

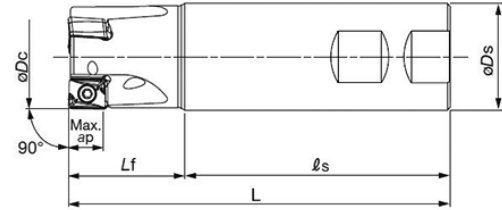
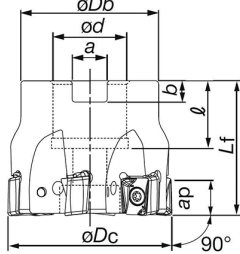
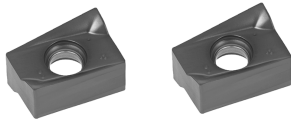
TUNGALOY® MILLING CUTTERS & INSERTS

DOREC

HIGH PERFORMANCE MILLING CUTTERS

• HIGH PRODUCTIVITY Shoulder Milling

- Highly rigid cutter body
- Ideal for general shoulder milling at high feed
- High performance levels with a diverse range of applications
- Uses double sided square insert
- Insert has high level of sharpness and incorporates effective wiper edges
- Thicker insert for rigidity
- Low cutting forces due to large rake angle
- Excellent surface finish



No of Flutes	Cutt Dia ϕDc	ϕDb	ϕd	l	L_f	b	a	Part Number	Price Each	Center Bolt	Insert Series
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Shell Mills-TPQ11R & TPQ18R SERIES SQUARE SHOULDER SHELL MILLS

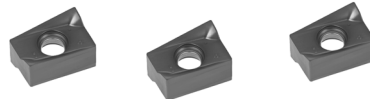
6	2.00	1.70	0.750	0.750	1.58	0.197	0.315	TO-6861287	\$500.40	C0.375x1.125H	LQMU11...
7	2.50	1.70	0.750	0.750	1.58	0.197	0.315	TO-6861294	\$595.97	C0.375 x1.125H	LQMU11...
10	3.00	1.97	1.00	1.030	1.97	0.236	0.375	TO-6861313	\$842.60	C0.500 x1.375H	LQMU11...
12	4.00	3.15	1.50	1.380	1.97	0.394	0.625	TO-6861300	\$991.07	-	LQMU11...
3	2.00	1.69	0.750	0.750	1.58	0.197	0.315	TO-6861295	\$433.00	C0.375x1.125H	LQMU18...
4	2.50	1.69	0.750	0.750	1.58	0.197	0.315	TO-6861296	\$540.60	C0.375 x1.125H	LQMU18...
5	3.00	1.97	1.00	1.030	1.97	0.236	0.375	TO-6861312	\$701.40	C0.500 x1.375H	LQMU18...
6	4.00	3.15	1.50	1.380	1.97	0.394	0.625	TO-6861306	\$839.90	-	LQMU18...
8	5.00	3.15	1.50	1.500	2.48	0.394	0.625	TO-6861284	\$1,079.70	-	LQMU18...
9	6.00	4.00	2.00	1.500	2.48	0.433	0.752	TO-6861316	\$1,350.60	-	LQMU18...

Endmills-EPQ11R SERIES SQUARE SHOULDER ENDMILLS

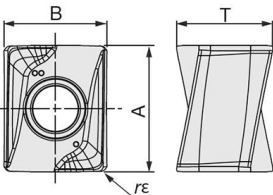
2	1.00	1.00	2.28	1.22	3.50	-	-	TO-6861292	\$317.20	-	LQMU11...
3	1.25	1.25	2.50	1.50	4.00	-	-	TO-6861317	\$377.50	-	LQMU11...
4	1.50	1.25	2.25	1.75	4.00	-	-	TO-6861305	\$411.20	-	LQMU11...

INSERTS FOR DOREC MILLING CUTTERS

- AH725 Grade:** Low & high carbon, alloy and tool steel
AH120 Grade: Grey & ductile cast iron, Superalloys
AH140 Grade: Stainless steel



DOREC



Description	Cutter Type	A	T	R	Grade AH725 Part Number	Grade AH120 Part Number	Grade AH140 Part Number	Price Each
LQMU110704PNER-MJ	EPQ11/TPQ11	0.433	0.327	0.016	TO-6861478	TO-6861234	TO-6861254	\$20.70
LQMU110708PNER-MJ		0.433	0.327	0.031	TO-6861477	TO-6861235	TO-6861242	\$20.70
LQMU110716PNER-MJ		0.433	0.327	0.063	TO-6861479	TO-6861228	TO-6861229	\$20.70
LQMU180804PNER-MJ	TPQ18	0.689	0.433	0.016	TO-6861480	TO-6861280	TO-6861263	\$24.60
LQMU180808PNER-MJ		0.689	0.433	0.031	TO-6861481	TO-6861271	TO-6861255	\$24.60
LQMU180816PNER-MJ		0.689	0.433	0.063	TO-6861524	TO-6861248	TO-6861243	\$24.60
LQMU180824PNER-MJ		0.689	0.433	0.094	TO-6861542	TO-6861249	TO-6861230	\$24.60

SPEEDS & FEEDS

Tips:

- To remove excessive chip accumulation use an air blast.
- When cutting interrupted surfaces like a casting skin, the cutting feed (fz) should be set below the values shown in the above table.
- Tool overhang should be minimized. When machining with long overhang applications the tool tends to chatter. Please reduce the feed rate fz.
- Cutting conditions limited by machine power and material rigidity. When cutting width or depth is large, set Vc and fz below the recommended values and check the machine vibration and spindle load.

Work Material	Hardness HB	Grades	Cutting Speed Vc (SFM)	Feed Per Tooth fz (ipt)
Low carbon steel (1018, 8620 etc.)	~ 200	AH725	330 - 800	.004 - .010
High carbon steel (1045, 1055 etc.)	200 ~ 300		330 - 750	.004 - .008
Alloyed steel (4140, 4340 etc.)	500 ~ 980			
Tool steel (H13, D2 etc.)	~ 300		330 - 600	
Stainless steel (304, 316 etc.)	-	AH140	300 - 600	.004 - .010
Grey cast iron (CLASS 25-40 etc.)	500 ~ 800	AH120	450 - 800	.004 - .010
Ductile cast iron (65-45-12 etc.)				
Heat-resisting alloy (Ti-6AL-4V, Inconel 718 etc.)	-	AH725	65 - 160	.003 - .008

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301

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