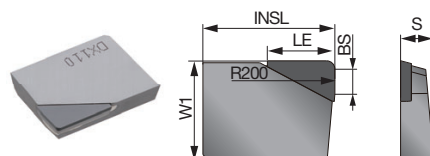
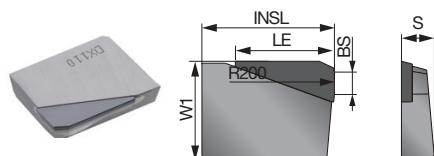


New

YDEN0603PDCR-LD

New

YDEN0603(04/08)PDFR-D



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

★ : First choice

Designation	APMX	Edge prep.	PCD											W1	INSL	S	BS	LE	
			DX110																
YDEN0603PDFR-D	0.177	Without	●												0.375	0.500	0.122	0.087	0.256
YDEN0603PDSR-D	0.177	With	●												0.375	0.500	0.122	0.087	0.256
YDEN060304PDFR-D	0.177	Without	●												0.375	0.500	0.122	0.110	0.256
YDEN060308PDFR-D	0.177	Without	●												0.375	0.500	0.122	0.094	0.256
YDEN0603PDCR-LD	0.295	With*	●												0.375	0.500	0.122	0.087	0.375
YDEN0603PDFR-WD	-	Without	●												0.364	0.504	0.122	0.177	-
YDEN0603PDFR-BD	-	Without	●												0.364	0.508	0.122	0.157	-

* Edge preparation is applied only on the peripheral and chamfered sections. The remaining section of the cutting edge is left sharp.

● : New product

● : Line up

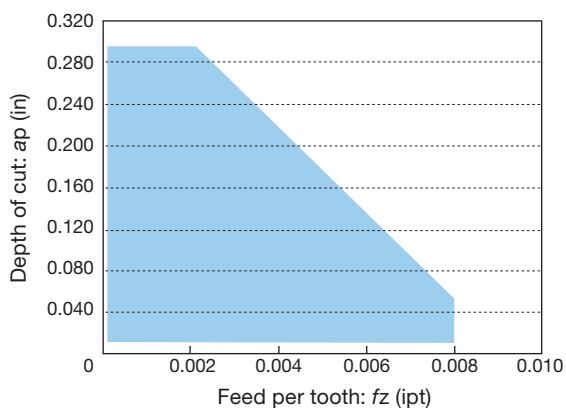
Package quantity = 1 pc. per box

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Grades	Cutting speed Vc (sfm)	Feed per tooth fz (ipt)
N	Cast aluminum alloy / Die-cast (Si < 13%)	DX110	1640 - 13123	0.002 - 0.008
	Cast aluminum alloy / Die-cast (Si ≥ 13%)	DX110	656 - 2625	0.002 - 0.008
	Aluminum alloy (1000 - 7000 series)	DX110	1640 - 13123	0.002 - 0.008
	Copper alloy	DX110	656 - 1640	0.002 - 0.008

- The values in the above list are of standard recommendations and may require adjustments in consideration with cutting depths and/or workpiece/machine rigidity.
- Use wiper inserts (-WD) for better surface requirements and deburring inserts (-BD) to remove burrs.
- Always use wet cutting (emulsion coolant) for machining aluminum or copper alloys.

APPLICATION RANGE



Cutter : TPYD06U3.00B1.00R16 ($\phi = 3.150"$ z = 16)
 Insert : YDEN0603PDCR-LD DX110
 Workpiece material : ADC12
 Cutting speed : Vc = 8245 sfm
 Coolant : Wet
 Machine : Vertical M/C, BT40, 18.5 kW

Tungaloy America, Inc.

3726 N Ventura Drive, Arlington Heights, IL 60004, U.S.A.

Inside Sales: +1-888-554-8394

Technical Support: +1-888-554-8391

Fax: +1-888-554-8392

www.tungaloy.com/us

Tungaloy Canada

432 Elgin St. Unit 3, Brantford, Ontario N3S 7P7, Canada

Phone: +1-519-758-5779 Fax: +1-519-758-5791

www.tungaloy.com/ca

Tungaloy de Mexico S.A.

C Los Arellano 113, Parque Industrial Siglo XXI

Aguascalientes, AGS, Mexico 20290

Phone: +52-449-929-5410 Fax: +52-449-929-5411

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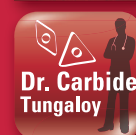


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July, 2021 (TJ)