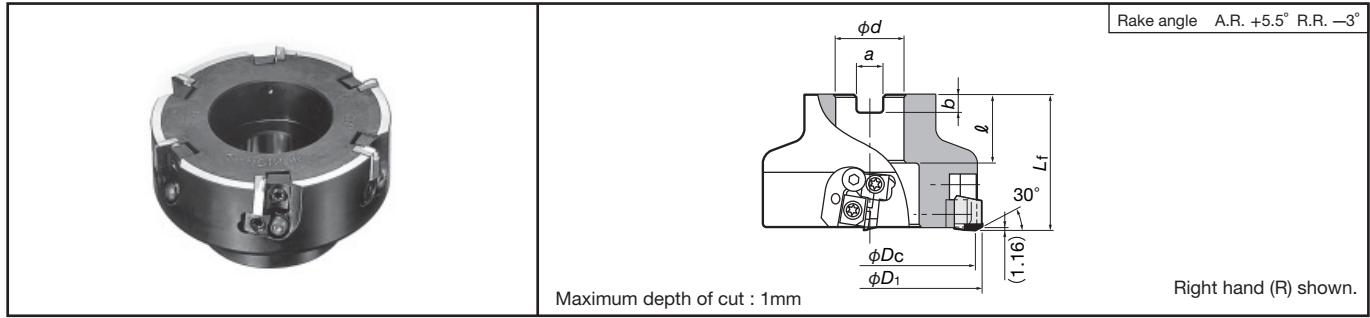


QPP15

Diameter $\phi 80\sim 400\text{mm}$ 60°
1mm



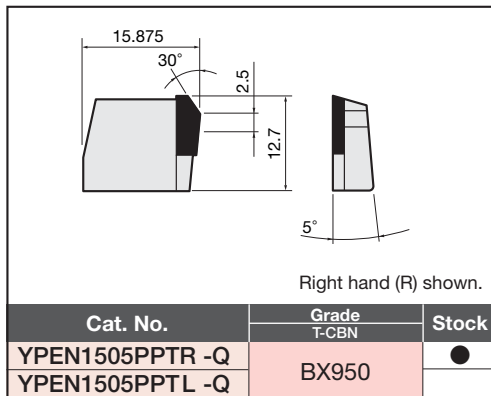
For high-speed finishing of cast irons



Cat. No.	Stock		No. of inserts	Dimensions (mm)						Weight (kg)	Mounting details	
	R	L		ϕD_c	ϕD_1	ϕd	l	L_f	b			a
QPP15080R/L			4	80	84	25.4	26	50	6	9.5	1.1	9-144(A)
QPP15100R/L			6	100	104	31.75	32	63	8	12.7	2.1	
QPP15125R/L			6	125	129	38.1	47.625		10	15.9	3.7	9-144(B)
QPP15160R/L			8	160	164	50.8			11	19	5.3	
QPP15200R/L			10	200	204	47.625	38	80	14	25.4	8.3	9-144(C)
QPP15250R/L			12	250	254						13.5	
QPP15315R/L			14	315	319						22.6	
QPP15355R/L			16	355	359						33.4	
QPP15400R/L			18	400	404						43.3	9-144(D)

Note: QPP15 type TAC mills can be made to having quick-change mounting specification shown on page 9-135.

Inserts



Packed : 1pcs.

Replacement parts

No.	Parts	Part Cat. No.
①	Insert locking wedge	FW304R/L-D
②	Locator adjusting wedge	FW325R/L-D
③	Screw for preventing wedge from flying out	BHM615-GT
④	Wedge fixing screw ($\phi D=80$)	FDS-8ST-18
	Wedge fixing screw (for $\phi D > 80$)	FDS-8ST
⑤	Adjusting wedge fixing screw	FDS-8ST-18
—	Wrench	T-27T

Right hand (R) shown.

Standard cutting conditions

Work materials	Insert grades	Cutting speed v_c (m/min)	Feed per rev. f_z (mm/rev)	Depth of cut a_p (mm)
Gray cast irons (JIS FC250~350)	BX950	350~2000	0.1~0.25	0.1~1.0

Note : Dry cutting is recommended.

Features of QPP15

- Highly efficient and accurate machining capability**
Performs well in high-speed machining and produces a fine surface finish on machining centers and special purpose machines.
Attainable accuracies: $Rz_{JIS} \leq 3.0 \mu\text{m}$, $Rz(R_{max}) \leq 6.0 \mu\text{m}$
- Provided with adjusting mechanism for all the inserts**
The axial runout of the cutter is micro adjustable with the adjusting wedge provided for each insert.
Attainable axial runout: $< 5 \mu\text{m}$
- Superior resistance to centrifugal force**
The inserts are firmly fixed even when using at speeds as high as v_c 2000 m/min and do not exhibit any looseness.

- No. of revolutions (min^{-1}) = Cutting speed $\times 1000 \div 3.14 \div$ Cutter diameter
- Table feed (mm/min) = No. of revolutions \times Feed per tooth \times No. of inserts

● : Stocked in Japan.