TANGENTIAL MILLING CUTTER
TYP TFL-WP
If the milling task requires exact 90° shoulders or a soft-cutting tool to reduce the cutting pressure, the TFL-WP tangential milling cutter is the right choice.

- Six cutting edges per insert
- Reduced cutting forces due to positive insert geometry
- Manufacturing of exact 90° shoulders
- High level of process reliability due to maximum cross-section of cutting inserts
- An insert geometry that produces a good surface quality
- Tangential installation position and optimal pitch of the milling system resulting in improved tool life and feed

The indexable inserts are fastened interchangeably with screw clamping. Axial and circular run-out accuracy make it possible to achieve an Ra-value of 6.3 μm. The cutting material variations available for the milling system open up a wide range of materials that can be processed. GJL and GJV-cast materials can be machined in a process-reliable way with the cutting materials.
TANGENTIAL MILLING CUTTER
TYP TFL-WP

![Tangential Milling Cutter](image)

- Ra to 6.3 μm
- \( v_c = 600 - 1200 \text{ m/min} \)
- \( f_z = 0.12 - 0.30 \text{ mm} \)
- \( a_p = \text{up to 5 mm} \)

6.3

**Stable / unstable components**

**With / without cooling**

<table>
<thead>
<tr>
<th>Type</th>
<th>SPK order no.</th>
<th>Dimensions</th>
<th>n_max (min⁻¹)</th>
</tr>
</thead>
<tbody>
<tr>
<td>TFL-063-06WP0600R-AM</td>
<td>771.00.164.36</td>
<td>63, 6, 63, 40</td>
<td>13000</td>
</tr>
<tr>
<td>TFL-080-08WP0600R-AM</td>
<td>771.00.164.46</td>
<td>80, 8, 80, 50</td>
<td>10000</td>
</tr>
<tr>
<td>TFL-100-10WP0600R-AM</td>
<td>771.00.164.56</td>
<td>100, 10, 100, 50</td>
<td>8000</td>
</tr>
<tr>
<td>TFL-125-12WP0600R-AM</td>
<td>771.00.164.66</td>
<td>125, 12, 125, 63</td>
<td>8000</td>
</tr>
<tr>
<td>TFL-160-16WP0600R-AM</td>
<td>771.00.164.76</td>
<td>160, 16, 160, 63</td>
<td>6000</td>
</tr>
</tbody>
</table>

**INSERT TYPE GRADE**

- **K**
  - EN-GJL 150
  - EN-GJL 300
  - EN-GJS 150-15
  - EN-GJS 300-15
  - EN-GJS 400-15
  - EN-GJS 500-15
  - EN-GJS 600-15
  - EN-GJS 700-15
  - EN-GJS 800-15
  - EN-GJS 900-15
  - EN-GJS 1000-15
  - EN-GJS 1100-15
  - EN-GJS 1200-15

- **H**
  - EN-GJS 150-7
  - EN-GJS 300-7
  - EN-GJS 400-7
  - EN-GJS 500-7
  - EN-GJS 600-7
  - EN-GJS 700-7
  - EN-GJS 800-7
  - EN-GJS 900-7
  - EN-GJS 1000-7
  - EN-GJS 1100-7
  - EN-GJS 1200-7

- **S**
  - EN-GJS 150-3
  - EN-GJS 300-3
  - EN-GJS 400-3
  - EN-GJS 500-3
  - EN-GJS 600-3
  - EN-GJS 700-3
  - EN-GJS 800-3
  - EN-GJS 900-3
  - EN-GJS 1000-3
  - EN-GJS 1100-3
  - EN-GJS 1200-3

- **P**
  - EN-GJS 150-18
  - EN-GJS 300-18
  - EN-GJS 400-18
  - EN-GJS 500-18
  - EN-GJS 600-18
  - EN-GJS 700-18
  - EN-GJS 800-18
  - EN-GJS 900-18
  - EN-GJS 1000-18
  - EN-GJS 1100-18
  - EN-GJS 1200-18

<table>
<thead>
<tr>
<th>INSERT</th>
<th>TYPE</th>
<th>GRADE</th>
<th>H</th>
<th>S</th>
<th>P</th>
<th>SPK ORDER NO.</th>
</tr>
</thead>
<tbody>
<tr>
<td>WPHX 0906.. T</td>
<td>WPHX 090612 T00520 SL 808</td>
<td>♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦</td>
<td>♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦</td>
<td>♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦ ♦</td>
<td>17.66.035.03.1</td>
<td></td>
</tr>
</tbody>
</table>

**ISO application group**

- **K** - Cast Iron
- **H** - Hard materials
- **S** - Special alloy
- **P** - Steel
- Main application ♦
- Additional application ♦

---

[Image-1](image) [Image-2](image) [Image-3](image)