
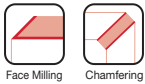


# TAC Mills for large depth of cut

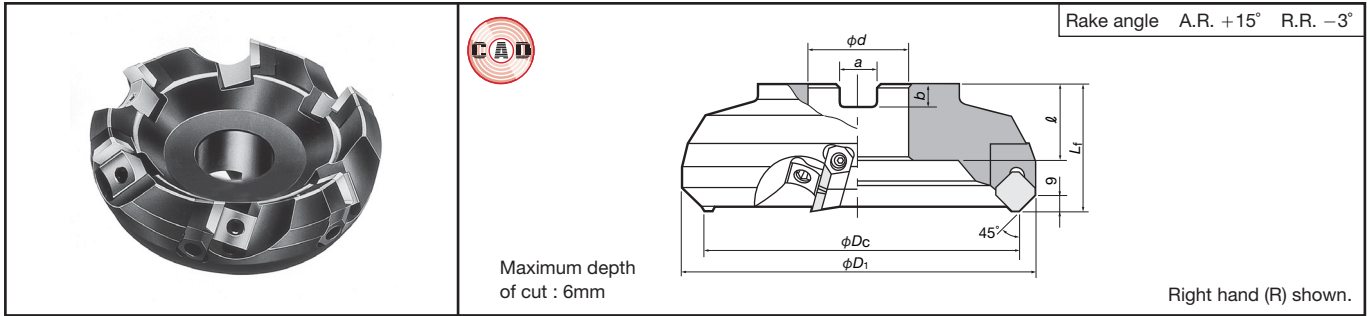
# TMD5400I

Diameter  $\phi 100\sim 315\text{mm}$  

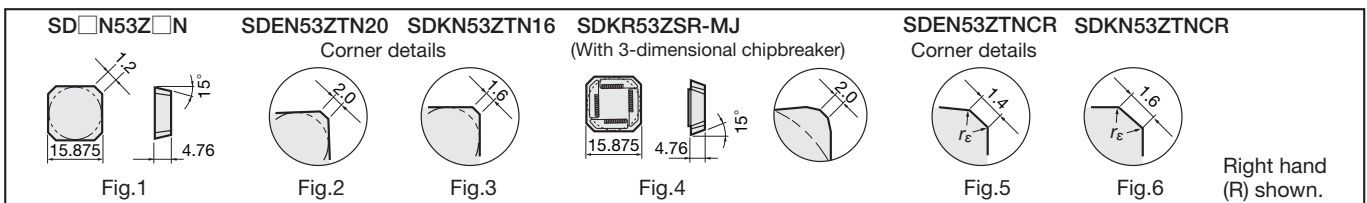


For general purpose, large depth milling of general steels, stainless steels, cast irons, and non-ferrous metals



Cat. No.	Stock		No. of inserts	Dimensions (mm)						Weight (kg)	Mounting details	
	R	L		$\phi D_c$	$\phi D_1$	$\phi d$	$l$	$L_f$	$b$			$a$
TMD5404R/LI	●		4	100	118	31.75	32	63	8	12.7	2.5	9-144 <sup>Ⓑ</sup>
TMD5405R/LI	●		6	125	142	38.1	38		10	15.9	3.7	
TMD5406R/LI	●			160	176	50.8			11	19	5.8	
TMD5408R/LI	●		8	200	216	47.625			14	25.4	9.0	9-144 <sup>Ⓒ</sup>
TMD5410R/LI	●		10	250	265						16.3	
TMD5412R/LI	●		12	315	330						25.2	9-144 <sup>Ⓓ</sup>

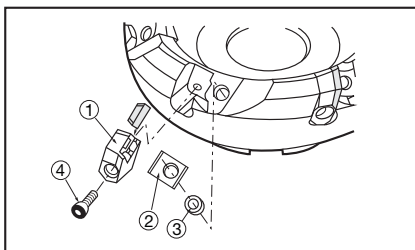
## Inserts



Cat. No. (Inch System)	ISO Cat. No. (Metric System)	Accuracy	Honing	Coated						Cermet		Uncoated			Figure
				T3130	T3030	T1015	AH120	AH140	GH330	NS740	N308	TH10	UX30	TX25	
SDCN53ZTN	SDCN1504AETN	C								●	●			●	Fig.1
SDEN53ZTN	SDEN1504AETN	E	With			●			●	●			●		Fig.5
SDEN53ZTNCR	SDEN1504AETNCR		Without	●	●										Fig.2
SDEN53ZTN20	SDEN1504AETN-20	K	With			●	●	●	●	●	▲		●	●	Fig.1
SDEN53ZFN	SDEN1504AEFN		Without	●	●										Fig.6
SDKN53ZTN	SDKN1504AETN		With			●	●	●	●				●	●	Fig.3
SDKN53ZTNCR	SDKN1504AETNCR		Without	●	●										Fig.1
SDKN53ZFN	SDKN1504AEFN		With	●	●										Fig.4

Notes: Inserts can be used for former PS-series TAC mills.

## Replacement parts



No.	Part	Part Cat. No.
①	Locator	LD540R/L
②	Insert locking wedge	WF500R/L
③	Wedge fixing screw	FDS-8S
④	Locator fixing screw	CM4 × 0.7 × 20
—	T-handle wrench	TP-4

Notes: • Dry cutting is recommended for all materials except for aluminum alloys.  
• When wet machining mild steels, carbon steels and alloy steels, use T3130 at lower cutting conditions.

## Standard cutting conditions

Work materials	Insert	Roughing (Depth of cut : 1.5~6mm)		Finishing (Depth of cut : 0.3~0.7mm)	
		Cutting speed $V_c$ (m/min)	Feed per tooth $f_z$ (mm/tooth)	Cutting speed $V_c$ (m/min)	Feed per tooth $f_z$ (mm/tooth)
Mildsteels Unhardened steels ( $< 180\text{HB}$ )	NS740·N308	150~250	0.1~0.25	150~250	0.1~0.3
	AH120·GH330			150~250	
	T3130·T3030	150~300	0.1~0.35	180~300	0.1~0.35
	UX30	100~180		130~200	
Carbon steels Alloy steels ( $< 300\text{HB}$ )	T3130·T3030	150~280	0.1~0.35	180~280	0.1~0.35
	NS740·N308	100~180	0.1~0.25	150~200	0.1~0.3
	AH120·GH330	100~200	0.1~0.3		0.1~0.35
	UX30	80~130		100~150	
Stainless steels ( $< 250\text{HB}$ )	AH140	80~180	0.15~0.3	100~200	0.15~0.33
	AH120·GH330	150~230	0.15~0.3	200~250	0.15~0.3
	UX30	150~180		180~200	
Die steels ( $< 30\text{HRC}$ )	T3130·T3030·AH120	100~150	0.1~0.2	100~150	0.1~0.2
Cast irons Ductile cast irons	UX30	80~130		80~130	
	T1015	100~200	0.1~0.3	100~200	0.1~0.3
Aluminum alloys (Si : $< 12\%$ )	TH10	200~1000	0.05~0.3	350~1000	0.1~0.3
	UX30	200~500	0.1~0.2	200~500	0.1~0.25

● : Stocked in Japan.  
▲ : Shortly unavailable