

To introduce TPDC insert line-up expansion for STS machining

TPDC-CM Line-up Expansion Information

**Additional diameters for stainless steel machining
are available from stock in Korea now**

- Sharp chamfer and hard point increases chipping resistance and prevents unexpected tool breakage.
- New grade with strength at high temperature and lubrication enhances welding resistance and excellent chip evacuation.
- The optimal thinning shape minimizes cutting load in pulling out chip.

Code system

TPD	1500	C	M	PC330N
↑ Top solid Piercing Drill	↑ Drill Dia. 1500: Ø15.0	↑ Insert type C: Cone type	↑ Workpiece P: Steel M: Stainless steel N: Aluminum	↑ Grade P: PC5335 M: PC330N N: H01

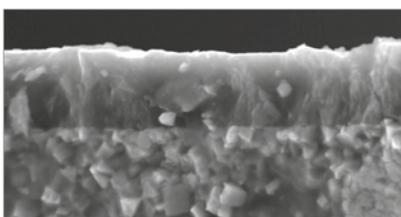
Recommended cutting conditions

ISO	Workpiece	Aspect ratio (L/D)	HB	Grade	vc (m/min)	Feed rate (mm/rev) per drill dia. (mm)		
						Ø12.00 - Ø17.99	Ø18.00 - Ø25.99	Ø26.00 - Ø30.99
M Stainless steel	Austenitic	1.5D, 3D	135 - 275	PC330N	65 (50 - 80)	0.05 - 0.15	0.10 - 0.20	0.15 - 0.25
	Ferritic, martensitic		135 - 275	PC330N	75 (60 - 90)	0.10 - 0.20	0.15 - 0.30	0.20 - 0.35
	Austenitic	5D	135 - 275	PC330N	60 (40 - 80)	0.05 - 0.15	0.10 - 0.20	0.15 - 0.25
	Ferritic, martensitic		135 - 275	PC330N	70 (50 - 90)	0.10 - 0.20	0.15 - 0.30	0.20 - 0.35
	Austenitic	8D	135 - 275	PC330N	50 (30 - 70)	0.05 - 0.10	0.05 - 0.15	0.10 - 0.20
	Ferritic, martensitic		135 - 275	PC330N	60 (40 - 80)	0.05 - 0.15	0.10 - 0.25	0.15 - 0.30
	Austenitic	10D, 12D	135 - 275	PC330N	50 (30 - 60)	0.05 - 0.10	0.05 - 0.15	0.10 - 0.20
	Ferritic, martensitic		135 - 275	PC330N	60 (40 - 70)	0.05 - 0.15	0.10 - 0.25	0.15 - 0.30

In interrupted machining, reduce the feed to 0.1 - 0.15 machining around the interrupted part.

In stainless steel machining, start with low feed machining then, gradually get the cutting conditions higher and set the optimal cutting conditions.

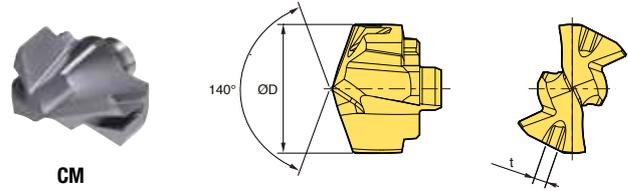
Features Grade



PC330N ^{new}

- PVD coating technology with hard and smooth surface.
- Coating layer with stability of thermal shock and adherence.
- Grade for stainless steel machining.

Inserts



TPDC-CM	Coated
	PC330N
TPD1200CM	▲
TPD1220CM	●
TPD1250CM	●
TPD1260CM	●
TPD1300CM	▲
TPD1350CM	○
TPD1400CM	▲
TPD1420CM	○
TPD1430CM	○
TPD1450CM	●
TPD1500CM	▲
TPD1520CM	●
TPD1550CM	○
TPD1600CM	▲
TPD1630CM	●
TPD1650CM	●
TPD1670CM	●
TPD1690CM	●
TPD1700CM	▲
TPD1750CM	▲
TPD1770CM	●
TPD1800CM	▲
TPD1810CM	●
TPD1850CM	●
TPD1860CM	○
TPD1870CM	●
TPD1900CM	●
TPD1920CM	●
TPD1930CM	●

TPDC-CM	Coated
	PC330N
TPD1950CM	●
TPD1970CM	●
TPD2000CM	▲
TPD2050CM	●
TPD2100CM	▲
TPD2150CM	●
TPD2200CM	▲
TPD2250CM	○
TPD2260CM	○
TPD2270CM	○
TPD2300CM	●
TPD2350CM	●
TPD2400CM	○
TPD2450CM	○
TPD2500CM	▲
TPD2530CM	○
TPD2550CM	○
TPD2580CM	○
TPD2590CM	○
TPD2600CM	▲
TPD2650CM	○
TPD2700CM	○
TPD2750CM	○
TPD2800CM	○
TPD2850CM	○
TPD2900CM	○
TPD2950CM	○
TPD3000CM	○
TPD3050CM	○

▲: Stock item Europe ●: Stock item ○: Production by request

**For any further information,
please contact our customer support team!**

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