

T-SLOT MILLING



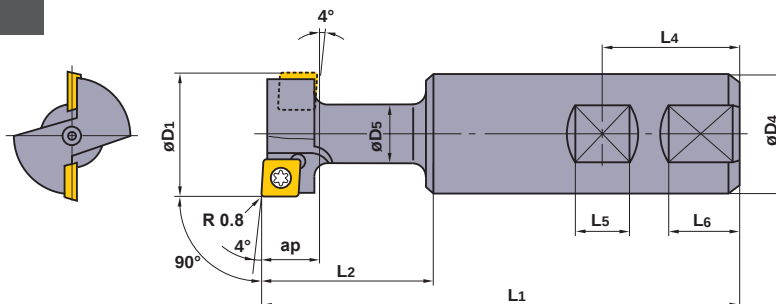
Roughing



TSMP



- T-groove order number 14, 18 and 22 are available.
- Shoulder milling and inversed spot facing are also possible.



Right hand tool holder only.

Order Number	T Slot Nomenclature	Stock R	Number of Teeth	Dimensions (mm)									★	① ②	Insert
				D1	L1	D4	D5	L2	L4	L5	L6	ap			
TSMR252S25	14	●	2	25	112	25	12.5	33.2	32	12	17	11	TS3	①TKY08D	MPMW070308
322S32	18	●	2	32	120	32	16	41.2	36	14	19	14	TS4	②TKY15R	MPMW090308
402S32	22	●	2	40	130	32	20	51.2	36	14	19	18	TS5	②TKY25R	MPMW120408

★ Clamp Torque (N • m) : TS3=1.0, TS4=3.5, TS5=7.5

INSERTS

Shape	Order Number	Class	Carbide UTi20T	Dimensions (mm)			Geometry
				D1	S1	Re	
	MPMW070308	M	●	7.94	3.18	0.8	
	090308	M	●	9.525	3.18	0.8	
	120408	M	●	12.7	4.76	0.8	

RECOMMENDED CUTTING CONDITIONS

Work Material	Hardness	Grade	Cutting Speed (m/min)	Feed per Revolution (mm/rev)
P Carbon Steel Alloy Steel	180—280HB	UTi20T	130 (100—160)	0.15 (0.1—0.2)
	280—350HB	UTi20T	80 (60—100)	0.1 (0.05—0.15)
K Cast Iron	Tensile Strength ≤450MPa	UTi20T	100 (80—120)	0.15 (0.1—0.2)

● Revolution (min⁻¹)=(1000×Cutting Speed)÷(3.14×φD1)

CAUTION FOR USE

- When T slot machining steel, the workpiece must be pre-machined as shown in the drawing, so as to ensure smooth chip evacuation.
- Slots to be machined must be free from chips for smooth machining.

