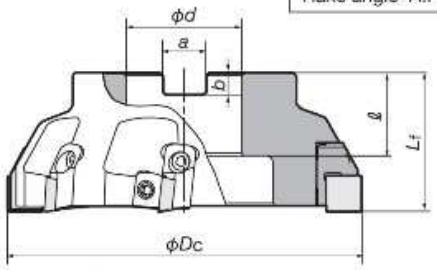
TPP16I

Diameter ϕ80~315mm | 90° | 12mm

P Steel | K Cast Iron | M Stainless

Face Milling | Face Milling | Shoulder Milling

For large depth, square shoulder milling of general steels, cast irons and stainless steels

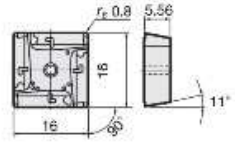


Maximum depth of cut : 12mm

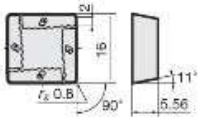
Cat. No.	Stock	No. of inserts	Dimensions (mm)						Weight (kg)	Mounting details
			øDc	ød	ℓ	Lf	b	a		
TPP16080RI	●	4	80	25.4	26	50	6	9.5	1.0	9-144Ⓐ
TPP16100RI	●	5	100	31.75	32	63	8	12.7	1.8	
TPP16125RI	●	6	125	38.1	38		10	15.9	2.8	9-144Ⓑ
TPP16160RI	●	8	160	50.8			11	19	4.6	
TPP16200RI	●	10	200	47.625			14	25.4	6.9	9-144Ⓒ
TPP16250RI	●	12	250						13.0	
TPP16315RI	●	14	315						22.2	9-144Ⓓ

Inserts

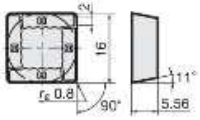
SPMR1605PPPR-ML



SPMR1605PPTR-MJ

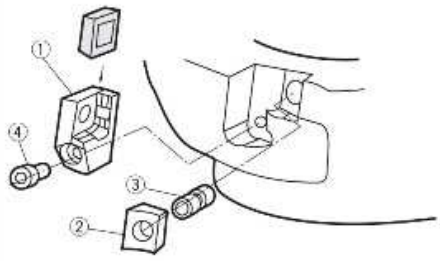


SPMR1605PPTR-MH



Cat. No.	Accuracy	Honing	Grades					
			Coated					Uncoated
			T3130	T3030	GH330	GH340	T1015	UX30
SPMR1605PPPR-ML	M	With			●	●		
SPMR1605PPTR-MJ			●	●	●		●	●
SPMR1605PPTR-MH			●	●	●		●	●

Replacement parts



No.	Parts	Part Cat. No
①	Locator	LPP16R
②	Insert locking wedge	WPP16R
③	Wedge fixing screw	FDS-8S (FDS-8SS)
④	Locator fixing screw	CM5×0.8×12
—	T-handle wrench	TP-4

Notes : Part cat. No. in ( ) is used for TPP16080R and TPP16100R.

● : Stocked in Japan.

Standard cutting conditions

●For MJ-chipbreaker inserts (General purpose)

Work materials	Insert grades	Roughing (Depth of cut : > 1.5mm)		Finishing (Depth of cut : 0.3~0.7 mm)	
		Cutting speed v_c(m/min)	Feed f_z(mm/tooth)	Cutting speed v_c(m/min)	Feed f_z(mm/tooth)
Mild steels Unhardened steels (<180 HB)	GH330	100~230	0.1~0.25	130~250	0.1~0.3
	T3130·T3030	130~300	0.1~0.28	180~300	
	UX30	100~180	0.1~0.25	130~200	
Carbon steels Alloy steels (<300 HB)	GH330	100~180	0.1~0.2	130~200	0.1~0.28
	T3130·T3030	130~280	0.1~0.25	180~280	
	UX30	80~130	0.1~0.2	100~150	
Die steels (<30 HRC)	GH330	100~150	0.1~0.18	100~150	0.1~0.2
	UX30	80~130		80~130	
Cast irons Ductile cast irons	T1015	100~200	0.1~0.2	100~200	0.1~0.25
	UX30	80~130	0.1~0.2	80~130	
Stainless steels (<250 HB)	GH330	150~200	0.15~0.23	200~250	0.15~0.25

●For ML-chipbreaker inserts (Sharpness-priority)

Work materials	Insert grades	Roughing (Depth of cut : > 1.5mm)		Finishing (Depth of cut : 0.3~0.7 mm)	
		Cutting speed v_c(m/min)	Feed f_z(mm/tooth)	Cutting speed v_c(m/min)	Feed f_z(mm/tooth)
Mild steels Unhardened steels (<180 HB)	GH340	100~200	0.05~0.17	100~230	0.05~0.2
	GH330	130~230		150~250	
	AH330	130~370		150~400	
Stainless steels (<250 HB)	GH340	100~170	0.05~0.12	100~200	0.05~0.15
	GH330	150~200		200~250	
Carbon steels Alloy steels (<250 HB)	GH340	100~170	0.05~0.12	100~200	0.05~0.15
	GH330	100~180		150~200	

●For MH-chipbreaker inserts (Toughness-priority)

Work materials	Insert grades	Roughing (Depth of cut : > 1.5mm)		Finishing (Depth of cut : 0.3~0.7 mm)	
		Cutting speed v_c(m/min)	Feed f_z(mm/tooth)	Cutting speed v_c(m/min)	Feed f_z(mm/tooth)
Mild steels Unhardened steels (<180 HB)	GH330	100~230	0.15~0.3	130~250	0.15~0.35
	T3130·T3030	130~300	0.15~0.33	180~300	0.15~0.38
	UX30	100~180	0.15~0.3	130~200	0.15~0.35
Carbon steels Alloy steels (<300 HB)	GH330	100~180	0.15~0.24	130~200	0.15~0.35
	T3130·T3030	130~280	0.15~0.3	180~280	
	UX30	80~130	0.15~0.24	100~150	
Die steels (<30 HRC)	GH330	100~150	0.15~0.22	100~150	0.15~0.28
	UX30	80~130		80~130	
Cast irons Ductile cast irons	T1015	100~200	0.15~0.24	100~200	0.15~0.3
	UX30	80~130	0.15~0.24	80~130	

Notes:
- As a rule, dry cutting (or air-blowing) is generally recommended.
- If a cutting fluid is used, the cutting speed should be set to the lower side of the values shown in the above table.
- When being used in square shoulder milling, climb milling is recommended.
- In square shoulder milling of stainless steel, when chips tend to be recut during cutting, change to up-milling mode.
- When wet machining mild steels, carbon steels and alloy steels, use T3130 at lower cutting conditions.