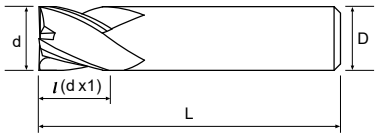
# General for Turning & Machine Center - 4 Flutes




Cutting Condition
**P147**

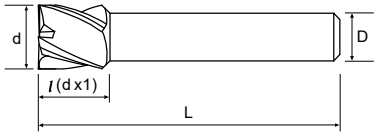





| MODE | Diameter | Flute Length | Full Length | Shank Diameter | Flute | Coating | | |
|---|---|---|---|---|---|---|---|---|
| | d | *l* | L | D | Z | AlTiBN | TiSiN | ZrN-A |
| TSTE0104 | 1 | 1 | 40 | 6 | 4 | .01 | .02 | .03 |
| TSTE0154 | 1.5 | 1.5 | 40 | 6 | 4 | .01 | .02 | .03 |
| TSTE0204 | 2 | 2 | 40 | 6 | 4 | .01 | .02 | .03 |
| TSTE0254 | 2.5 | 2.5 | 40 | 6 | 4 | .01 | .02 | .03 |
| TSTE0304 | 3 | 3 | 40 | 6 | 4 | .01 | .02 | .03 |
| TSTE0354 | 3.5 | 3.5 | 40 | 6 | 4 | .01 | .02 | .03 |
| TSTE0404 | 4 | 4 | 40 | 6 | 4 | .01 | .02 | .03 |
| TSTE0504 | 5 | 5 | 40 | 6 | 4 | .01 | .02 | .03 |
| TSTE0604 | 6 | 6 | 40 | 6 | 4 | .01 | .02 | .03 |
| TSTE0804 | 8 | 8 | 40 | 8 | 4 | .01 | .02 | .03 |
| TSTE1004 | 10 | 10 | 45 | 10 | 4 | .01 | .02 | .03 |






| MODE | Diameter | Flute Length | Full Length | Shank Diameter | Flute | Coating | | |
|---|---|---|---|---|---|---|---|---|
| | d | *l* | L | D | Z | AlTiBN | TiSiN | ZrN-A |
| TTE0704 | 7 | 7 | 40 | 6 | 4 | .01 | .02 | .03 |
| TTE0804 | 8 | 8 | 40 | 6 | 4 | .01 | .02 | .03 |
| TTE1004 | 10 | 10 | 45 | 6 | 4 | .01 | .02 | .03 |
| TTE1204 | 12 | 12 | 50 | 10 | 4 | .01 | .02 | .03 |
| TTE1604 | 16 | 16 | 60 | 10 | 4 | .01 | .02 | .03 |

Application :

★ Perfect ◎ Excellent ○ Good

| Coating | Carbon steel, Alloy steel | Pre-harden steel | High-hardened | | | | Stainless steel | Titanium alloy | Nickel/Inconel alloy | Copper alloy | Aluminum alloy |
|---|---|---|---|---|---|---|---|---|---|---|---|
| | | ~45HRC | ~50HRC | ~55HRC | ~60HRC | ~65HRC | | | | | |
| AlTiBN | ◎ | ◎ | ◎ | ○ | | | ○ | | | | |
| TiSiN | ○ | ○ | ○ | ◎ | | | | | | | |
| ZrN-A | ◎ | ◎ | ◎ | ○ | | | ◎ | ○ | ○ | | |



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