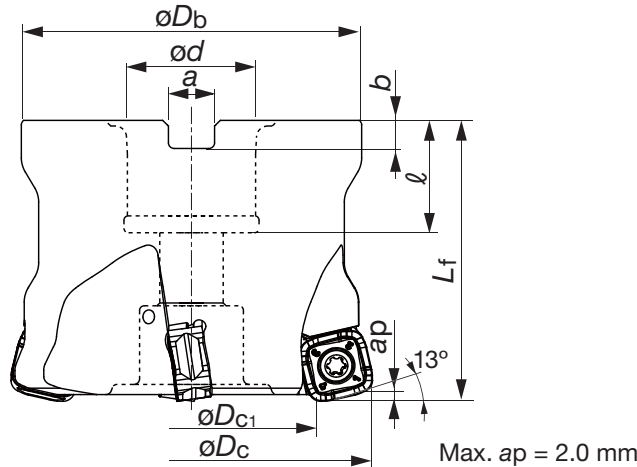


Cutter



● Bore type

JIS

Replacement parts

Description		Parts Cat. No.
Wrench	Clamping screw	CSPB-4
	Bit	BLD IP15/S7
	Handle	H-TBS

Cat. No.	Stock	No. of inserts	Dimensions (mm)								Weight (kg)	Air hole	Center bolt	Insert
			ϕD_c	ϕD_{c1}	ϕD_b	ϕd	ℓ	L_f	b	a				
TXQ12R050M22.2-03	●	3	50	33.8	47	22.225	20	50	5	8	0.4	with	FSHM10-40H	SQMU1206 ZSR-MJ
TXQ12R063M22.2-04	●	4	63	46.8	59	22.225	20	50	5	8	0.8		CM10X30H	
TXQ12R080M31.7-05	●	5	80	63.8	76	31.75	32	63	8	12.7	1.5		CM16X40H	
TXQ12R100M31.7-06	●	6	100	83.8	96	31.75	32	63	8	12.7	2.6		CM16X40H	
TXQ12R125M38.1-07	●	7	125	108.8	98	38.1	44	63	10	15.9	3.3		TMBA-M20H	

● : Stocked items

Standard cutting conditions

Work material	Hardness	Priority	Grades	Cutting speed V_c (m/min)	Feed per tooth f_z (mm/t)
High carbon steels (S45C / C45 etc.)	~ 300HB	First choice	AH725	100 - 300	0.5 - 2.0
		For wear resistance	T3130		
		For impact resistance	AH130		
Alloyed steels (SCM440 / 42CrMo4 etc.)	~ 300HB	First choice	AH725	100 - 200	0.5 - 1.5
		For wear resistance	T3130		
		For impact resistance	AH130		
Prehardened steels (PX5, NAK80 etc.)	30 ~ 40HRC	-	AH725	100 - 200	0.5 - 1.0
Stainless steel (SUS304 / X5CrNi18-9 etc.)	~ 200HB	-	AH130	100 - 150	0.3 - 0.8
Grey cast iron (FC250 / GG250 / 250 etc.)	-	-	AH120	100 - 300	0.5 - 2.0
Ductile cast irons (FCD600 / GGG60 / 600-3 etc.)	-	-	AH120	80 - 200	0.5 - 2.0
Titanium alloy (Ti-6Al-4V etc.)	~ 40HRC	-	AH725	30 - 60	0.3 - 0.7
Hardened steels (SKD61 / X40CrMoV5-1 etc.)	40 ~ 50HRC	-	AH725	80 - 130	0.1 - 0.3
	50 ~ 60HRC			50 - 70	0.03 - 0.07

- Slot or pocket milling is not recommended, since the chip recutting easily occurs.
- Tool overhang length must be as short as possible to avoid chatter. When the tool overhang length is long, decrease the number of revolutions and feed.

- Cutting conditions are generally limited by the rigidity and power of the machine and the rigidity of the workpiece. When setting the conditions, start from half of the values of the standard cutting conditions and then increase the value gradually while making sure the machine is running normally.