

Trochoidal solution for high productivity milling



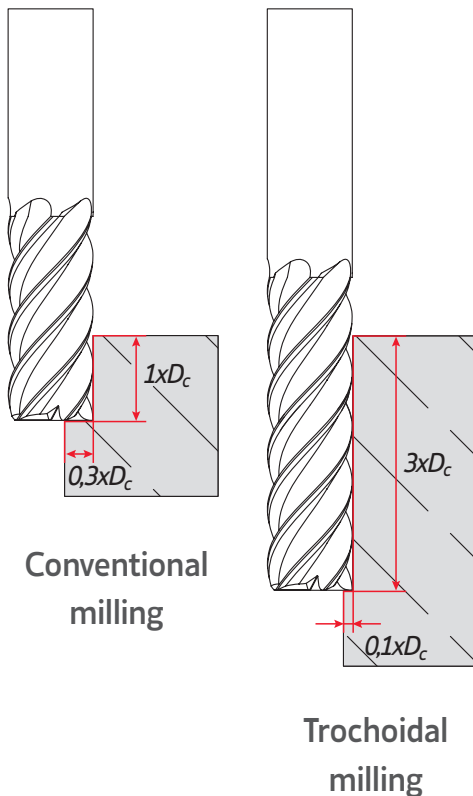
DYN-INTEG
Trochoidal Milling - TSP

NEW
PHP
NEW
GRADE



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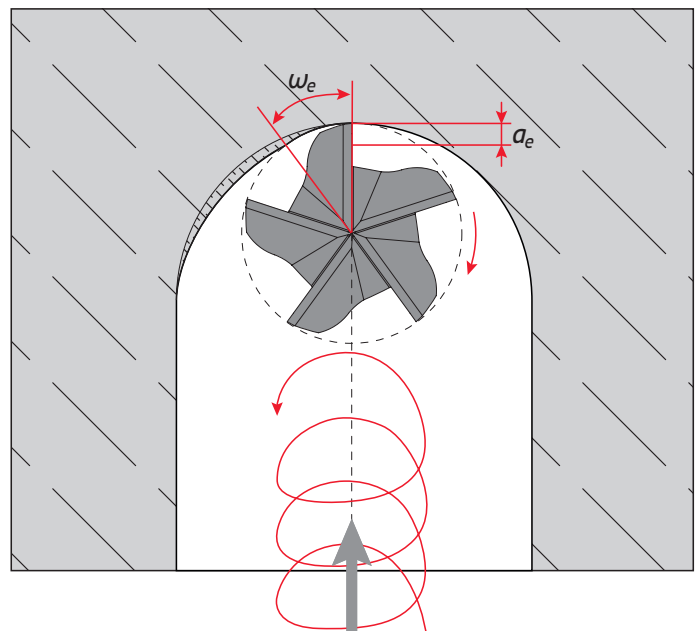
Trochoidal milling is a dynamic method of high-speed machining developed to increase the tool lifetime while also increasing productivity. This method is mostly used for slotting and consists of multiple circular cuts going forward.



When using conventional machining strategies most endmills can only mill its cutting diameter in depth. With trochoidal strategy, DYN-INTEG mills can work up to three times their cutting diameter highly increasing **productivity**.

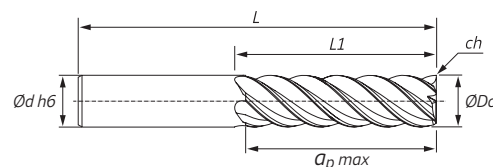
Trochoidal milling strategy

As depth of cut (a_p) increases, the cutting width (a_e) must decrease. Because this strategy consists of circular cuts the engagement angle (w_e) is also small. For those reasons the cutting forces are very low and less heat is generated, increasing the tool lifetime.



HC40TSP = Corner Chamfer, Variable Helix 40°-42° || Trochoidal Speed Cutting

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				P	K	Dimensions Dimensões Dimensiones (mm)					
				PVD	PVD						
		²⁾ Grade code		T1	T1						
Geometry code		Reference Referência Referencia		PHP920	PHP920						
HA	HB					ØDc	Ød (h6)	a _p max	L	L1	ch
1180118	1180456	HC40TSPL 5 060 20	5			6	6	20	60	26	0,15
1180119	1180457	HC40TSPL 5 080 25	5			8	8	25	63	32	0,15
1180225	1180458	HC40TSPL 5 100 32	5			10	10	32	79	38	0,20
1180690	1180689	HC40TSPL 5 120 41	5			12	12	41	100	48	0,20
1180226	1180460	HC40TSPL 5 160 50	5			16	16	50	110	56	0,25
1180123	1180461	HC40TSPL 5 180 60	5			18	18	60	130	66	0,30
1180462	1180463	HC40TSPL 5 200 64	5			20	20	64	130	70	0,35

Stock item | Produto de stock | Itens de stock

Available under request | Disponível sobre consulta | Disponible bajo consulta

Order code = (1) Geometry Code + (2) Grade Code

Note: For HB (weldon) endmills, the reference ends with "-W"

RECOMMENDED CUTTING CONDITIONS || Condições de corte recomendadas | Condiciones de corte recomendables

ISO	Workpiece Material	Vc (m/min)		fz (mm/t)		ae (mm)		Coolant
		min	max	min	max	min	max	
P	Non-alloy Steel < 600 N/mm ²	250	325	0,007xDc	0,011xDc	0,05xDc	0,1xDc	Emulsion / MQL
	Non-alloy Steel < 800 N/mm ²	210	300					
	Alloy Steel 800 N/mm ² - 1000 N/mm ²	175	250					
	Alloy Steel 1000 N/mm ² - 1400 N/mm ²	125	210					
	Alloy Steel 1400 N/mm ² - 1600 N/mm ²	80	150					
K	Cast Iron - Soft	210	250					
	Cast Iron - Hard	140	175					



SOLID CARBIDE

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