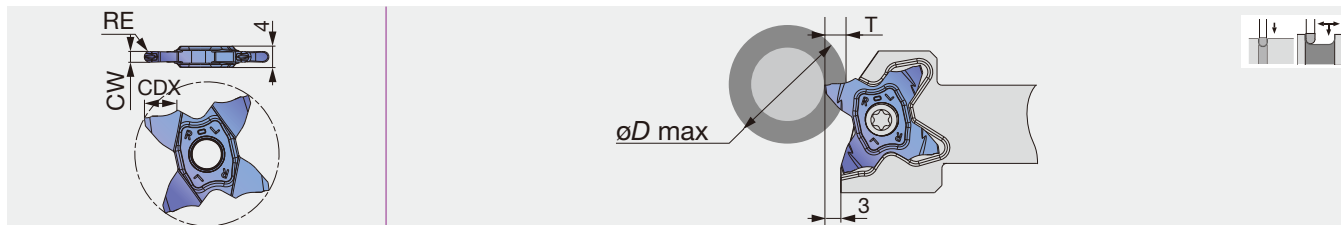


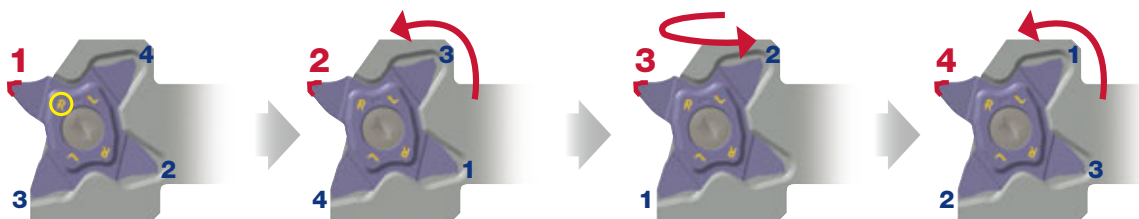
TCM27-Full R



Designation	Grade AH725	CW ± 0.02	RE	CDX	Relation of groove depth (T) and Max. diameter (øD max)												
					T≤1.0	T≤2.0	T≤3.0	T≤3.5	T≤4.0	T≤4.5	T≤5.0	T≤5.5	T≤5.7	T≤6.0	T≤6.2	T≤6.4	
TCM27-157-079	●	1.57	0.79	3	∞	∞	∞	-	-	-	-	-	-	-	-	-	-
TCM27-200-100	●	2	1	3	∞	∞	∞	-	-	-	-	-	-	-	-	-	-
TCM27-239-120	●	2.39	1.2	5.7	∞	∞	∞	600	280	180	130	50	35	-	-	-	-
TCM27-300-150	●	3	1.5	6.4	∞	∞	∞	600	280	180	135	105	95	85	78	55	-

Package Quantity = 5 pcs.
● : Line up

HOW TO INDEX INSERTS



1. Right-hand edge (R) is used for the right-hand toolholders.
2. Rotate the insert
3. Flip over the insert
4. Rotate the insert

STANDARD CUTTING CONDITIONS

ISO	Workpiece materials	Grades	Cutting speed Vc (m/min)	Feed: f (mm/rev)						Depth of cut for profiling (with full radius insert)
				New TCL27	TCS27	TCM27	Parting-off		Profiling (with full radius insert)	
							Grooving, parting-off	(with hand)		
P	Carbon steel (S45C / C45, etc.)	AH725	100 - 200	0.03 - 0.12	0.05 - 0.15	0.05 - 0.25	0.04 - 0.12	0.05 - 0.10	0.05 - 0.15	0.5
	Alloy steel (SCM435 / 34CrMo4, etc.)	AH725	50 - 180	0.03 - 0.12	0.05 - 0.15	0.05 - 0.25	0.04 - 0.12	0.05 - 0.10	0.05 - 0.15	0.5
M	Stainless steel (SUS304 / X5CrNi18-9, etc.)	AH725	100 - 150	0.03 - 0.12	0.05 - 0.15	0.05 - 0.20	0.04 - 0.12	0.05 - 0.10	0.05 - 0.15	0.5
K	Grey cast iron (FC250 / 250 / GGG25, etc.)	AH725	50 - 180	0.03 - 0.12	0.05 - 0.15	0.05 - 0.25	0.04 - 0.12	0.05 - 0.10	0.05 - 0.15	0.5
	Ductile cast iron (FCD400 / 400-15 / GGG400, etc.)	AH725	50 - 120	0.03 - 0.12	0.05 - 0.15	0.05 - 0.20	0.04 - 0.12	0.05 - 0.10	0.05 - 0.15	0.5
S	Titanium alloys (Ti-6Al-4V, etc.)	AH725	30 - 60	0.03 - 0.12	0.05 - 0.15	0.05 - 0.15	0.04 - 0.12	0.05 - 0.10	0.05 - 0.10	0.5
	Superalloys (Inconel718, etc.)	AH725	20 - 50	0.03 - 0.12	0.05 - 0.15	0.05 - 0.15	0.04 - 0.12	0.05 - 0.10	0.05 - 0.10	0.5