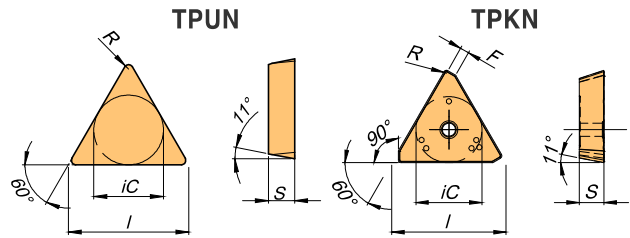
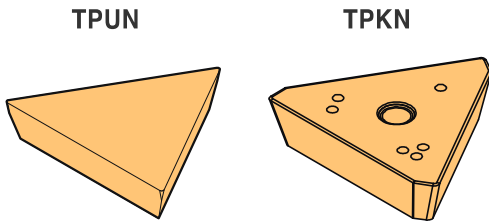
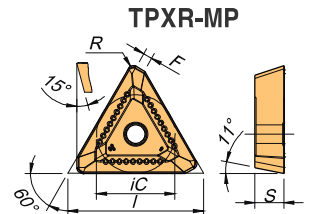
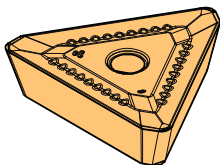


# TP... 2204.. Inserts | Pastilhas | Plaquetas



**New** TPXR-MP



ISO	Grade Code	Grades																		Dimensions (mm)										
		P						M			K						N		S						H					
		M6	54	68	66	78	86	I5	68	66	I5	54	68	66	I5	D2	67	17	10	D6	P3	G6	I5	M6	D4	iC	S	I	R	F
(1) Geometry Code	ISO Ref.	PH6103	PH6910	PH6920	PH6930	PH6125	PH6135	PH6740	PH6920	PH6930	PH6740	PH6910	PH6920	PH6930	PH6740	PH6705	PH6325	PH0325	PH0910	PDP410	PH7930	PH7740	PH6740	PH6103	PBH910					
1120777	TPUN 220404			○				○																		12,70	4,76	22	0,4	-
1120779	TPUN 220408			○				⊗																		12,70	4,76	22	0,8	-
1120783	TPUN 220412			○				⊗																		12,70	4,76	22	1,2	-
1110465	TPKN 2204 PDER			⊗				⊗						⊗												12,70	4,76	22	0,5	1,7
1110466	TPKN 2204 PDFR			○				⊗									⊗									12,70	4,76	22	0,5	1,7
1110609	TPKN 2204 PDSR			⊗				⊗						⊗												12,70	4,76	22	0,5	1,7
<b>New</b> 1112135	TPXR 2204 PDSR-MP			○										○												12,70	4,76	22	1,0	1,7

⊗ First choice / 1ª escolha / 1ª opción   ⊗ Stock items / Itens de stock   ○ Available under request / Disponibilidade sob consulta / Disponible bajo consulta

Insert Order Code = (1) Geometry Code + (2) Grade Code

## Rec. Cutting Conditions

ISO	PSM	Material	HB (Brinell) Grade	V <sub>C</sub> (m/min)			Feed f <sub>z</sub> (mm/t)
				Wear Resistance		Toughness	
				PH6920	PH6740	PH0325	
<b>P</b>	1	Unalloyed steel	125-220	150-230	130-160	-	0,10-0,30
	2	Low-alloyed steel	220-280	140-220	120-150	-	0,10-0,30
	3	High-alloy steel	280-380	130-180	100-130	-	0,10-0,25
<b>K</b>	7	Malleable cast iron	130-230	150-280	130-250	120-170	0,10-0,30
	8	Grey cast iron	180-245	130-230	110-220	100-150	0,10-0,30
	9	Nodular cast iron	160-250	80-190	80-170	70-120	0,10-0,25

(Note 1) Cutting conditions a<sub>e</sub>/D<sub>c</sub>=70%.

(Note 2) Cutting conditions should be adjusted according to the machine and work rigidity.

(Note 3) It's possible to occur vibrations in certain cases. Please reduce depth of cut and / or reduce cutting conditions in following cases:

- When using long shank;
- When using long tool overhang with arbor type;
- When application has poor clamping rigidity or when using a low rigidity machine.

A  
Milling  
Plus  
TCPlus  
HiFeed  
AluPro  
LinePro  
Classic  
TroMill  
W-Pro  
MultiFit  
HardMill  
Solid Carbide  
Technical Data