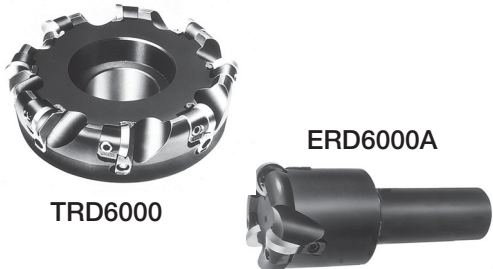


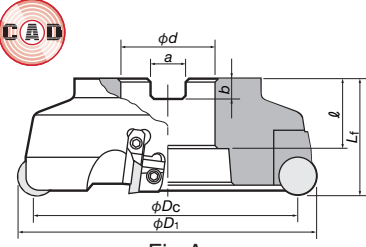


For high-feed milling of steels, cast irons and hard materials



**TRD6000**

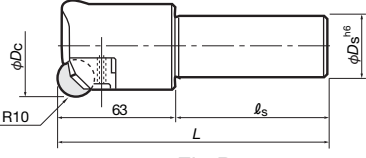
**ERD6000A**



**Fig.A**

Maximum depth of cut : 10mm

|            |     |          |              |
|------------|-----|----------|--------------|
| Rake angle | TRD | A.R. +8° | R.R. -3°     |
|            | ERD | A.R. +8° | R.R. -2°~+3° |



**Fig.B**

Right hand (R) shown.

## TRD6000 (Fig.A)

| Cat. No.   | Stock |   | No. of inserts | Dimensions (mm) |            |          |     |       |     | Weight (kg) | Mounting details |          |
|------------|-------|---|----------------|-----------------|------------|----------|-----|-------|-----|-------------|------------------|----------|
|            | R     | L |                | $\phi D_c$      | $\phi D_1$ | $\phi d$ | $l$ | $L_f$ | $b$ |             |                  | $a$      |
| TRD6003R/L | ●     |   | 4              | 60              | 80         | 25.4     | 26  | 63    | 6   | 9.5         | 1.2              | 9-144(A) |
| TRD6004R/L | ●     |   | 5              | 80              | 100        | 31.75    | 32  |       | 8   | 12.7        | 2.1              |          |
| TRD6005R/L | ●     |   | 6              | 105             | 125        | 38.1     | 38  |       | 10  | 15.9        | 3.2              | 9-144(B) |
| TRD6006R/L | ●     |   | 8              | 140             | 160        | 50.8     |     |       | 11  | 19          | 5.4              |          |
| TRD6008R/L | ●     |   | 10             | 180             | 200        | 47.625   |     |       | 14  | 25.4        | 8.6              |          |

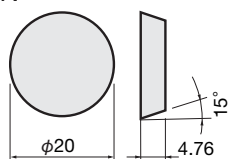
## ERD6000A (Fig.B, shank-type spec)

| Cat. No.  | Stock | No. of inserts | Dimensions (mm) |            |     |       |
|-----------|-------|----------------|-----------------|------------|-----|-------|
|           |       |                | $\phi D_1$      | $\phi D_s$ | $L$ | $l_s$ |
| ERD6050RA | ●     | 3              | 50              | 32         | 143 | 80    |
| ERD6063RA | ●     |                | 63              |            |     |       |

Note: Plunging up to 4 mm depth is possible.

## Inserts

RD□N2004□N



| Cat. No (Metric system) | Accuracy | Honing  | Grade  |          |      |
|-------------------------|----------|---------|--------|----------|------|
|                         |          |         | Coated | Uncoated |      |
|                         |          |         | AH120  | UX30     | TH10 |
| RDCN2004TN              | C        | With    |        | ●        |      |
| RDCN2004FN              |          | Without |        |          |      |
| RDCA2004TN              |          | With    |        | ●        |      |
| RDCA2004FN              |          | Without |        |          |      |
| RDKN2004TN              | K        | With    | ●      | ●        |      |
| RDKN2004FN              |          | Without |        |          | ●    |

The above figure shows RD□N-type insert.

• RDCA type inserts have a hole.

Note: The inserts can be used for the former PS series.

## Replacement parts

| No. | Parts                | Part Cat. No. |                       |                     |
|-----|----------------------|---------------|-----------------------|---------------------|
|     |                      | TRD6003R/L    | TRD6004R/L~TRD6008R/L | ERD6050RA~ERD6063RA |
| ①   | Locator              | LR603R/L      | LR603R/L              | LR602R/L            |
| ②   | Insert locking wedge | WR603R/L      | WR603R/L              | WR602R/L            |
| ③   | Wedge fixing screw   | FDS-8S        | FDS-8                 | FDS-6Z              |
| ④   | Locator fixing screw | CM4×0.7×20    | CM4×0.7×20            | SHCM4-16            |
| —   | T-handle wrench      | TP-4          | TP-4                  | TP-3A               |

● : Stocked in Japan.

## Standard cutting conditions

| Work materials                        | Insert grades | Cutting speed $v_c$ (m/min) | Depth of cut : 0.4-1            | Depth of cut : 1.5-3            | Depth of cut : 4-6              |
|---------------------------------------|---------------|-----------------------------|---------------------------------|---------------------------------|---------------------------------|
|                                       |               |                             | Feed per tooth $f_z$ (mm/tooth) | Feed per tooth $f_z$ (mm/tooth) | Feed per tooth $f_z$ (mm/tooth) |
| Carbon steels, alloy steels (< 300HB) | AH120         | 150~250                     | 0.3~0.5                         | 0.2~0.3                         | 0.1~0.2                         |
|                                       | UX30          | 80~150                      | 0.3~0.6                         |                                 |                                 |
| Die steels (< 30HRC)                  | AH120         | 100~150                     | 0.2~0.4                         | 0.15~0.3                        |                                 |
|                                       | UX30          | 80~130                      | 0.25~0.5                        |                                 |                                 |
| Hardened steels (40~55HRC)            | AH120         | 20~60                       | 0.1~0.2                         | 0.05~0.2                        | —                               |
|                                       | UX30          |                             |                                 |                                 |                                 |
| Gray cast irons, ductile cast irons   | AH120         | 100~150                     | 0.3~0.6                         | 0.2~0.4                         | 0.1~0.25                        |
|                                       | TH10          | 80~130                      |                                 |                                 |                                 |

Note: Feed rate should be inversely proportional to depth of cut and selected depending on machine rigidity.