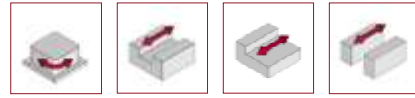
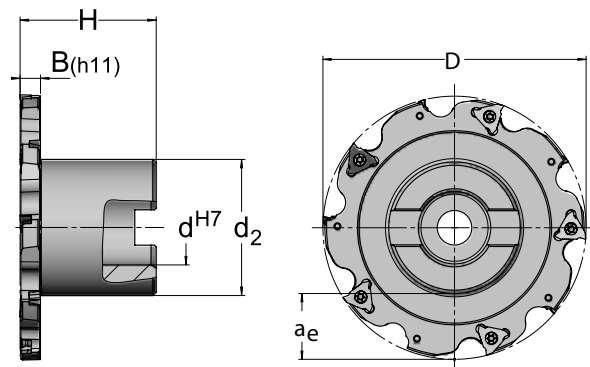


SIDE MILLING CUTTERS

TB18



Extremely smooth cutting through left and right hand inserts – highly precise widths of cut from 4–12 mm
Complies with narrow radial and axial run out tolerances
3-side embedding of the T-style indexable insert



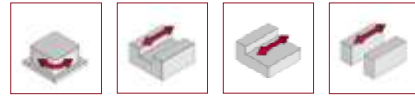
TB18

Article	D	d ₂	d ^{H7}	H	B _(h11)	zz	z _{eff}	a _e	lc	kg	INS
01T.0604.041	63	32	16	32	4	4 x 2	4	13.0	no	0.21	TN..1302.R/L
01T.0605.001	63	32	16	32	5	4 x 2	4	13.0	no	0.22	TC..1102.R/L
01T.0606.001	63	32	16	32	6	4 x 2	4	13.0	no	0.23	TC..1103.R/L
01T.0610.001	63	32	16	32	10	3 x 2	3	13.0	no	0.30	TN..1606.R/L
01T.0804.041	80	40	22	40	4	5 x 2	5	13.0	no	0.37	TN..1302.R/L
01T.0805.001	80	40	22	40	5	5 x 2	5	18.0	no	0.39	TC..1102.R/L
01T.0806.001	80	40	22	40	6	5 x 2	5	18.0	no	0.41	TC..1103.R/L
01T.0808.001	80	40	22	40	8	4 x 2	4	18.0	no	0.47	TN..1604.R/L
01T.0810.001	80	40	22	40	10	4 x 2	4	18.0	no	0.53	TN..1606.R/L
01T.0812.001	80	40	22	40	12	4 x 2	4	18.0	no	0.57	TN..1606.R/L*
01T.1004.041	100	45	27	45	4	8 x 2	8	18.0	no	0.67	TN..1302.R/L
01T.1005.001	100	45	27	45	5	7 x 2	7	25.0	no	0.58	TC..1102.R/L
01T.1006.001	100	45	27	45	6	7 x 2	7	25.0	no	0.62	TC..1103.R/L
01T.1008.001	100	45	27	45	8	5 x 2	5	25.0	no	0.70	TN..1604.R/L
01T.1010.001	100	45	27	45	10	5 x 2	5	25.0	no	0.79	TN..1606.R/L
01T.1012.001	100	45	27	45	12	5 x 2	5	25.0	no	0.86	TN..1606.R/L*
01T.1204.042	125	58	32	50	4	9 x 2	9	32.0	no	0.67	TN..1302.R/L
01T.1205.001	125	58	32	50	5	9 x 2	9	32.0	no	1.04	TC..1102.R/L
01T.1206.001	125	58	32	50	6	9 x 2	9	32.0	no	1.09	TC..1103.R/L
01T.1208.001	125	58	32	50	8	6 x 2	6	32.0	no	1.22	TN..1604.R/L
01T.1210.001	125	58	32	50	10	6 x 2	6	32.0	no	1.36	TN..1606.R/L
01T.1212.001	125	58	32	50	12	6 x 2	6	32.0	no	1.49	TN..1606.R/L*
01T.1606.001	160	68	40	63	6	11 x 2	11	44.0	no	1.85	TC..1103.R/L
01T.1607.001	160	68	40	63	7	8 x 2	8	44.0	no	1.97	TN..16T3.R/L
01T.1608.001	160	68	40	63	8	8 x 2	8	44.0	no	2.08	TN..1604.R/L
01T.1609.001	160	68	40	63	9	8 x 2	8	44.0	no	2.20	TN..1604.R/L*
01T.1610.001	160	68	40	63	10	8 x 2	8	44.0	no	2.32	TN..1606.R/L
01T.1612.001	160	68	40	63	12	8 x 2	8	44.0	no	2.40	TN..1606.R/L*

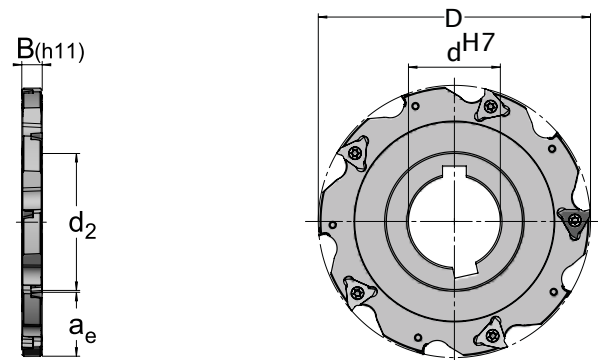
* Note that the screw length required varies depending on the insert used. Other dimensions on request.

SIDE MILLING CUTTERS

TN18



Extremely smooth cutting through left and right hand inserts – highly precise widths of cut from 4–12 mm
Complies with narrow radial and axial run out tolerances
3-side embedding of the T-style indexable insert

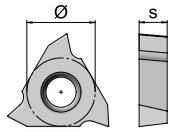


TN18

Article	D	d ₂	d ^{H7}	B _(h11)	zz	z _{eff}	a _e	lc	kg	INS
14T.0604.041	63	34	22	4	4 x 2	4	12.0	no	0.07	TN..1302.R/L
14T.0605.001	63	34	22	5	4 x 2	4	12.0	no	0.08	TC..1102.R/L
14T.0606.001	63	34	22	6	4 x 2	4	12.0	no	0.10	TC..1103.R/L
14T.0804.041	80	40	27	4	5 x 2	5	12.0	no	0.11	TN..1302.R/L
14T.0805.001	80	40	27	5	5 x 2	5	18.0	no	0.14	TC..1102.R/L
14T.0806.001	80	40	27	6	5 x 2	5	18.0	no	0.17	TC..1103.R/L
14T.0810.001	80	40	27	10	4 x 2	4	18.0	no	0.30	TN..1606.R/L
14T.1004.041	100	40	32	4	7 x 2	7	25.0	no	0.28	TN..1302.R/L
14T.1005.001	100	46	32	5	7 x 2	7	25.0	no	0.21	TC..1102.R/L
14T.1006.001	100	46	32	6	7 x 2	7	25.0	no	0.27	TC..1103.R/L
14T.1007.001	100	46	32	7	5 x 2	5	25.0	no	0.32	TN..16T3.R/L
14T.1008.001	100	46	32	8	5 x 2	5	25.0	no	0.37	TN..1604.R/L
14T.1009.001	100	46	32	9	5 x 2	5	25.0	no	0.42	TN..1604.R/L*
14T.1010.001	100	46	32	10	5 x 2	5	25.0	no	0.47	TN..1606.R/L
14T.1012.001	100	46	32	12	5 x 2	5	25.0	no	0.57	TN..1606.R/L*
14T.1204.041	125	46	32	4	9 x 2	9	37.0	no	0.28	TN..1302.R/L
14T.1205.001	125	46	32	5	9 x 2	9	37.0	no	0.36	TC..1102.R/L
14T.1206.001	125	46	32	6	9 x 2	9	37.0	no	0.44	TC..1103.R/L
14T.1207.001	125	46	32	7	6 x 2	6	37.0	no	0.52	TN..16T3.R/L
14T.1208.001	125	46	32	8	6 x 2	6	37.0	no	0.61	TN..1604.R/L
14T.1209.001	125	46	32	9	6 x 2	6	37.0	no	0.69	TN..1604.R/L*
14T.1210.001	125	46	32	10	6 x 2	6	37.0	no	0.78	TN..1606.R/L
14T.1212.001	125	46	32	12	6 x 2	6	37.0	no	0.92	TN..1606.R/L*
14T.1606.001	160	55	40	6	11 x 2	11	50.0	no	0.72	TC..1103.R/L
14T.1607.001	160	55	40	7	8 x 2	8	50.0	no	0.84	TN..16T3.R/L
14T.1608.001	160	55	40	8	8 x 2	8	50.0	no	0.97	TN..1604.R/L
14T.1609.001	160	55	40	9	8 x 2	8	50.0	no	1.12	TN..1604.R/L*
14T.1610.001	160	55	40	10	8 x 2	8	50.0	no	1.25	TN..1606.R/L
14T.1612.001	160	55	40	12	8 x 2	8	50.0	no	1.54	TN..1606.R/L*
14T.2007.001	200	55	40	7	10 x 2	10	70.0	no	1.40	TN..16T3.R/L
14T.2008.001	200	55	40	8	10 x 2	10	70.0	no	1.59	TN..1604.R/L
14T.2009.001	200	55	40	9	10 x 2	10	70.0	no	1.81	TN..1604.R/L*
14T.2010.001	200	55	40	10	10 x 2	10	70.0	no	1.98	TN..1606.R/L
14T.2012.001	200	55	40	12	10 x 2	10	70.0	no	2.43	TN..1606.R/L*
14T.2508.001	250	68	50	8	12 x 2	12	89.0	no	2.51	TN..1604.R/L
14T.2510.001	250	68	50	10	12 x 2	12	89.0	no	3.22	TN..1606.R/L
14T.2512.001	250	68	50	12	12 x 2	12	89.0	no	3.91	TN..1606.R/L*

* Note that the screw length required varies depending on the insert used. Other dimensions on request.

INS SHAPE TC | TN

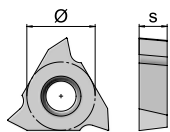


		TC TN								
AS	Ø			s						
3	11	13	16	02	03	T3	04	06		
	6.35	8	9.52	2.6	3.2	3.97	4.76	6.4		

Matching of machining parameters
with the AV material groups

				Steel						
Article		Designation		A22	A21	A20	A19	A18	A17	A16
TC..1102..	TC.1102.004.35 SKY77	TCAW 1102ZZ TL-28	h_{max}	0.12	0.10	0.10	0.08	0.08	0.06	0.05
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TC.1102.005.35 SKY77	TCAW 1102ZZ TR-28	h_{max}	0.12	0.10	0.10	0.08	0.08	0.06	0.05
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TC.1102.004.40 SKY77	TCAW 110206 TL-28	h_{max}	0.12	0.10	0.10	0.08	0.08	0.06	0.05
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TC.1102.005.40 SKY77	TCAW 110206 TR-28	h_{max}	0.12	0.10	0.10	0.08	0.08	0.06	0.05
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
TC..1103..	TC.1103.007.27 SKY77	TCAW 1103ZZ TL-28	h_{max}	0.12	0.10	0.10	0.08	0.08	0.06	0.05
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TC.1103.006.27 SKY77	TCAW 1103ZZ TR-28	h_{max}	0.12	0.10	0.10	0.08	0.08	0.06	0.05
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TC.1103.007.28 SKY77	TCAW 1103ZZ TL-28	h_{max}	0.12	0.10	0.10	0.08	0.08	0.06	0.05
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TC.1103.006.28 SKY77	TCAW 1103ZZ TR-28	h_{max}	0.12	0.10	0.10	0.08	0.08	0.06	0.05
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
TN..1302..	TN.1302.140.06 SKY77	TNAX 130203 SL-28	h_{max}	0.14	0.12	0.12	0.10	0.10	0.08	0.06
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TN.1302.141.06 SKY77	TNAX 130203 SR-28	h_{max}	0.14	0.12	0.12	0.10	0.10	0.08	0.06
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
TN..16T3..	TN.16T3.004.14 SKY77	TNAW 16T3ZZ TL-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TN.16T3.003.14 SKY77	TNAW 16T3ZZ TR-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TN.16T3.003.25 SKY77	TNAW 16T308 SR-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TN.16T3.004.25 SKY77	TNAW 16T308 SL-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110

INS SHAPE TC | TN

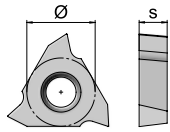


		TC TN							
AS	Ø			s					
3	11	13	16	02	03	T3	04	06	
	6.35	8	9.52	2.6	3.2	3.97	4.76	6.4	

Matching of machining parameters
with the AV material groups

				Steel						
Article		Designation		A22	A21	A20	A19	A18	A17	A16
TN..1604..	TN.1604.004.41 SKY77	TNAW 1604ZZ TR-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TN.1604.003.41 SKY77	TNAW 1604ZZ TL-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TN.1604.004.46 SKY77	TNAW 160408 SL-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TN.1604.003.46 SKY77	TNAW 160408 SR-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
TN..1606..	TN.1606.004.49 SKY77	TNAW 1606ZZ TL-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TN.1606.003.49 SKY77	TNAW 1606ZZ TR-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TN.1606.004.60 SKY77	TNAW 160608 SL-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110
	TN.1606.003.60 SKY77	TNAW 160608 SR-28	h_{max}	0.16	0.16	0.16	0.14	0.12	0.10	0.08
			v_c	280-320	240-280	210-240	180-210	140-180	110-140	80-110

INS SHAPE TC | TN

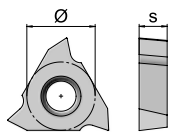


		TC TN							
AS	Ø			s					
3	11	13	16	02	03	T3	04	06	
	6.35	8	9.52	2.6	3.2	3.97	4.76	6.4	

Matching of machining parameters
with the AV material groups

				Cast iron					
Article		Designation		D21	D20	D19	D18	D17	D16
TC..1102..	TC.1102.004.35 SKY77	TCAW 1102ZZ TL-28	h_{max}	0.12	0.12	0.10	0.10	0.08	0.06
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
	TC.1102.005.35 SKY77	TCAW 1102ZZ TR-28	h_{max}	0.12	0.12	0.10	0.10	0.08	0.06
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
	TC.1102.004.40 SKY77	TCAW 110206 TL-28	h_{max}	0.12	0.12	0.10	0.10	0.08	0.06
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
	TC.1102.005.40 SKY77	TCAW 110206 TR-28	h_{max}	0.12	0.12	0.10	0.10	0.08	0.06
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
TC..1103..	TC.1103.007.27 SKY77	TCAW 1103ZZ TL-28	h_{max}	0.12	0.12	0.10	0.10	0.08	0.06
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
	TC.1103.006.27 SKY77	TCAW 1103ZZ TR-28	h_{max}	0.12	0.12	0.10	0.10	0.08	0.06
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
	TC.1103.007.28 SKY77	TCAW 1103ZZ TL-28	h_{max}	0.12	0.12	0.10	0.10	0.08	0.06
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
	TC.1103.006.28 SKY77	TCAW 1103ZZ TR-28	h_{max}	0.12	0.12	0.10	0.10	0.08	0.06
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
TN..1302..	TN.1302.140.06 SKY77	TNAX 130203 SL-28	h_{max}	0.14	0.14	0.12	0.12	0.10	0.08
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
	TN.1302.141.06 SKY77	TNAX 130203 SR-28	h_{max}	0.14	0.14	0.12	0.12	0.10	0.08
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
TN..16T3..	TN.16T3.004.14 SKY77	TNAW 16T3ZZ TL-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
	TN.16T3.003.14 SKY77	TNAW 16T3ZZ TR-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
	TN.16T3.003.25 SKY77	TNAW 16T308 SR-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08
			v_c	280-320	260-290	210-260	190-240	180-210	140-180
	TN.16T3.004.25 SKY77	TNAW 16T308 SL-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08
			v_c	280-320	260-290	210-260	190-240	180-210	140-180

INS SHAPE TC | TN

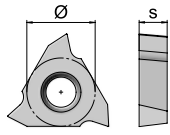


		TC TN							
AS	Ø			s					
3	11	13	16	02	03	T3	04	06	
	6.35	8	9.52	2.6	3.2	3.97	4.76	6.4	

Matching of machining parameters
with the AV material groups

				Cast iron						
Article	Designation			D21	D20	D19	D18	D17	D16	
TN..1604..	TN.1604.004.41 SKY77	TNAW 1604ZZ TR-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	280-320	260-290	210-260	190-240	180-210	140-180	
	TN.1604.004.41 NERO26	TNAW 1604ZZ TR-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	340-380	280-340	240-280	210-240	180-210	140-180	
TN..1604..	TN.1604.003.41 SKY77	TNAW 1604ZZ TL-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	280-320	260-290	210-260	190-240	180-210	140-180	
	TN.1604.003.41 NERO26	TNAW 1604ZZ TL-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	340-380	280-340	240-280	210-240	180-210	140-180	
TN..1604..	TN.1604.004.46 SKY77	TNAW 160408 SL-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	280-320	260-290	210-260	190-240	180-210	140-180	
	TN.1604.004.46 NERO26	TNAW 160408 SL-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	340-380	280-340	240-280	210-240	180-210	140-180	
TN..1604..	TN.1604.003.46 SKY77	TNAW 160408 SR-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	280-320	260-290	210-260	190-240	180-210	140-180	
	TN.1604.003.46 NERO26	TNAW 160408 SR-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	340-380	280-340	240-280	210-240	180-210	140-180	
TN..1606..	TN.1606.004.49 SKY77	TNAW 1606ZZ TL-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	280-320	260-290	210-260	190-240	180-210	140-180	
	TN.1606.004.49 NERO26	TNAW 1606ZZ TL-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	340-380	280-340	240-280	210-240	180-210	140-180	
	TN..1606..	TN.1606.003.49 SKY77	TNAW 1606ZZ TR-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08
				v_c	280-320	260-290	210-260	190-240	180-210	140-180
		TN.1606.003.49 NERO26	TNAW 1606ZZ TR-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08
				v_c	340-380	280-340	240-280	210-240	180-210	140-180
	TN..1606..	TN.1606.004.60 SKY77	TNAW 160608 SL-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08
				v_c	280-320	260-290	210-260	190-240	180-210	140-180
		TN.1606.004.60 NERO26	TNAW 160608 SL-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08
				v_c	340-380	280-340	240-280	210-240	180-210	140-180
TN..1606..	TN.1606.003.60 SKY77	TNAW 160608 SR-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	280-320	260-290	210-260	190-240	180-210	140-180	
	TN.1606.003.60 NERO26	TNAW 160608 SR-28	h_{max}	0.18	0.18	0.15	0.13	0.10	0.08	
			v_c	340-380	280-340	240-280	210-240	180-210	140-180	

INS SHAPE TC | TN

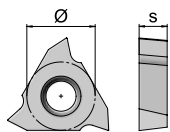


		TC TN								
AS	Ø			s						
3	11	13	16	02	03	T3	04	06		
	6.35	8	9.52	2.6	3.2	3.97	4.76	6.4		

Matching of machining parameters
with the AV material groups

Article	Designation		Stainless steels				NF metals			
			C12	C11	C10	C09	E82	E81	E80	
TC..1102..	TC.1102.004.35 SKY77	TCAW 1102ZZ TL-28	h_{max}	0.10	0.08	0.07	0.05	0.15	0.12	0.10
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TC.1102.005.35 SKY77	TCAW 1102ZZ TR-28	h_{max}	0.10	0.08	0.07	0.05	0.15	0.12	0.10
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TC.1102.004.40 SKY77	TCAW 110206 TL-28	h_{max}	0.10	0.08	0.07	0.05	0.15	0.12	0.10
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TC.1102.005.40 SKY77	TCAW 110206 TR-28	h_{max}	0.10	0.08	0.07	0.05	0.15	0.12	0.10
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
TC..1103..	TC.1103.007.27 SKY77	TCAW 1103ZZ TL-28	h_{max}	0.10	0.08	0.07	0.05	0.15	0.12	0.10
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TC.1103.006.27 SKY77	TCAW 1103ZZ TR-28	h_{max}	0.10	0.08	0.07	0.05	0.15	0.12	0.10
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TC.1103.007.28 SKY77	TCAW 1103ZZ TL-28	h_{max}	0.10	0.08	0.07	0.05	0.15	0.12	0.10
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TC.1103.006.28 SKY77	TCAW 1103ZZ TR-28	h_{max}	0.10	0.08	0.07	0.05	0.15	0.12	0.10
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
TN..1302..	TN.1302.140.06 SKY77	TNAX 130203 SL-28	h_{max}	0.10	0.08	0.07	0.05	0.17	0.15	0.10
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TN.1302.141.06 SKY77	TNAX 130203 SR-28	h_{max}	0.10	0.08	0.07	0.05	0.17	0.15	0.10
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
TN..16T3..	TN.16T3.004.14 SKY77	TNAW 16T3ZZ TL-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TN.16T3.003.14 SKY77	TNAW 16T3ZZ TR-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TN.16T3.003.25 SKY77	TNAW 16T308 SR-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TN.16T3.004.25 SKY77	TNAW 16T308 SL-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450

INS SHAPE TC | TN



		TC TN								
AS	Ø			s						
3	11	13	16	02	03	T3	04	06		
	6.35	8	9.52	2.6	3.2	3.97	4.76	6.4		

Matching of machining parameters
with the AV material groups

Article	Designation		Stainless steels				NF metals			
			C12	C11	C10	C09	E82	E81	E80	
TN..1604..	TN.1604.004.41 SKY77	TNAW 1604ZZ TR-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TN.1604.003.41 SKY77	TNAW 1604ZZ TL-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TN.1604.004.46 SKY77	TNAW 160408 SL-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TN.1604.003.46 SKY77	TNAW 160408 SR-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
TN..1606..	TN.1606.004.49 SKY77	TNAW 1606ZZ TL-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TN.1606.003.49 SKY77	TNAW 1606ZZ TR-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TN.1606.004.60 SKY77	TNAW 160608 SL-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450
	TN.1606.003.60 SKY77	TNAW 160608 SR-28	h_{max}	0.12	0.10	0.08	0.07	0.20	0.18	0.15
			v_c	120-200	140-150	100-140	60-100	650-1000	450-650	280-450

INS

TC..1102...	08B.2538.7991	TX208
TC..1103...	08B.2552.7991	TX208
TN..11T3...	08B.0354.7991	TX208
TN..1302...	08B.0334.001	TX208
TN..1604...	08B.0364.7991	TX208
TN..1604...*	08B.0375.7991	TX208
TN..1606...	08B.3585.7991	TX215
TN..1606...*	08B.3509.7991	TX215

* Note that the screw length required varies depending on the insert used