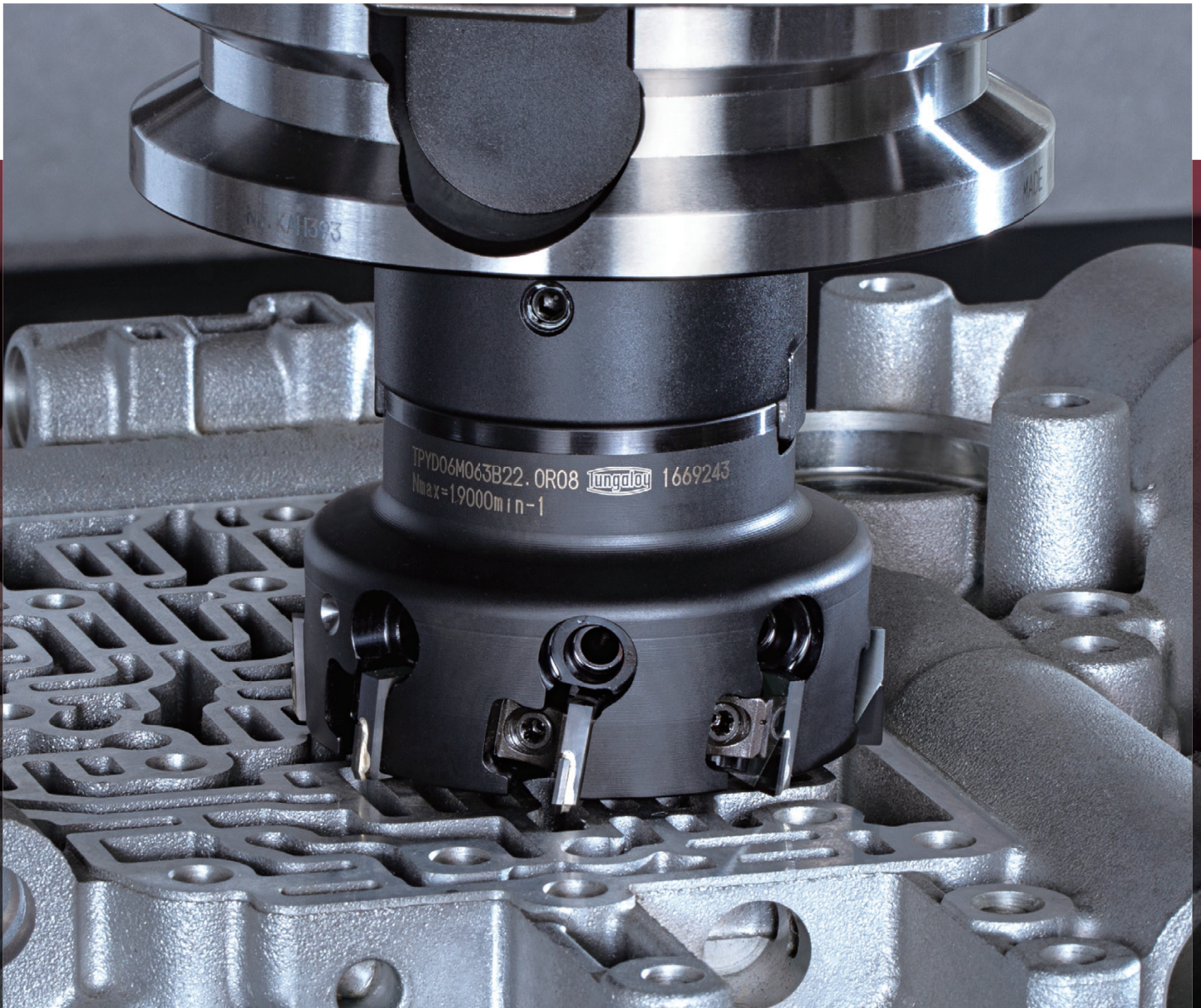


TUNG^{PEED}MILL

Tungaloy Report No. 524S1-G

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.

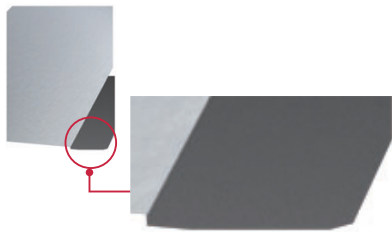
DC (mm)	Number of inserts on the cutter	
	New Close pitch	Extra close pitch
50	6	8
63	8	10
80	10	16
100	12	22
125	14	26
160	20	34



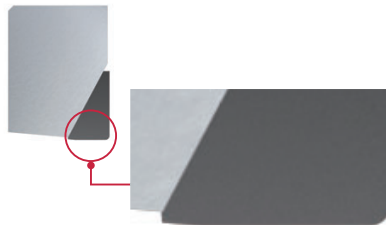
New insert geometries

■ Nose radius (with R0.4 or R0.8)

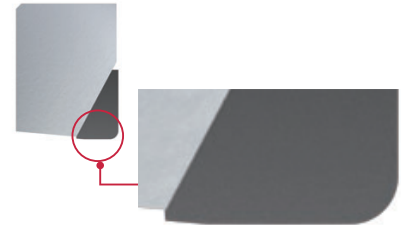
Ideal for applications where corner radius on the workpiece is specified. Rounded nose corner can also protect the edge from fracture during challenging interrupted cutting.



Double-angle design (YDEN0603PDFR-D)



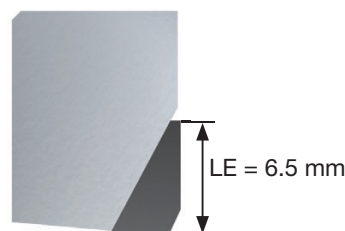
R0.4 (YDEN0603**04**PDFR-D)



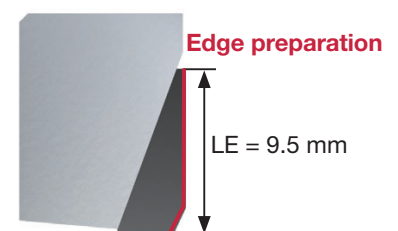
R0.8 (YDEN0603**08**PDFR-D)

■ Long edged insert

Featuring 9.5 mm 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)

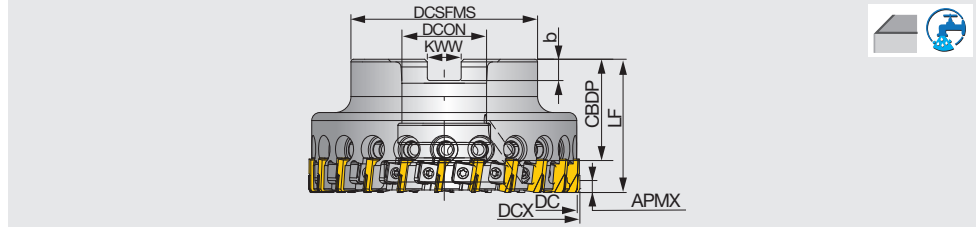


Long edge version
(YDEN0603PDCR-**LD**)

TPYD06

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

GAMP = +9°, GAMF = +4°



	Designation	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...

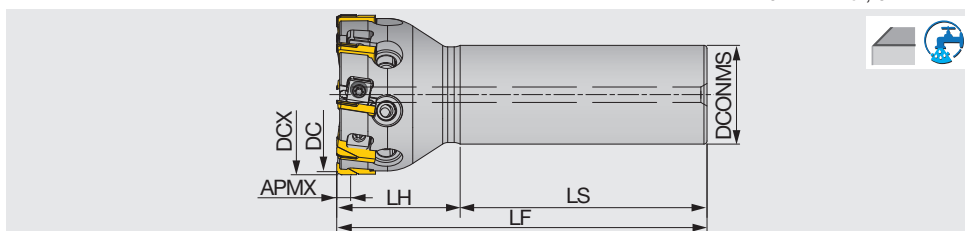
SPARE PARTS

Designation	Insert locking wedge	Wedge fixing screw	Adjusting cam	Torx bit	Cam tightening screw	Wrench	Grip	Shell locking bolt
TPYD06M063B22.0R**	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	CM10x30H
TPYD06*080B2*.R**	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	CM12x30H
TPYD06M100B32.0R**	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	CM16x40H
TPYD06J100B31.7R**	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	TMBA-M16H
TPYD06*125B**.R**	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W	TMBA-M20H
TPYD06*160B**.R**	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°



	Designation	APMX	DC	DCX	CICT	DCONMS	LF	LH	LS	WT(kg)	Air hole	RPMX(min ⁻¹)	Insert
New	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...

SPARE PARTS

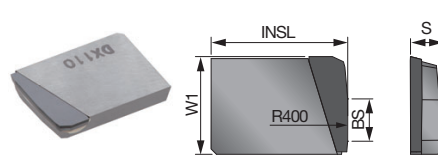
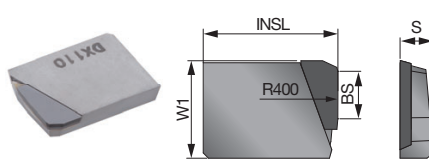
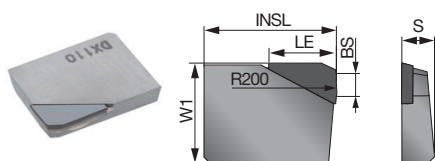
Designation	Insert locking wedge	Wedge fixing screw	Adjusting cam	Torx bit	Cam tightening screw	Wrench	Grip
EPYD06M050C32.0R**	WF875N	DS-5T	AJC08	BLDT10/S7-A	SSHM4-4	P-2	H-TB2W

■ INSERT

YDEN0603PD(F/S)R-D

YDEN0603PDFR-WD

YDEN0603PDFR-BD

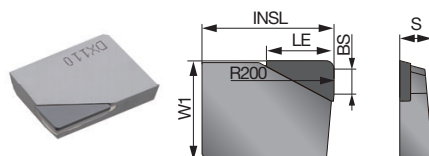
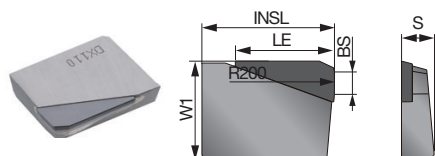


New

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	4.5	Without	●												9.5	12.7	3.1	2.2	6.5
YDEN0603PDSR-D	4.5	With	●												9.5	12.7	3.1	2.2	6.5
YDEN060304PDFR-D	4.5	Without	●												9.5	12.7	3.1	2.8	6.5
YDEN060308PDFR-D	4.5	Without	●												9.5	12.7	3.1	2.4	6.5
YDEN0603PDCR-LD	7.5	With*	●												9.5	12.7	3.1	2.2	9.5
YDEN0603PDFR-WD	-	Without	●												9.2	12.8	3.1	4.5	-
YDEN0603PDFR-BD	-	Without	●												9.2	12.9	3.1	4	-

* 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

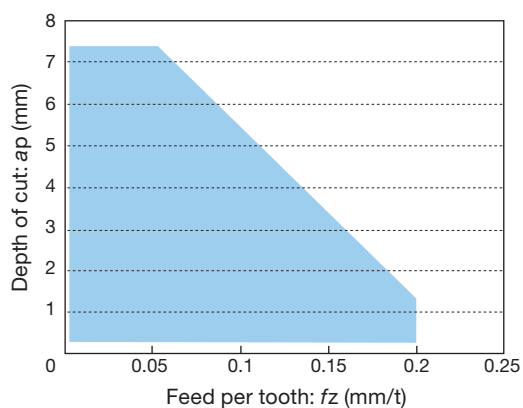
Package quantity = 1 pc. per box

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Grades	Cutting speed V_c (m/min)	Feed per tooth f_z (mm/t)
N	Cast aluminum alloy / Die-cast (Si < 13%)	DX110	500 - 4,000	0.05 - 0.2
	Cast aluminum alloy / Die-cast (Si ≥ 13%)	DX110	200 - 800	0.05 - 0.2
	Aluminum alloy (1000 - 7000 series)	DX110	500 - 4,000	0.05 - 0.2
	Copper alloy	DX110	200 - 500	0.05 - 0.2

- 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 : TPYD06J080B25.4R16 ($\phi = 80$ mm, $z = 16$)
 Insert : YDEN0603PDCR-LD DX110
 Workpiece material : ADC12
 Cutting speed : $V_c = 2,513$ m/min
 Coolant : Wet
 Machine : Vertical M/C, BT40, 18.5 kW

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