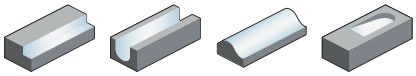
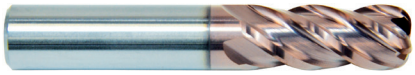
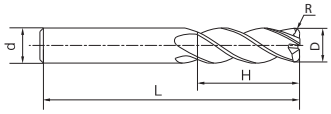
Torus mill | High-performance machining

TM-4R



– Factory standard
– Centre cutting
– Helix angle 38°





Article	✻	Dimensions [mm]					Teeth	Grade
		R	D	d (h6)	H	L		KMS405
TM-4R-D6R0.5		0.5	6	6	16	50	4	●
TM-4R-D6R0.3		0.3	6	6	16	50	4	●
TM-4R-D6R1.0		1	6	6	16	50	4	●
TM-4R-D6R 0.75		0.75	6	6	16	50	4	○
TM-4R-D8R0.5		0.5	8	8	20	60	4	●
TM-4R-D8R0.3		0.3	8	8	20	60	4	●
TM-4R-D8R1.0		1	8	8	20	60	4	●
TM-4R-D8R0.75		0.75	8	8	20	60	4	○
TM-4R-D10R0.75		0.75	10	10	25	75	4	○
TM-4R-D10R1.6		1.6	10	10	25	75	4	●
TM-4R-D10R2.0		2	10	10	25	75	4	●
TM-4R-D10R0.5		0.5	10	10	25	75	4	●
TM-4R-D10R2.5		2.5	10	10	25	75	4	○
TM-4R-D10R1.0		1	10	10	25	75	4	●
TM-4R-D10R3.0		3	10	10	25	75	4	●
TM-4R-D10R1.25		1.25	10	10	25	75	4	○
TM-4R-D10R1.5		1.5	10	10	25	75	4	●
TM-4R-D12R1.5		1.5	12	12	30	75	4	●
TM-4R-D12R0.5		0.5	12	12	30	75	4	●
TM-4R-D12R1.0		1	12	12	30	75	4	●
TM-4R-D12R4.0		4	12	12	30	75	4	●
TM-4R-D12R1.6		1.6	12	12	30	75	4	●
TM-4R-D12R2.5		2.5	12	12	30	75	4	●
TM-4R-D12R1.25		1.25	12	12	30	75	4	○
TM-4R-D12R0.75		0.75	12	12	30	75	4	○
TM-4R-D12R3.0		3	12	12	30	75	4	●
TM-4R-D12R3.2		3.2	12	12	30	75	4	●
TM-4R-D12R2.0		2	12	12	30	75	4	●
TM-4R-D16R1.25		1.25	16	16	35	90	4	●
TM-4R-D16R4.0		4	16	16	35	90	4	●
TM-4R-D16R1.0		1	16	16	35	90	4	●
TM-4R-D16R3.0		3	16	16	35	90	4	●
TM-4R-D16R2.0		2	16	16	35	90	4	●
TM-4R-D16R6.3		6.3	16	16	35	90	4	○
TM-4R-D16R5.0		5	16	16	35	90	4	●
TM-4R-D16R1.5		1.5	16	16	35	90	4	●
TM-4R-D16R2.5		2.5	16	16	35	90	4	●

● Ex stock ○ On demand
✻ With internal cooling

Application field

P	M	K	N	S	H
	✔			✔	

✔ Very suitable
✔ Suitable

System code B278 | Cutting data B492 | Nonstandard order B541

Solid carbide milling System code – DIN-ISO

5	5	0	1	R	30	2	GM	R05	0800
1	2	3	4	5	6	7	8	9	10

Type	
Code	Description
5	Milling cutter

1

Shank type	
Code	Description
1	Shank
5	DIN 6535 HA
6	Weldon shank DIN 6535 HB
7	Whistle Notch DIN 6535 HE
9	Morse taper shank

2

Cutting edge type	
Code	Description
0	Square shoulder mill
6	Ball nose cutter
8	Torus mill

3

Tool length	
Code	Description
1	DIN 6527 K
2	DIN 6527 L
5	Factory standard ZCC-A
6	Factory standard ZCC-B
8	DIN 6528
9	Factory standard ZCC-D

4

Rotation direction	
Code	Description
R	Right
L	Left

5

Helix angle	
Code	Description
20	20°
30	30°
3841	38°/41°
45	45°
55	55°
60	60°

6

Number of teeth	
Code	Description
2	2
...	
M	Indicated when different diameters have a different number of teeth

7

Application	
Code	Description
GM	Semi-finishing
GF	Finishing
HM	Hard machining
MHH	High-speed hard machining
NH	High-performance machining of heat-resistant alloys

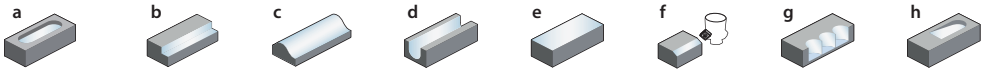
8

Radius [mm]	
Code	Description
R03	0,3
R15	1,5
R30	3,0
...	

9

Diameter [mm]	
Code	Description
0100	1,0
0800	8,0
2000	20,0
...	

10



a Groove milling
b Square shoulder milling
c Profile milling
d Slot milling
e Face milling
f Chamfer milling
g Plunge milling
h Circular milling/Ramping

GM – 2 E L P – D12 R0.5 – M08

1	2	3	4	5	6	7	8

Application	
Code	Description
GR	General roughing
GM	Semi-finishing
GF	Finishing
PM	High-performance machining
EPM	«Ecoline» – High-performance machining
VPM	Full-slot applications
HM	Hard machining
NM	General machining of non-ferrous metals
AL	General machining of Al and Al alloys
ALP	High-performance machining of Al and Al alloys
ALG	General machining of Al and Al alloys
UM	HSC/HPC machining
UMC	HSC machining with chip splitter geometry
VSM	General machining of heat-resistant alloys
TM	General machining of heat-resistant alloys

1

Number of teeth

2

Cutting edge type	
Code	Description
E	Square shoulder mill with protective chamfer
F	Square shoulder mill with sharp cutting edges
B	Ball nose cutter
R	Torus mill
W	Ripper
H	High-feed mill

3

Cutting edge length	
Code	Description
L	Long
X	Extra long
F	Short

4

Type	
Code	Description
S	Mini diameter
P	Ground neck
C	Conical neck

5

Diameter [mm]	
Code	Description
D3.0	3,0
D20.0	20,0
...	

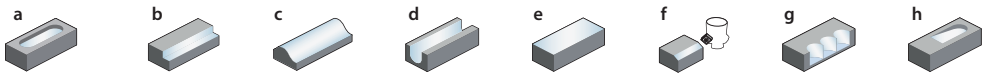
6

Radius [mm]	
Code	Description
R0.5	0,5
R3.0	3,0
...	

7

Features	
Code	Description
G	Spiral angle 30°
M	Neck length [mm]
S	Thin shank
AIR	For aerospace industry

8



a Groove milling **b** Square shoulder milling **c** Profile milling **d** Slot milling **e** Face milling **f** Chamfer milling **g** Plunge milling **h** Circular milling/Ramping

Recommended feed rate

Solid carbide milling group 9 – Square shoulder mills UM/UMC series, VPM series HSC/HPC

	a_e / D	Feed rate per cutting edge (f_z) [mm]																			
		Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 18	Ø 20										
P	1/1	0,06	0,06	0,06	0,07	0,07	0,07	0,07	0,08	0,08	0,08										
	1/2	0,08	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10	0,10										
	1/10	0,14	0,14	0,16	0,18	0,22	0,25	0,27	0,3	0,32	0,36										
M	1/1	0,05	0,05	0,05	0,05	0,05	0,05	0,05	0,06	0,06	0,06										
	1/2	0,06	0,06	0,06	0,07	0,07	0,07	0,07	0,08	0,08	0,08										
	1/10	0,10	0,10	0,10	0,12	0,12	0,14	0,16	0,16	0,18	0,18										
K	1/1	0,06	0,06	0,06	0,07	0,07	0,07	0,07	0,08	0,08	0,08										
	1/2	0,08	0,08	0,08	0,09	0,09	0,09	0,09	0,10	0,10	0,10										
	1/10	0,14	0,14	0,16	0,18	0,22	0,25	0,27	0,3	0,32	0,36										
H	1/1	0,045	0,045	0,045	0,053	0,053	0,053	0,053	0,06	0,06	0,06										
	1/2	0,06	0,06	0,06	0,07	0,07	0,07	0,07	0,08	0,08	0,08										
	1/10	0,10	0,10	0,10	0,12	0,12	0,14	0,16	0,16	0,18	0,18										

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

Solid carbide milling group 10 – Square shoulder mills VSM series, TM series

	a_e / D	Feed rate per cutting edge (f_z) [mm]																			
		Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 18	Ø 20										
P	1/1	0,03	0,04	0,05	0,05	0,05	0,05	0,06	0,06	0,07	0,08										
	1/2	0,04	0,06	0,07	0,07	0,07	0,07	0,08	0,09	0,10	0,11										
	1/10	0,05	0,08	0,09	0,09	0,09	0,09	0,11	0,12	0,14	0,15										
M	1/1	0,02	0,03	0,04	0,04	0,04	0,04	0,04	0,05	0,05	0,06										
	1/2	0,03	0,05	0,05	0,05	0,05	0,05	0,06	0,07	0,08	0,08										
	1/10	0,04	0,06	0,07	0,07	0,07	0,07	0,08	0,09	0,10	0,11										
S	1/1	0,02	0,03	0,04	0,04	0,04	0,04	0,04	0,05	0,05	0,06										
	1/2	0,03	0,05	0,05	0,05	0,05	0,05	0,06	0,07	0,08	0,08										
	1/10	0,04	0,06	0,07	0,07	0,07	0,07	0,08	0,09	0,10	0,11										

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.

Solid carbide milling group 11 – Deburring cutters FM series

	a_e / D	Feed rate per cutting edge (f_z) [mm]																			
		Ø 3	Ø 4	Ø 5	Ø 6	Ø 8	Ø 10	Ø 12	Ø 14	Ø 16	Ø 18	Ø 20									
P	1/1																				
	1/2																				
	1/10	0,02	0,02	0,03	0,03	0,04	0,06	0,07	0,07	0,08	0,08	0,09									
M	1/1																				
	1/2																				
	1/10	0,02	0,02	0,02	0,02	0,03	0,05	0,06	0,06	0,06	0,06	0,07									
K	1/1																				
	1/2																				
	1/10	0,02	0,02	0,03	0,03	0,04	0,06	0,07	0,07	0,08	0,08	0,09									
N	1/1																				
	1/2																				
	1/10	0,03	0,03	0,05	0,05	0,06	0,09	0,11	0,11	0,12	0,12	0,14									

Note: The given cutting values are guide values, which were determined under ideal conditions.
The values have to be adapted in individual cases.