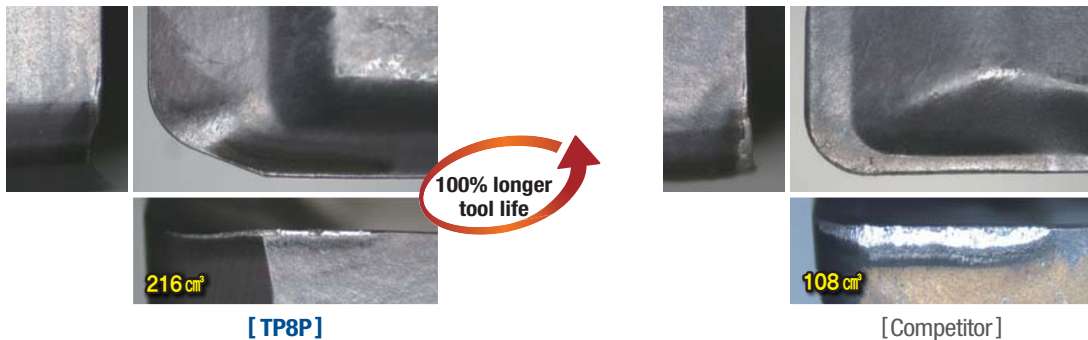


Performance evaluation

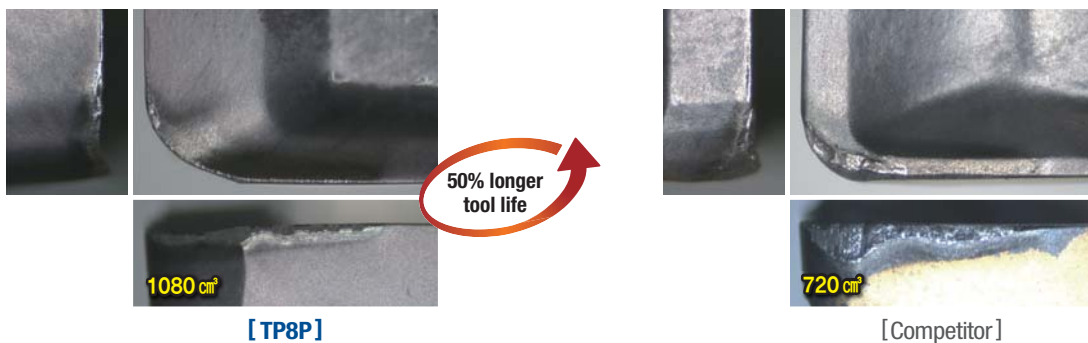
Wear resistance

Workpiece	Cast iron (600-3), steel rectangular tube, 300 (L) × 200 (W) × 100 (H)	
Cutting conditions	vc (m/min) = 150, fz (mm/t) = 0.15, ap (mm) = 3.0, ae (mm) = 40, dry	
Tools	Insert SOKX1406XPNR-ML (PC5300)	Holder TP8PCM063R-22-6-S014


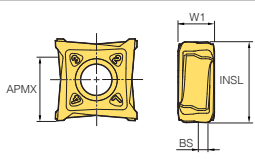

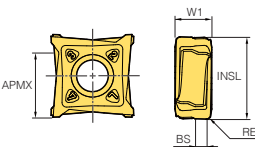


Wear resistance

Workpiece	Cast iron (600-3), steel rectangular tube, 300 (L) × 200 (W) × 100 (H)	
Cutting conditions	vc (m/min) = 200, fz (mm/t) = 0.2, ap (mm) = 3.0, dry	
Tools	Insert SOKX1406XPNR-ML (PC5300)	Holder TP8PCM063R-22-6-S014



Insert

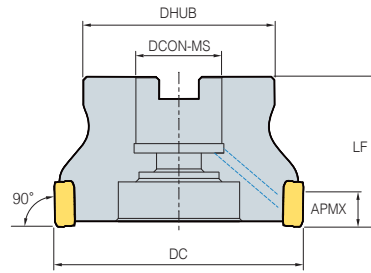
Picture	Designation	Coated	Dimensions (mm)					Geometries
		PC5300	INSL	W1	BS	RE	APMX	
	SOKX 1406XPNR-ML	●	14.47	6.5	1.35	-	11	
	SOKX 140608PNR-ML	●	14.47	6.5	1.69	0.8	11	

●: Stock item

TP8PC(M)-S014



AA
90°
• AR: -6°
• RR: -23° ~ -18°



(mm)

	Designation	Stock		DC	DHUB	DCON-MS	LF	APMX	
TP8PCM	040R-16-3-S014	●	3	40	34	16	40	11	0.18
	040R-16-4-S014	●	4	40	34	16	40	11	0.17
	050R-22-4-S014	●	4	50	45	22	40	11	0.28
	050R-22-5-S014	●	5	50	45	22	40	11	0.27
	050R-22-6-S014	●	6	50	45	22	40	11	0.28
	063R-22-6-S014	●	6	63	49	22	40	11	0.44
	063R-22-7-S014	●	7	63	49	22	40	11	0.45
	063R-22-8-S014	●	8	63	49	22	40	11	0.45
	080R-27-6-S014	●	6	80	60	27	50	11	0.87
	080R-27-7-S014	●	7	80	60	27	50	11	0.86
	080R-27-9-S014	●	9	80	60	27	50	11	0.89
	100R-32-8-S014	●	8	100	70	32	63	11	1.79
	100R-32-12-S014	●	12	100	70	32	63	11	1.80
	125R-40-9-S014	●	9	125	90	40	63	11	2.95
125R-40-15-S014	●	15	125	90	40	63	11	2.96	
TP8PC	080R-25.4-6-S014	●	6	80	60	25.4	50	11	0.90
	080R-25.4-7-S014	●	7	80	60	25.4	50	11	0.90
	080R-25.4-9-S014	●	9	80	60	25.4	50	11	0.92
	100R-31.75-8-S014	●	8	100	70	31.75	63	11	1.80
	100R-31.75-12-S014	●	12	100	70	31.75	63	11	1.82
	125R-38.1-9-S014	●	9	125	90	38.1	63	11	3.00
	125R-38.1-15-S014	●	15	125	90	38.1	63	11	3.00

●: Stock item

Available inserts



SOKX-ML

Designation	Coated	
	PC5300	
SOKX 1406XPNR-ML	●	
140608PNR-ML	●	

●: Stock item

Available arbors

	Designation	DCON	Available arbors
TP8PCM	040R-16-□-S014	16	BT□□-FMC16-□□
	050R-22-□-S014	22	BT□□-FMC22-□□
	063R-22-□-S014		
	080R-27-□-S014	27	BT□□-FMC27-□□
	100R-32-□-S014	32	BT□□-FMC32-□□
	125R-40-□-S014	40	BT□□-FMC40-□□
TP8PC	080R-25.4-□-S014	25.4	BT□□-FMA25.4-□□
	100R-31.75-□-S014	31.75	BT□□-FMA31.75-□□
	125R-38.1-□-SA14	38.1	BT□□-FMA38.1-□□

Parts

Specification	Screw 	Wrench
Ø40	FTGA0511-P	TW20-100
Ø50 ~ Ø125	FTGA0513-P	TW20-100

TP8PS-S014



AA
90°

• AR: -6°
• RR: -29° ~ -23°

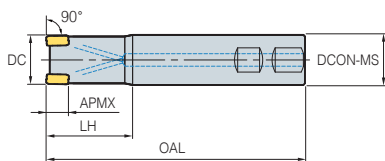


Fig. 1

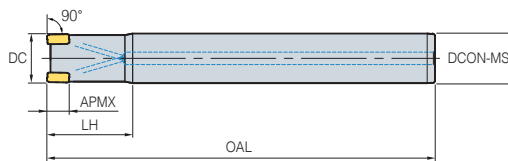


Fig. 2

(mm)

	Designation	Stock		DC	DCON-MS	LH	OAL	APMX		Fig.
TP8PS	032R-2W32-130-S014	●	2	32	32	40	130	11	0.70	1
	032R-3W32-130-S014	●	3	32	32	40	130	11	0.69	1
	032R-2C32-250-S014	●	2	32	32	50	250	11	1.40	2
	032R-3C32-250-S014	●	3	32	32	50	250	11	1.39	2
	040R-3W32-130-S014	●	3	40	32	40	130	11	0.78	1
	040R-4W32-130-S014	●	4	40	32	40	130	11	0.77	1
	040R-3C32-250-S014	●	3	40	32	50	250	11	1.51	2
	040R-4C32-250-S014	●	4	40	32	50	250	11	1.51	2

●: Stock item

Available inserts



SOKX-ML

Designation	Coated	
	PC5300	
SOKX 1406XPNR-ML	●	
140608PNR-ML	●	

●: Stock item

Parts

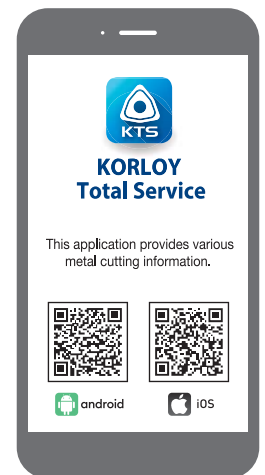
Specification	Screw	Wrench
Ø32	FTGA0511-P	TW20-100
Ø40	FTGA0513-P	TW20-100

⚠ For the safe metalcutting

- Use safety supplies such as protective gloves to prevent possible injury while touching the edge of tools.
- Use safety glasses or safety cover to hedge possible dangers. Inappropriate usage or excessive cutting condition may lead tool's breakage or even the fragment's scattering.
- Clamp the workpiece tightly enough to prevent its movement while its machining.
- Properly manage the tool change phase because the inordinately used tool can be easily broken under the excessive cutting load or severe wear, and it may threat the operator's safety.
- Use safety cover because chips evacuated during cutting are hot and sharp and may cause burns and cuts. To remove chips safely, stop machining, put on protective gloves, and use a hook or other tools.
- Prepare for fire prevention measures as the use of the non-water soluble cutting oil may cause fire.
- Use safety cover and other safety supplies because the spare parts or the inserts can be pulled out due to centrifugal force while high speed machining.



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