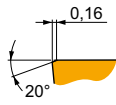
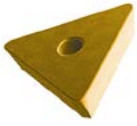




Suitability and starting values for cutting speed (vc), feed (f) and depth of cut (ap). Refer to our Machining Calculator app for further calculations.

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]



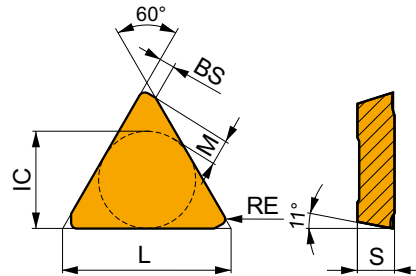
PDSR edge preparation, zero rake angle geometry for medium machining.

TPKN 2204PDSR	H10	-	-	-	-	-	-	80	0.20	5.5	-	-	-	-	-	-	-	-
	M5315	-	235	0.20	5.5	-	-	220	0.20	5.5	-	-	-	-	-	45	0.15	1.0
	M8310	-	195	0.20	5.5	-	-	185	0.20	5.5	-	-	-	-	-	35	0.15	1.0
	M8330	-	175	0.20	5.5	-	-	165	0.20	5.5	-	-	-	-	-	35	0.15	1.0
	M8340	-	160	0.20	5.5	-	-	150	0.20	5.5	-	-	-	-	-	-	-	-
	M9325	-	220	0.20	5.5	-	-	205	0.20	5.5	-	-	-	-	-	40	0.15	1.0
	S26	-	75	0.20	5.5	-	-	-	-	-	-	-	-	-	-	-	-	-

TPKR

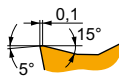


	IC [mm]	L [mm]	M [mm]	S [mm]	BS [mm]
1603	9.530	16.50	2	3.18	1.40
2204	12.700	22.00	4	4.76	1.40



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	-	-	-	-	-	-	-	-	-