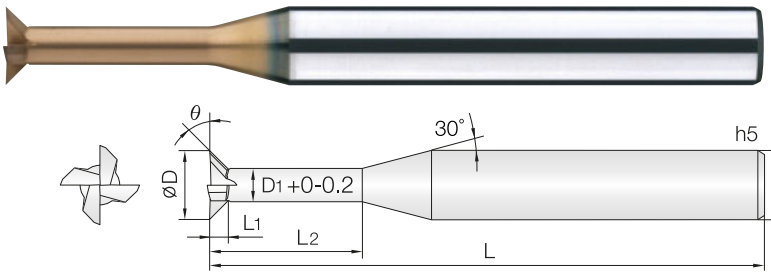
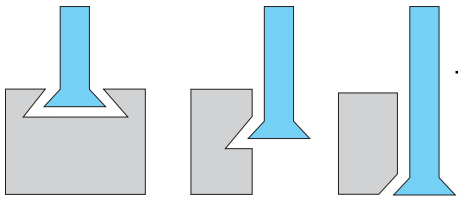
4&6TAC

4&6 Flutes T-Angular Cutter



Available Cutting Shape



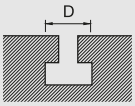
4 | 6 | WC | JCRO Coating | D +0 −0.02 Ø1.5~ Ø5 | D −0.01 −0.03 Ø6~ Ø12 | L1 ±0.03 Ø1.5~ Ø5 | L1 ±0.05 Ø6 ~ 12 | 0° Helix Angle

D Size	D Tolerance
Ø1.5 ~ 5	+0 ~ −0.02 mm
Ø6 ~ 12	−0.01 ~ −0.03 mm

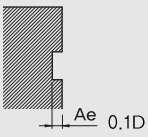
4TES /4TRS /3TRC /4 &6TDA /4 &6TAC

■ Use the same RPM and reduce the feed by 30% for 3TRC.

Slotting

Material	Mild Steels / Carbon Steels		Alloy Steels		Prehardened Steels	
Outside Diameter	RPM	FEED	RPM	FEED	RPM	FEED
Ø1.5	3,050	117	1,890	77	1,530	59
Ø2	2,850	110	1,790	72	1,440	55
Ø2.5	2,680	99	1,700	66	1,350	50
Ø3	2,500	92	1,610	60	1,260	45
Ø4	2,150	81	1,430	54	1,080	41
Ø5	1,800	70	1,200	47	900	35
Ø6	1,430	59	950	39	720	30
Ø8	1,070	44	720	30	540	22
Ø10	860	35	580	23	430	17
Ø12	720	30	480	20	360	14
Depth of Cut						

Side Cutting

Material	Mild Steels / Carbon Steels		Alloy Steels		Prehardened Steels	
Outside Diameter	RPM	FEED	RPM	FEED	RPM	FEED
Ø1.5	3,050	162	1,890	94	1,530	76
Ø2	2,850	149	1,790	88	1,440	70
Ø2.5	2,680	135	1,700	83	1,350	65
Ø3	2,500	122	1,610	79	1,260	59
Ø4	2,150	108	1,430	72	1,080	54
Ø5	1,800	95	1,200	65	900	49
Ø6	1,430	86	950	58	720	43
Ø8	1,070	64	720	43	540	32
Ø10	860	52	580	34	430	26
Ø12	720	43	480	29	360	22
Depth of Cut						

- When entering the tool to the workpiece, enter the tool from outside to the workpiece.
- The parameters on the table is based on 4 flutes. For using 3TRC , use the same RPM and reduce the feed by 30%.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- If the table over the maximum RPM and feed of your machine, or found red heat on the material, adjust RPM and feed in the same proportion.
- If a vibration is occurred while side milling, reduce the feed.