

GrooveLine



TETRAMCUT

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Tungaloy Report No. 416S1-G

Expanded groove width options for **TCL18 and TCG18 inserts**

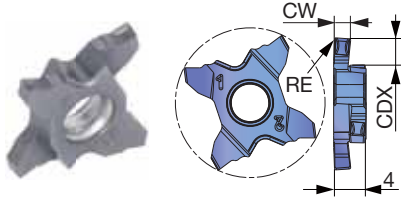


INDUSTRY 4.0
FEED the SPEED!



For more information

TCL18R (3D chipbreaker)



Right-hand (R) shown.

P Steel	★								
M Stainless	★								
K Cast iron	★								
N Non-ferrous									
S Superalloys	★								
H Hard materials									

★ : First choice
☆ : Second choice

New

Designation	HAND	CW±0.02	RE	Coated						CDX	
				AH7025							
TCL18R175-020	R	1.75	0.2	●							3.5
TCL18R250-030	R	2.5	0.3	●							3.5

5 pieces per package
● : New product

New TCG18R/L (Full R)



Right-hand (R) shown.

P Steel	★								
M Stainless	★								
K Cast iron	★								
N Non-ferrous									
S Superalloys	★								
H Hard materials									

★ : First choice
☆ : Second choice

Designation	HAND	CW±0.02	RE	Coated						CDX	
				AH7025							
TCG18R100-050	R	1	0.5	★							2
TCG18L100-050	L	1	0.5	★							2
TCG18R158-079	R	1.58	0.79	★							3.5
TCG18L158-079	L	1.58	0.79	★							3.5
TCG18R200-100	R	2	1	★							3.5
TCG18L200-100	L	2	1	★							3.5
TCG18R239-120	R	2.39	1.2	★							3.5
TCG18L239-120	L	2.39	1.2	★							3.5
TCG18R300-150	R	3	1.5	★							3.5
TCG18L300-150	L	3	1.5	★							3.5
TCG18R318-159	R	3.18	1.59	★							3.5
TCG18L318-159	L	3.18	1.59	★							3.5

5 pieces per package
★ : To be released in 2020

STANDARD CUTTING CONDITIONS

TCL18R (3D chipbreaker), TCG18R/L (Full R)

ISO	Workpiece materials	Grades	Cutting speed Vc (m/min)	Feed: f (mm/rev)	
				TCL18	TCG18
P	Low carbon steel S15C / C15, S20C / C20, etc.	AH7025	80 - 180	0.03 - 0.12	0.04 - 0.14
	Carbon steels, Alloy steel S55C / C55, SCM440 / 42CrMoS4, etc.	AH7025	80 - 180	0.03 - 0.12	0.04 - 0.14
	Prehardened steel NAK80, PX5, etc.	AH7025	80 - 180	0.03 - 0.12	0.04 - 0.14
M	Stainless steel SUS304 / X5CrNi18-9, X5CrNiMo17-12-2, etc.	AH7025	50 - 120	0.03 - 0.12	0.04 - 0.14
K	Grey cast iron FC250 / GG25 / 250, FC300 / GG30 / 300, etc.	AH7025	50 - 180	0.03 - 0.12	0.04 - 0.14
	Ductile cast iron FCD400 / 400-15, FCD600 / 600-3, etc.	AH7025	50 - 180	0.03 - 0.12	0.04 - 0.14
S	Titanium alloys Ti-6Al-4V, etc.	AH7025	30 - 80	0.03 - 0.12	0.04 - 0.14
	Superalloys Inconel718, etc.	AH7025	20 - 60	0.03 - 0.12	0.04 - 0.14

Standard lineup of TetraMini-Cut grooving inserts

Groove width CW (mm)	Corner rad. RE (mm)	TCL18R	TCS18R	TCG18R/L	TCP18R/L	TCP18R/L-F
		AH7025	AH7025	AH7025	AH725	SH725
0.33	0.05				●	●
0.43	0.05				●	●
0.50	0.05				●	●
0.75	0.05				●	●
0.95	0.05				●	●
1.00	0.05					●
	0.1		●	●	●	●
1.20	0.5			★		
	0.05					●
1.25	0.1		●	●	●	●
	0.1		●	●	●	●
1.30	0.05					●
	0.1		●	●	●	●
1.40	0.2		●	●	●	●
	0.1		●	●	●	●
1.45	0.2		●	●	●	●
	0.05					●
1.50	0.1	●	●	●	●	●
	0.2	●	●	●	●	●
1.58	0.79			★		
1.60	0.2		●	●	●	●
1.70	0.2		●	●	●	●
1.75	0.05					●
	0.1		●	●	●	●
1.85	0.2	●	●	●	●	●
	0.2	●	●	●	●	●
2.00	0.05					●
	0.1	●	●	●	●	●
2.25	0.2	●	●	●	●	●
	0.2	●	●	●	●	●
2.30	0.2		●	●	●	●
2.39	1.2			★		
2.50	0.1		●	●	●	●
	0.2		●	●	●	●
2.65	0.3	●	●	●	●	●
	0.3	●	●	●	●	●
2.80	0.3		●	●	●	●
3.00	0.1	●	●	●	●	●
	0.2	●	●	●	●	●
3.18	0.3	●	●	●	●	●
	1.5			★		
	1.59			★		

● : New product ★ : To be released in 2020 ● : Line up

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