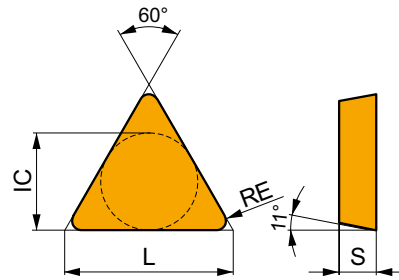




TPUN

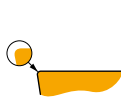


	IC	L	S
	[mm]	[mm]	[mm]
1103	6.350	11.00	3.18
1603	9.525	16.50	3.18
2204	12.700	22.00	4.76



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			
	[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]



Zero rake geometry milling insert, can also be used for turning.

TPUN 110304	H10	0.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	M8330	0.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TPUN 110308	M8330	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TPUN 160304	8215	0.4	☑	155	0.15	4.0	–	–	–	☑	145	0.15	4.0	–	–	–	–	–	–
	H10	0.4	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	M8330	0.4	☑	155	0.15	4.0	–	–	–	☑	145	0.15	4.0	–	–	–	–	–	–
	S26	0.4	☑	65	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–
TPUN 160308	8215	0.8	☑	185	0.15	4.0	–	–	–	☑	175	0.15	4.0	–	–	–	–	–	–
	H10	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	M8330	0.8	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
	S26	0.8	☑	75	0.15	4.0	–	–	–	–	–	–	–	–	–	–	–	–	–
TPUN 160312	M8330	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–
TPUN 220408	8215	0.8	☑	170	0.20	5.0	–	–	–	☑	160	0.20	5.0	–	–	–	–	–	–
	M8330	0.8	☑	170	0.20	5.0	–	–	–	☑	160	0.20	5.0	–	–	–	–	–	–
	S26	0.8	☑	70	0.20	5.0	–	–	–	–	–	–	–	–	–	–	–	–	–
TPUN 220412	M8330	1.2	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–	–