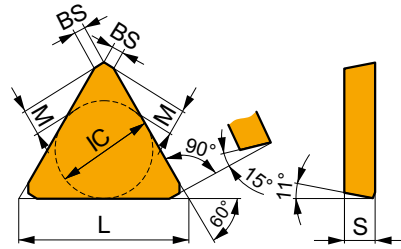




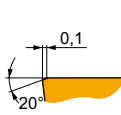
## TPCN 16

	BS	IC	L	M	S
	[mm]	[mm]	[mm]	[mm]	[mm]
1603	1.20	9.530	16.10	2	3.18



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]

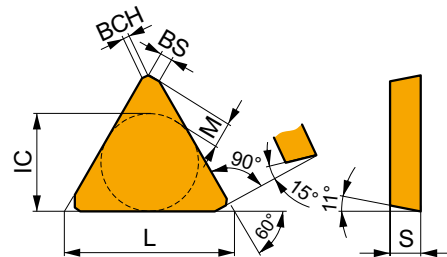


Special design for disc milling.

TPCN 1603PDSN	M8330	-	■	195	0.20	-	-	-	■	185	0.20	-	-	-	-	-	-	-	-	-
	M8340	-	■	175	0.20	-	-	-	■	165	0.20	-	-	-	-	-	-	-	-	-

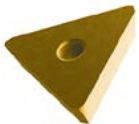
## TPKN

	IC	L	M	S	BCH	BS
	[mm]	[mm]	[mm]	[mm]	[mm]	[mm]
1603	9.530	16.50	2	3.18	1.20	1.30
2204	12.700	22.00	4	4.76	1.20	1.50



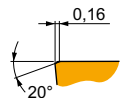
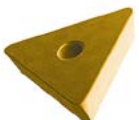
Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE	P			M			K			N			S			H		
		vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap	vc	f	ap
	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]	[m/min]	[mm/tooth]	[mm]



PDER edge preparation, zero rake angle geometry for light to medium machining.

TPKN 1603PDER	M8330	-	■	195	0.15	4.0	-	-	■	185	0.15	4.0	-	-	-	-	-	-	-
	M8340	-	■	175	0.15	4.0	-	-	■	165	0.15	4.0	-	-	-	-	-	-	-
TPKN 2204PDER	8215	-	■	190	0.15	5.5	-	-	■	180	0.15	5.5	-	-	-	-	-	-	-
	M8330	-	■	190	0.15	5.5	-	-	■	180	0.15	5.5	-	-	-	-	-	-	-
	M8340	-	■	170	0.15	5.5	-	-	■	160	0.15	5.5	-	-	-	-	-	-	-



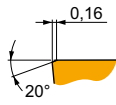
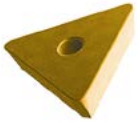
PDSR edge preparation, zero rake angle geometry for medium machining.

TPKN 1603PDSR	M8330	-	■	185	0.20	4.0	-	-	■	175	0.20	4.0	-	-	-	-	-	-	■	35	0.15	1.0
	M8340	-	■	165	0.20	4.0	-	-	■	155	0.20	4.0	-	-	-	-	-	-	-	-	-	-
	S26	-	■	75	0.20	4.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE [mm]	P			M			K			N			S			H		
		vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]



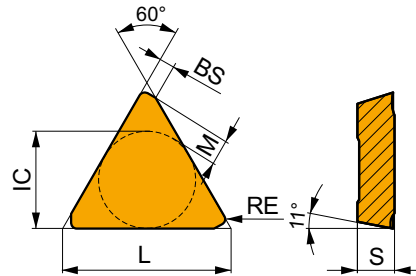
PDSR edge preparation, zero rake angle geometry for medium machining.

TPKN 2204PDSR	H10	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	
	M5315	–	✓	235	0.20	5.5	–	–	–	✓	80	0.20	5.5	–	–	–	–	–	–
	M8310	–	✓	195	0.20	5.5	–	–	–	✓	220	0.20	5.5	–	–	–	–	–	–
	M8330	–	✓	195	0.20	5.5	–	–	–	✓	185	0.20	5.5	–	–	–	–	–	–
	M8340	–	✓	175	0.20	5.5	–	–	–	✓	165	0.20	5.5	–	–	–	–	–	–
	M8340	–	✓	160	0.20	5.5	–	–	–	✓	150	0.20	5.5	–	–	–	–	–	–
	M9325	–	✓	220	0.20	5.5	–	–	–	✓	205	0.20	5.5	–	–	–	–	–	–
S26	–	✓	75	0.20	5.5	–	–	–	–	–	–	–	–	–	–	–	–	–	

## TPKR

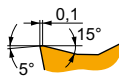


	IC [mm]	L [mm]	M [mm]	S [mm]	BS [mm]
1603	9.530	16.50	2	3.18	1.40
2204	12.700	22.00	4	4.76	1.40



Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

Product	RE [mm]	P			M			K			N			S			H		
		vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]	vc [m/min]	f [mm/tooth]	ap [mm]



PDSR edge preparation, chipbreaker geometry for medium to heavy machining.

TPKR 1603PDSR	M8330	–	■	185	0.20	4.0	✓	110	0.18	4.0	■	175	0.20	4.0	–	–	–	–	–
	M8340	–	■	165	0.20	4.0	✓	95	0.18	4.0	✓	155	0.20	4.0	–	–	–	–	–
TPKR 2204PDSR	M8330	–	■	175	0.20	5.5	✓	105	0.18	5.5	■	165	0.20	5.5	–	–	–	–	–
	M8340	–	■	160	0.20	5.5	✓	95	0.18	5.5	✓	150	0.20	5.5	–	–	–	–	–
	M9325	–	■	220	0.20	5.5	–	–	–	–	■	205	0.20	5.5	–	–	–	–	–
	M9340	–	■	195	0.20	5.5	✓	115	0.18	5.5	–	–	–	–	–	–	–	–	–