

METRIC

TOP CUT 4TM

4-Edged Indexable Drill Capable
of Drilling up to 5xD



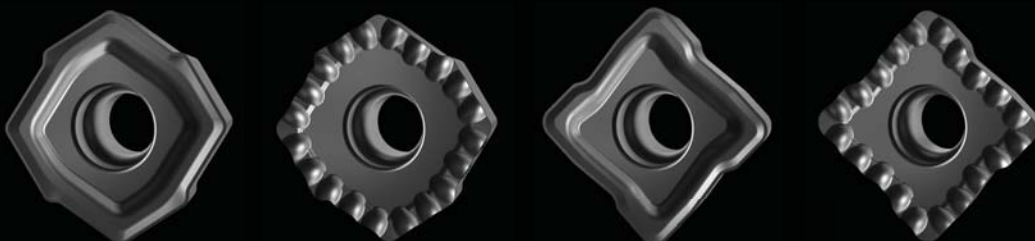
WM35PH Grade Now Available for
Stainless Steels and High-Temp Alloys

WIDIA  TM

WM35PH is the latest grade for the Top Cut 4 platform of high-performance indexable drilling. With the smooth Hi-PIMS coating surface, these V36 and V38 inserts offer durability and repeatability with every cut.

THE SOLUTION FEATURES:

- ▽ Optimum layer adhesion prevents the coating from flaking and edge build-up
- ▽ Specialized grades increase tool life and ensure high process reliability in stainless steels and high-temp alloys
- ▽ V36 geometry provides stability and versatility in general-purpose machining
- ▽ V38 geometry excels in long-chipping materials



Industries



General Engineering



Automotive



Oil & Gas



Wind & Solar



Aerospace



Aerospace and Defense



Earthworks

Materials



Stainless Steels



High-Temp Alloys

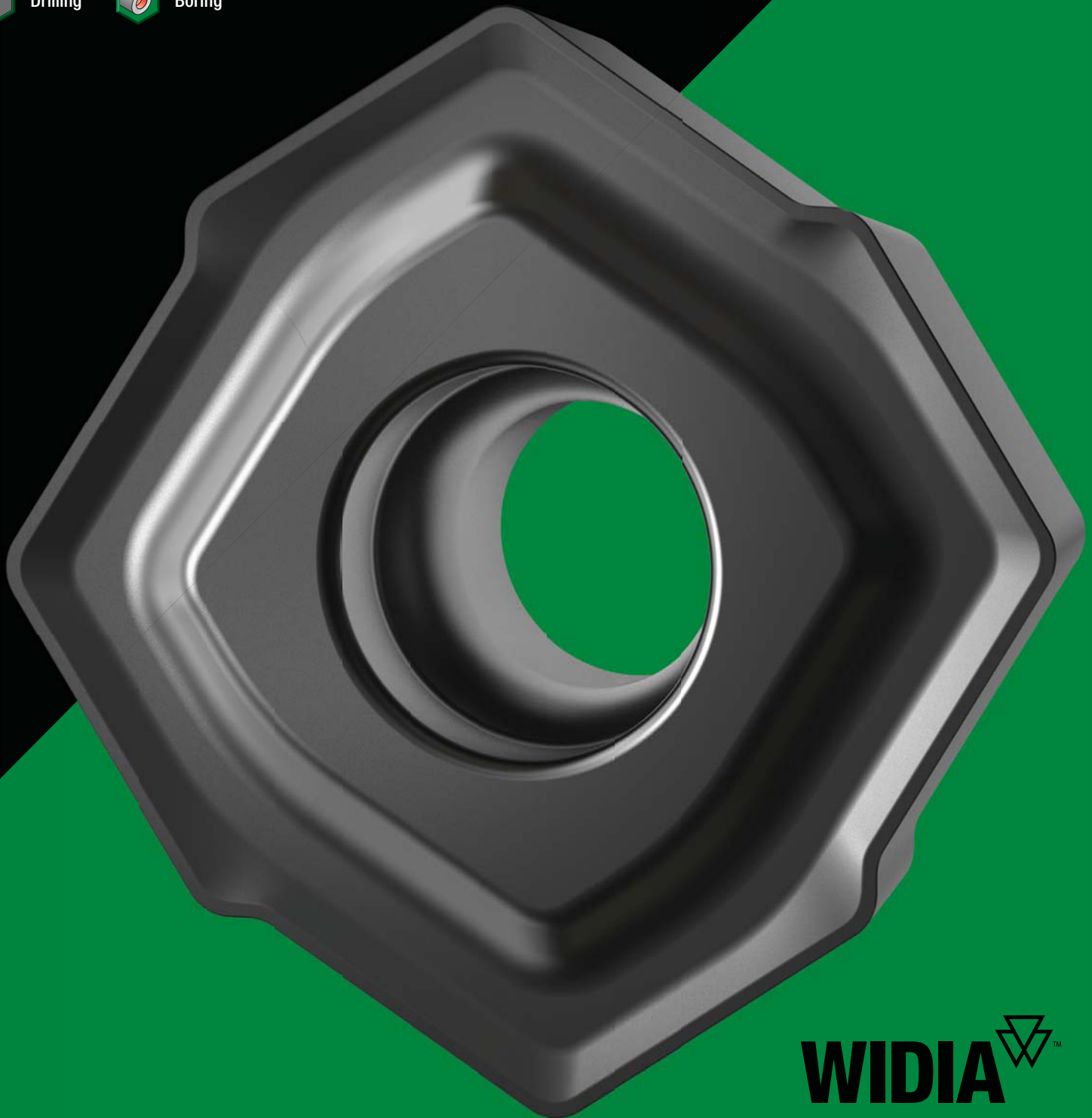
Applications



Drilling

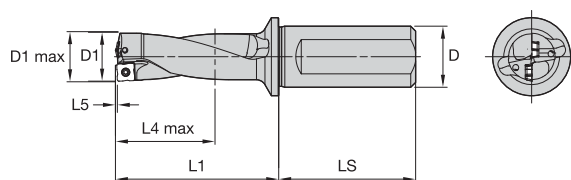


Boring



WIDIA 

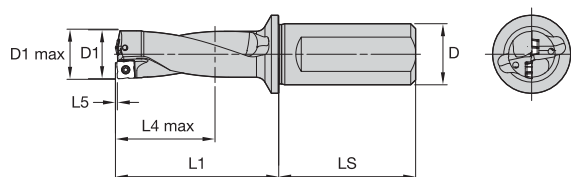




Top Cut 4

2xD • SLR Shanks

Order Number	Catalog Number	D1	D1 Max	D	L1	L4 Max	L5	LS	SSC	Periphery Insert	Center Insert
5537778	TCF120R2SLR20MA	12,00	12,50	20	43,4	24,4	0,43	50,00	A	TCF040204AP	TCF040203AC
5537779	TCF125R2SLR20MA	12,50	13,00	20	44,5	25,5	0,45	50,00	A	TCF040204AP	TCF040203AC
5537860	TCF127R2SLR20MA	12,70	13,20	20	45,9	25,9	0,46	50,00	A	TCF040204AP	TCF040203AC
5537861	TCF130R2SLR20MA	13,00	13,50	20	46,5	26,5	0,47	50,00	A	TCF040204AP	TCF040203AC
5537862	TCF135R2SLR20MA	13,50	14,00	20	48,5	27,5	0,48	50,00	A	TCF040204AP	TCF040203AC
5577828	TCF140R2SLR25MB	14,00	14,50	25	48,5	28,5	0,49	56,00	B	TCF050204BP	TCF060203BC
5577829	TCF145R2SLR25MB	14,50	15,00	25	49,5	29,5	0,52	56,00	B	TCF050204BP	TCF060203BC
5577920	TCF150R2SLR25MB	15,00	15,50	25	51,5	30,5	0,55	56,00	B	TCF050204BP	TCF060203BC
5577921	TCF155R2SLR25MB	15,50	16,00	25	53,6	31,6	0,56	56,00	B	TCF050204BP	TCF060203BC
5577922	TCF160R2SLR25MB	16,00	16,50	25	54,6	32,6	0,58	56,00	B	TCF050204BP	TCF060203BC
5577923	TCF165R2SLR25MB	16,50	17,00	25	56,6	33,6	0,60	56,00	B	TCF050204BP	TCF060203BC
5577924	TCF170R2SLR25MB	17,00	17,50	25	57,6	34,6	0,61	56,00	B	TCF050204BP	TCF060203BC
5577925	TCF175R2SLR25MB	17,50	18,00	25	59,6	35,6	0,63	56,00	B	TCF050204BP	TCF060203BC
5577926	TCF180R2SLR25MB	18,00	18,50	25	60,6	36,6	0,64	56,00	B	TCF050204BP	TCF060203BC
5577927	TCF185R2SLR25MB	18,50	19,00	25	62,7	37,7	0,65	56,00	B	TCF050204BP	TCF060203BC
5578820	TCF190R2SLR25MC	19,00	19,50	25	63,7	38,7	0,68	56,00	C	TCF070306CP	TCF070304CC
5578821	TCF195R2SLR25MC	19,50	20,00	25	65,7	39,7	0,71	56,00	C	TCF070306CP	TCF070304CC
5578822	TCF200R2SLR25MC	20,00	20,50	25	66,7	40,7	0,72	56,00	C	TCF070306CP	TCF070304CC
5578823	TCF205R2SLR25MC	20,50	21,00	25	68,7	41,7	0,74	56,00	C	TCF070306CP	TCF070304CC
5578824	TCF210R2SLR25MC	21,00	21,50	25	70,8	42,8	0,75	56,00	C	TCF070306CP	TCF070304CC
5578825	TCF220R2SLR25MC	22,00	22,50	25	73,8	44,8	0,78	56,00	C	TCF070306CP	TCF070304CC
5578826	TCF225R2SLR25MC	22,50	23,00	25	74,8	45,8	0,79	56,00	C	TCF070306CP	TCF070304CC
5578827	TCF230R2SLR25MC	23,00	23,50	25	76,8	46,8	0,80	56,00	C	TCF070306CP	TCF070304CC
5537167	TCF240R2SLR25MD	24,00	25,00	25	76,9	48,9	0,87	56,00	D	TCF080308DP	TCF090305DC
5537168	TCF250R2SLR32MD	25,00	26,00	32	80,9	50,9	0,91	60,00	D	TCF080308DP	TCF090305DC
5537169	TCF260R2SLR32MD	26,00	27,00	32	83,9	52,9	0,94	60,00	D	TCF080308DP	TCF090305DC
5537820	TCF265R2SLR32MD	26,50	27,50	32	86,0	54,0	0,95	60,00	D	TCF080308DP	TCF090305DC
5537821	TCF270R2SLR32MD	27,00	28,00	32	87,0	55,0	0,97	60,00	D	TCF080308DP	TCF090305DC
5537822	TCF280R2SLR32MD	28,00	29,00	32	90,0	57,0	0,99	60,00	D	TCF080308DP	TCF090305DC
5537823	TCF290R2SLR32MD	29,00	30,00	32	93,0	59,0	1,02	60,00	D	TCF080308DP	TCF090305DC
5537937	TCF300R2SLR32ME	30,00	31,00	32	93,1	61,1	1,09	60,00	E	TCF100408EP	TCF120405EC
5537938	TCF310R2SLR32ME	31,00	32,00	32	96,1	63,1	1,12	60,00	E	TCF100408EP	TCF120405EC
5537939	TCF320R2SLR32ME	32,00	33,00	32	99,2	65,2	1,15	60,00	E	TCF100408EP	TCF120405EC
5537940	TCF330R2SLR40ME	33,00	34,00	40	103,2	67,2	1,18	70,00	E	TCF100408EP	TCF120405EC
5537941	TCF340R2SLR40ME	34,00	35,00	40	106,2	69,2	1,21	70,00	E	TCF100408EP	TCF120405EC
5537942	TCF350R2SLR40ME	35,00	36,00	40	109,2	71,2	1,24	70,00	E	TCF100408EP	TCF120405EC
5537943	TCF360R2SLR40ME	36,00	37,00	40	112,3	73,3	1,27	70,00	E	TCF100408EP	TCF120405EC
5578539	TCF370R2SLR40MF	37,00	38,00	40	115,3	75,3	1,35	70,00	F	TCF120412FP	TCF150406FC
5578600	TCF375R2SLR40MF	37,50	38,50	40	116,4	76,4	1,36	70,00	F	TCF120412FP	TCF150406FC
5578601	TCF380R2SLR40MF	38,00	39,00	40	118,4	77,4	1,38	70,00	F	TCF120412FP	TCF150406FC
5578602	TCF390R2SLR40MF	39,00	40,00	40	121,4	79,4	1,41	70,00	F	TCF120412FP	TCF150406FC
5578603	TCF400R2SLR40MF	40,00	41,00	40	123,4	81,4	1,45	70,00	F	TCF120412FP	TCF150406FC
5578604	TCF410R2SLR40MF	41,00	42,00	40	126,5	83,5	1,48	70,00	F	TCF120412FP	TCF150406FC
5578605	TCF420R2SLR40MF	42,00	43,00	40	129,5	85,5	1,51	70,00	F	TCF120412FP	TCF150406FC
5578606	TCF430R2SLR40MF	43,00	44,00	40	132,5	87,5	1,53	70,00	F	TCF120412FP	TCF150406FC
5578607	TCF440R2SLR40MF	44,00	45,00	40	135,6	89,6	1,56	70,00	F	TCF120412FP	TCF150406FC
5578608	TCF450R2SLR40MF	45,00	46,00	40	138,6	91,6	1,59	70,00	F	TCF120412FP	TCF150406FC
5578694	TCF460R2SLR40MG	46,00	47,00	40	136,7	93,7	1,67	70,00	G	TCF150512GP	TCF180508GC
5578695	TCF470R2SLR40MG	47,00	48,00	40	139,7	95,7	1,70	70,00	G	TCF150512GP	TCF180508GC
5578696	TCF480R2SLR40MG	48,00	49,00	40	142,7	97,7	1,73	70,00	G	TCF150512GP	TCF180508GC
5578697	TCF490R2SLR40MG	49,00	50,00	40	145,8	99,8	1,76	70,00	G	TCF150512GP	TCF180508GC
5578698	TCF500R2SLR40MG	50,00	51,00	40	147,8	101,8	1,79	70,00	G	TCF150512GP	TCF180508GC
5578699	TCF505R2SLR40MG	50,50	51,50	40	149,8	102,8	1,80	70,00	G	TCF150512GP	TCF180508GC
5578710	TCF510R2SLR40MG	51,00	52,00	40	150,8	103,8	1,81	70,00	G	TCF150512GP	TCF180508GC
5578711	TCF520R2SLR40MG	52,00	53,00	40	153,8	105,8	1,84	70,00	G	TCF150512GP	TCF180508GC
5578712	TCF530R2SLR40MG	53,00	54,00	40	156,9	107,9	1,87	70,00	G	TCF150512GP	TCF180508GC
5578713	TCF540R2SLR40MG	54,00	55,00	40	159,9	109,9	1,89	70,00	G	TCF150512GP	TCF180508GC
5578714	TCF550R2SLR40MG	55,00	56,00	40	161,9	111,9	1,92	70,00	G	TCF150512GP	TCF180508GC
5578715	TCF560R2SLR40MG	56,00	57,00	40	164,9	113,9	1,94	70,00	G	TCF150512GP	TCF180508GC
5538613	TCF570R2SLR40MH	57,00	58,00	40	162,1	116,1	2,06	70,00	H	TCF180614HP	TCF210608HC



Top Cut 4

2xD • SLR Shanks • *Continued*

Order Number	Catalog Number	D1	D1 Max	D	L1	L4 Max	L5	LS	SSC	Periphery Insert	Center Insert
5538614	TCF580R2SLR40MH	58,00	59,00	40	165,1	118,1	2,09	70,00	H	TCF180614HP	TCF210608HC
5538615	TCF590R2SLR40MH	59,00	60,00	40	168,1	120,1	2,12	70,00	H	TCF180614HP	TCF210608HC
5538616	TCF600R2SLR40MH	60,00	61,00	40	170,1	122,1	2,15	70,00	H	TCF180614HP	TCF210608HC
5538617	TCF610R2SLR40MH	61,00	62,00	40	173,2	124,2	2,18	70,00	H	TCF180614HP	TCF210608HC
5538618	TCF620R2SLR40MH	62,00	63,00	40	176,2	126,2	2,20	70,00	H	TCF180614HP	TCF210608HC
5538619	TCF630R2SLR40MH	63,00	64,00	40	179,2	128,2	2,23	70,00	H	TCF180614HP	TCF210608HC
5538630	TCF640R2SLR40MH	64,00	65,00	40	181,3	130,3	2,26	70,00	H	TCF180614HP	TCF210608HC
5538631	TCF650R2SLR40MH	65,00	66,00	40	184,3	132,3	2,28	70,00	H	TCF180614HP	TCF210608HC
5538632	TCF660R2SLR40MH	66,00	67,00	40	187,3	134,3	2,31	70,00	H	TCF180614HP	TCF210608HC
5538633	TCF670R2SLR40MH	67,00	68,00	40	189,3	136,3	2,33	70,00	H	TCF180614HP	TCF210608HC
5538634	TCF680R2SLR40MH	68,00	69,00	40	192,4	138,4	2,36	70,00	H	TCF180614HP	TCF210608HC

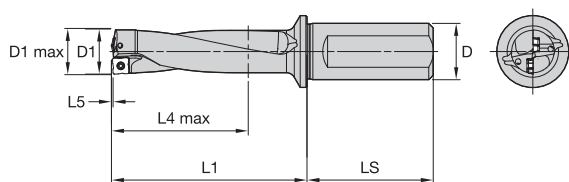
D	LS
20,00	50
25,00	56
32,00	60
40,00	70

WARNING

During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece.

When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force.

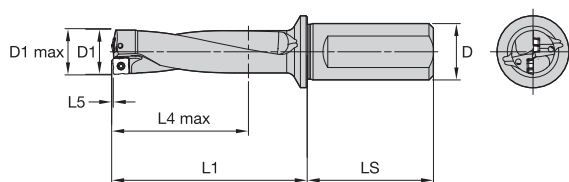
Provide adequate shielding to protect bystanders.



Top Cut 4

3xD • SLR Shanks

Order Number	Catalog Number	D1	D1 Max	D	L1	L4 Max	L5	LS	SSC	Periphery Insert	Center Insert
5537863	TCF120R3SLR20MA	12,00	12,50	20	55,4	36,4	0,43	50,00	A	TCF040204AP	TCF040203AC
5537864	TCF125R3SLR20MA	12,50	13,00	20	57,0	38,0	0,45	50,00	A	TCF040204AP	TCF040203AC
5537866	TCF127R3SLR20MA	12,70	13,20	20	58,6	38,6	0,46	50,00	A	TCF040204AP	TCF040203AC
5537867	TCF130R3SLR20MA	13,00	13,50	20	59,5	39,5	0,47	50,00	A	TCF040204AP	TCF040203AC
5537868	TCF135R3SLR20MA	13,50	14,00	20	61,0	41,0	0,48	50,00	A	TCF040204AP	TCF040203AC
5577928	TCF140R3SLR25MB	14,00	14,50	25	62,5	42,5	0,49	56,00	B	TCF050204BP	TCF060203BC
5577929	TCF145R3SLR25MB	14,50	15,00	25	64,0	44,0	0,52	56,00	B	TCF050204BP	TCF060203BC
5577930	TCF150R3SLR25MB	15,00	15,50	25	66,5	45,5	0,55	56,00	B	TCF050204BP	TCF060203BC
5577931	TCF155R3SLR25MB	15,50	16,00	25	69,1	47,1	0,56	56,00	B	TCF050204BP	TCF060203BC
5577932	TCF160R3SLR25MB	16,00	16,50	25	70,6	48,6	0,58	56,00	B	TCF050204BP	TCF060203BC
5577933	TCF165R3SLR25MB	16,50	17,00	25	73,1	50,1	0,60	56,00	B	TCF050204BP	TCF060203BC
5577934	TCF170R3SLR25MB	17,00	17,50	25	74,6	51,6	0,61	56,00	B	TCF050204BP	TCF060203BC
5577935	TCF175R3SLR25MB	17,50	18,00	25	77,1	53,1	0,63	56,00	B	TCF050204BP	TCF060203BC
5577936	TCF180R3SLR25MB	18,00	18,50	25	78,6	54,6	0,64	56,00	B	TCF050204BP	TCF060203BC
5577937	TCF185R3SLR25MB	18,50	19,00	25	81,2	56,2	0,65	56,00	B	TCF050204BP	TCF060203BC
5578828	TCF190R3SLR25MC	19,00	19,50	25	82,7	57,7	0,68	56,00	C	TCF070306CP	TCF070304CC
5578829	TCF195R3SLR25MC	19,50	20,00	25	85,2	59,2	0,71	56,00	C	TCF070306CP	TCF070304CC
5578830	TCF200R3SLR25MC	20,00	20,50	25	86,7	60,7	0,72	56,00	C	TCF070306CP	TCF070304CC
5578831	TCF205R3SLR25MC	20,50	21,00	25	89,2	62,2	0,74	56,00	C	TCF070306CP	TCF070304CC
5578832	TCF210R3SLR25MC	21,00	21,50	25	91,8	63,8	0,75	56,00	C	TCF070306CP	TCF070304CC
5578833	TCF220R3SLR25MC	22,00	22,50	25	95,8	66,8	0,78	56,00	C	TCF070306CP	TCF070304CC
5578834	TCF225R3SLR25MC	22,50	23,00	25	97,3	68,3	0,79	56,00	C	TCF070306CP	TCF070304CC
5578835	TCF230R3SLR25MC	23,00	23,50	25	99,8	69,8	0,80	56,00	C	TCF070306CP	TCF070304CC
5537824	TCF240R3SLR25MD	24,00	25,00	25	100,9	72,9	0,87	56,00	D	TCF080308DP	TCF090305DC
5537825	TCF250R3SLR32MD	25,00	26,00	32	105,9	75,9	0,91	60,00	D	TCF080308DP	TCF090305DC
5537826	TCF260R3SLR32MD	26,00	27,00	32	109,9	78,9	0,94	60,00	D	TCF080308DP	TCF090305DC
5537827	TCF265R3SLR32MD	26,50	27,50	32	112,5	80,5	0,95	60,00	D	TCF080308DP	TCF090305DC
5537828	TCF270R3SLR32MD	27,00	28,00	32	114,0	82,0	0,97	60,00	D	TCF080308DP	TCF090305DC
5537829	TCF280R3SLR32MD	28,00	29,00	32	118,0	85,0	0,99	60,00	D	TCF080308DP	TCF090305DC
5537830	TCF290R3SLR32MD	29,00	30,00	32	122,0	88,0	1,02	60,00	D	TCF080308DP	TCF090305DC
5537944	TCF300R3SLR32ME	30,00	31,00	32	123,1	91,1	1,09	60,00	E	TCF100408EP	TCF120405EC
5537945	TCF310R3SLR32ME	31,00	32,00	32	127,1	94,1	1,12	60,00	E	TCF100408EP	TCF120405EC
5537946	TCF320R3SLR32ME	32,00	33,00	32	131,2	97,2	1,15	60,00	E	TCF100408EP	TCF120405EC
5537947	TCF330R3SLR40ME	33,00	34,00	40	136,2	100,2	1,18	70,00	E	TCF100408EP	TCF120405EC
5537948	TCF340R3SLR40ME	34,00	35,00	40	140,2	103,2	1,21	70,00	E	TCF100408EP	TCF120405EC
5537949	TCF350R3SLR40ME	35,00	36,00	40	144,2	106,2	1,24	70,00	E	TCF100408EP	TCF120405EC
5537950	TCF360R3SLR40ME	36,00	37,00	40	148,3	109,3	1,27	70,00	E	TCF100408EP	TCF120405EC
5578609	TCF370R3SLR40MF	37,00	38,00	40	152,3	112,3	1,35	70,00	F	TCF120412FP	TCF150406FC
5578610	TCF375R3SLR40MF	37,50	38,50	40	153,9	113,9	1,36	70,00	F	TCF120412FP	TCF150406FC
5578611	TCF380R3SLR40MF	38,00	39,00	40	156,4	115,4	1,38	70,00	F	TCF120412FP	TCF150406FC
5578612	TCF390R3SLR40MF	39,00	40,00	40	160,4	118,4	1,41	70,00	F	TCF120412FP	TCF150406FC
5578613	TCF400R3SLR40MF	40,00	41,00	40	163,4	121,4	1,45	70,00	F	TCF120412FP	TCF150406FC
5578614	TCF410R3SLR40MF	41,00	42,00	40	167,5	124,5	1,48	70,00	F	TCF120412FP	TCF150406FC
5578615	TCF420R3SLR40MF	42,00	43,00	40	171,5	127,5	1,51	70,00	F	TCF120412FP	TCF150406FC
5578616	TCF430R3SLR40MF	43,00	44,00	40	175,5	130,5	1,53	70,00	F	TCF120412FP	TCF150406FC
5578617	TCF440R3SLR40MF	44,00	45,00	40	179,6	133,6	1,56	70,00	F	TCF120412FP	TCF150406FC
5578618	TCF450R3SLR40MF	45,00	46,00	40	183,6	136,6	1,59	70,00	F	TCF120412FP	TCF150406FC
5578716	TCF460R3SLR40MG	46,00	47,00	40	182,7	139,7	1,67	70,00	G	TCF150512GP	TCF180508GC
5578717	TCF470R3SLR40MG	47,00	48,00	40	186,7	142,7	1,70	70,00	G	TCF150512GP	TCF180508GC
5578718	TCF480R3SLR40MG	48,00	49,00	40	190,7	145,7	1,73	70,00	G	TCF150512GP	TCF180508GC
5578719	TCF490R3SLR40MG	49,00	50,00	40	194,8	148,8	1,76	70,00	G	TCF150512GP	TCF180508GC
5578720	TCF500R3SLR40MG	50,00	51,00	40	197,8	151,8	1,79	70,00	G	TCF150512GP	TCF180508GC
5578721	TCF505R3SLR40MG	50,50	51,50	40	200,3	153,3	1,80	70,00	G	TCF150512GP	TCF180508GC
5578722	TCF510R3SLR40MG	51,00	52,00	40	201,8	154,8	1,81	70,00	G	TCF150512GP	TCF180508GC
5578723	TCF520R3SLR40MG	52,00	53,00	40	205,8	157,8	1,84	70,00	G	TCF150512GP	TCF180508GC
5578724	TCF530R3SLR40MG	53,00	54,00	40	209,9	160,9	1,87	70,00	G	TCF150512GP	TCF180508GC
5578726	TCF540R3SLR40MG	54,00	55,00	40	213,9	163,9	1,89	70,00	G	TCF150512GP	TCF180508GC
5578727	TCF550R3SLR40MG	55,00	56,00	40	216,9	166,9	1,92	70,00	G	TCF150512GP	TCF180508GC
5578728	TCF560R3SLR40MG	56,00	57,00	40	220,9	169,9	1,94	70,00	G	TCF150512GP	TCF180508GC
5538635	TCF570R3SLR40MH	57,00	58,00	40	219,1	173,1	2,06	70,00	H	TCF180614HP	TCF210608HC



Top Cut 4

3xD • SLR Shanks • *Continued*

Order Number	Catalog Number	D1	D1 Max	D	L1	L4 Max	L5	LS	SSC	Periphery Insert	Center Insert
5538636	TCF580R3SLR40MH	58,00	59,00	40	223,1	176,1	2,09	70,00	H	TCF180614HP	TCF210608HC
5538637	TCF590R3SLR40MH	59,00	60,00	40	227,1	179,1	2,12	70,00	H	TCF180614HP	TCF210608HC
5538638	TCF600R3SLR40MH	60,00	61,00	40	230,1	182,1	2,15	70,00	H	TCF180614HP	TCF210608HC
5538639	TCF610R3SLR40MH	61,00	62,00	40	234,2	185,2	2,18	70,00	H	TCF180614HP	TCF210608HC
5538640	TCF620R3SLR40MH	62,00	63,00	40	238,2	188,2	2,20	70,00	H	TCF180614HP	TCF210608HC
5538641	TCF630R3SLR40MH	63,00	64,00	40	242,2	191,2	2,23	70,00	H	TCF180614HP	TCF210608HC
5538642	TCF640R3SLR40MH	64,00	65,00	40	245,3	194,3	2,26	70,00	H	TCF180614HP	TCF210608HC
5538643	TCF650R3SLR40MH	65,00	66,00	40	249,3	197,3	2,28	70,00	H	TCF180614HP	TCF210608HC
5538644	TCF660R3SLR40MH	66,00	67,00	40	253,3	200,3	2,31	70,00	H	TCF180614HP	TCF210608HC
5538645	TCF670R3SLR40MH	67,00	68,00	40	256,3	203,3	2,33	70,00	H	TCF180614HP	TCF210608HC
5538646	TCF680R3SLR40MH	68,00	69,00	40	260,4	206,4	2,36	70,00	H	TCF180614HP	TCF210608HC

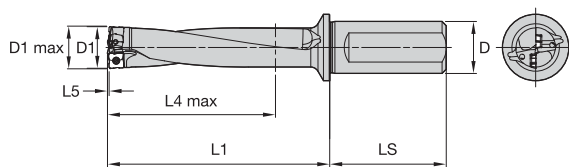
D	LS
20,00	50
25,00	56
32,00	60
40,00	70

WARNING

During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece.

When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force.

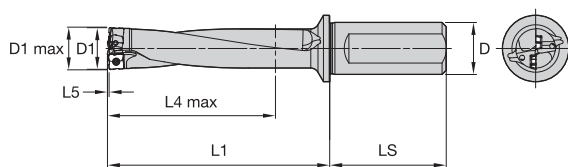
Provide adequate shielding to protect bystanders.



Top Cut 4

4xD • SLR Shanks

Order Number	Catalog Number	D1	D1 Max	D	L1	L4 Max	L5	LS	SSC	Periphery Insert	Center Insert
5537869	TCF120R4SLR20MA	12,00	12,50	20	67,4	48,4	0,43	50,00	A	TCF040204AP	TCF040203AC
5537870	TCF125R4SLR20MA	12,50	13,00	20	69,5	50,5	0,45	50,00	A	TCF040204AP	TCF040203AC
5537871	TCF127R4SLR20MA	12,70	13,20	20	71,3	51,3	0,46	50,00	A	TCF040204AP	TCF040203AC
5537872	TCF130R4SLR20MA	13,00	13,50	20	72,5	52,5	0,47	50,00	A	TCF040204AP	TCF040203AC
5537873	TCF135R4SLR20MA	13,50	14,00	20	75,5	54,5	0,48	50,00	A	TCF040204AP	TCF040203AC
5577938	TCF140R4SLR25MB	14,00	14,50	25	76,5	56,5	0,49	56,00	B	TCF050204BP	TCF060203BC
5577939	TCF145R4SLR25MB	14,50	15,00	25	78,5	58,5	0,52	56,00	B	TCF050204BP	TCF060203BC
5577940	TCF150R4SLR25MB	15,00	15,50	25	81,5	60,5	0,55	56,00	B	TCF050204BP	TCF060203BC
5577941	TCF155R4SLR25MB	15,50	16,00	25	84,6	62,6	0,56	56,00	B	TCF050204BP	TCF060203BC
5577942	TCF160R4SLR25MB	16,00	16,50	25	86,6	64,6	0,58	56,00	B	TCF050204BP	TCF060203BC
5577943	TCF165R4SLR25MB	16,50	17,00	25	89,6	66,6	0,60	56,00	B	TCF050204BP	TCF060203BC
5577944	TCF170R4SLR25MB	17,00	17,50	25	91,6	68,6	0,61	56,00	B	TCF050204BP	TCF060203BC
5577945	TCF175R4SLR25MB	17,50	18,00	25	94,6	70,6	0,63	56,00	B	TCF050204BP	TCF060203BC
5577946	TCF180R4SLR25MB	18,00	18,50	25	96,6	72,6	0,64	56,00	B	TCF050204BP	TCF060203BC
5577947	TCF185R4SLR25MB	18,50	19,00	25	99,7	74,7	0,65	56,00	B	TCF050204BP	TCF060203BC
5578836	TCF190R4SLR25MC	19,00	19,50	25	101,7	76,7	0,68	56,00	C	TCF070306CP	TCF070304CC
5578837	TCF195R4SLR25MC	19,50	20,00	25	104,7	78,7	0,71	56,00	C	TCF070306CP	TCF070304CC
5578838	TCF200R4SLR25MC	20,00	20,50	25	106,7	80,7	0,72	56,00	C	TCF070306CP	TCF070304CC
5578839	TCF205R4SLR25MC	20,50	21,00	25	109,7	82,7	0,74	56,00	C	TCF070306CP	TCF070304CC
5578840	TCF210R4SLR25MC	21,00	21,50	25	112,8	84,8	0,75	56,00	C	TCF070306CP	TCF070304CC
5578841	TCF220R4SLR25MC	22,00	22,50	25	117,8	88,8	0,78	56,00	C	TCF070306CP	TCF070304CC
5578842	TCF225R4SLR25MC	22,50	23,00	25	119,8	90,8	0,79	56,00	C	TCF070306CP	TCF070304CC
5578843	TCF230R4SLR25MC	23,00	23,50	25	122,8	92,8	0,80	56,00	C	TCF070306CP	TCF070304CC
5537831	TCF240R4SLR25MD	24,00	25,00	25	124,9	96,9	0,87	56,00	D	TCF080308DP	TCF090305DC
5537832	TCF250R4SLR32MD	25,00	26,00	32	130,9	100,9	0,91	60,00	D	TCF080308DP	TCF090305DC
5537833	TCF260R4SLR32MD	26,00	27,00	32	135,9	104,9	0,94	60,00	D	TCF080308DP	TCF090305DC
5537834	TCF265R4SLR32MD	26,50	27,50	32	139,0	107,0	0,95	60,00	D	TCF080308DP	TCF090305DC
5537835	TCF270R4SLR32MD	27,00	28,00	32	141,0	109,0	0,97	60,00	D	TCF080308DP	TCF090305DC
5537836	TCF280R4SLR32MD	28,00	29,00	32	146,0	113,0	0,99	60,00	D	TCF080308DP	TCF090305DC
5537837	TCF290R4SLR32MD	29,00	30,00	32	151,0	117,0	1,02	60,00	D	TCF080308DP	TCF090305DC
5537951	TCF300R4SLR32ME	30,00	31,00	32	153,1	121,1	1,09	60,00	E	TCF100408EP	TCF120405EC
5537952	TCF310R4SLR32ME	31,00	32,00	32	158,1	125,1	1,12	60,00	E	TCF100408EP	TCF120405EC
5537953	TCF320R4SLR32ME	32,00	33,00	32	163,2	129,2	1,15	60,00	E	TCF100408EP	TCF120405EC
5537954	TCF330R4SLR40ME	33,00	34,00	40	165,2	133,2	1,18	70,00	E	TCF100408EP	TCF120405EC
5537955	TCF340R4SLR40ME	34,00	35,00	40	174,2	137,2	1,21	70,00	E	TCF100408EP	TCF120405EC
5537956	TCF350R4SLR40ME	35,00	36,00	40	179,2	141,2	1,24	70,00	E	TCF100408EP	TCF120405EC
5537957	TCF360R4SLR40ME	36,00	37,00	40	184,3	145,3	1,27	70,00	E	TCF100408EP	TCF120405EC
5578619	TCF370R4SLR40MF	37,00	38,00	40	189,3	149,3	1,35	70,00	F	TCF120412FP	TCF150406FC
5578620	TCF375R4SLR40MF	37,50	38,50	40	191,4	151,4	1,36	70,00	F	TCF120412FP	TCF150406FC
5578621	TCF380R4SLR40MF	38,00	39,00	40	194,4	153,4	1,38	70,00	F	TCF120412FP	TCF150406FC
5578622	TCF390R4SLR40MF	39,00	40,00	40	199,4	157,4	1,41	70,00	F	TCF120412FP	TCF150406FC
5578623	TCF400R4SLR40MF	40,00	41,00	40	203,4	161,4	1,45	70,00	F	TCF120412FP	TCF150406FC
5578624	TCF410R4SLR40MF	41,00	42,00	40	208,5	165,5	1,48	70,00	F	TCF120412FP	TCF150406FC
5578625	TCF420R4SLR40MF	42,00	43,00	40	213,5	169,5	1,51	70,00	F	TCF120412FP	TCF150406FC
5578626	TCF430R4SLR40MF	43,00	44,00	40	218,5	173,5	1,53	70,00	F	TCF120412FP	TCF150406FC
5578627	TCF440R4SLR40MF	44,00	45,00	40	223,6	177,6	1,56	70,00	F	TCF120412FP	TCF150406FC
5578628	TCF450R4SLR40MF	45,00	46,00	40	228,6	181,6	1,59	70,00	F	TCF120412FP	TCF150406FC
5578729	TCF460R4SLR40MG	46,00	47,00	40	228,7	185,7	1,67	70,00	G	TCF150512GP	TCF180508GC
5578730	TCF470R4SLR40MG	47,00	48,00	40	233,7	189,7	1,70	70,00	G	TCF150512GP	TCF180508GC
5578731	TCF480R4SLR40MG	48,00	49,00	40	238,7	193,7	1,73	70,00	G	TCF150512GP	TCF180508GC
5578732	TCF490R4SLR40MG	49,00	50,00	40	243,8	197,8	1,76	70,00	G	TCF150512GP	TCF180508GC
5578733	TCF500R4SLR40MG	50,00	51,00	40	247,8	201,8	1,79	70,00	G	TCF150512GP	TCF180508GC
5578734	TCF505R4SLR40MG	50,50	51,50	40	250,8	203,8	1,80	70,00	G	TCF150512GP	TCF180508GC
5578735	TCF510R4SLR40MG	51,00	52,00	40	252,8	205,8	1,81	70,00	G	TCF150512GP	TCF180508GC
5578736	TCF520R4SLR40MG	52,00	53,00	40	257,8	209,8	1,84	70,00	G	TCF150512GP	TCF180508GC
5578737	TCF530R4SLR40MG	53,00	54,00	40	262,9	213,9	1,87	70,00	G	TCF150512GP	TCF180508GC
5578738	TCF540R4SLR40MG	54,00	55,00	40	267,9	217,9	1,89	70,00	G	TCF150512GP	TCF180508GC
5578739	TCF550R4SLR40MG	55,00	56,00	40	271,9	221,9	1,92	70,00	G	TCF150512GP	TCF180508GC
5578750	TCF560R4SLR40MG	56,00	57,00	40	276,9	225,9	1,94	70,00	G	TCF150512GP	TCF180508GC
5538647	TCF570R4SLR40MH	57,00	58,00	40	276,1	230,1	2,06	70,00	H	TCF180614HP	TCF210608HC



Top Cut 4

4xD • SLR Shanks • *Continued*

Order Number	Catalog Number	D1	D1 Max	D	L1	L4 Max	L5	LS	SSC	Periphery Insert	Center Insert
5538648	TCF580R4SLR40MH	58,00	59,00	40	281,1	234,1	2,09	70,00	H	TCF180614HP	TCF210608HC
5538649	TCF590R4SLR40MH	59,00	60,00	40	286,1	238,1	2,12	70,00	H	TCF180614HP	TCF210608HC
5538650	TCF600R4SLR40MH	60,00	61,00	40	290,1	242,1	2,15	70,00	H	TCF180614HP	TCF210608HC
5538651	TCF610R4SLR40MH	61,00	62,00	40	295,2	246,2	2,18	70,00	H	TCF180614HP	TCF210608HC
5538652	TCF620R4SLR40MH	62,00	63,00	40	300,2	250,2	2,20	70,00	H	TCF180614HP	TCF210608HC
5538653	TCF630R4SLR40MH	63,00	64,00	40	305,2	254,2	2,23	70,00	H	TCF180614HP	TCF210608HC
5538654	TCF640R4SLR40MH	64,00	65,00	40	309,3	258,3	2,26	70,00	H	TCF180614HP	TCF210608HC
5538655	TCF650R4SLR40MH	65,00	66,00	40	314,3	262,3	2,28	70,00	H	TCF180614HP	TCF210608HC
5538656	TCF660R4SLR40MH	66,00	67,00	40	319,3	266,3	2,31	70,00	H	TCF180614HP	TCF210608HC
5538657	TCF670R4SLR40MH	67,00	68,00	40	323,3	270,3	2,33	70,00	H	TCF180614HP	TCF210608HC
5538658	TCF680R4SLR40MH	68,00	69,00	40	328,4	274,4	2,36	70,00	H	TCF180614HP	TCF210608HC

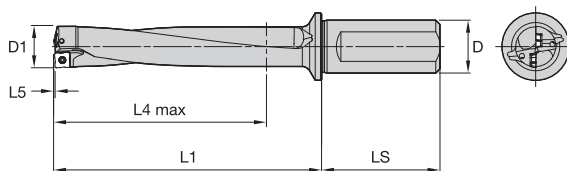
D	LS
20,00	50
25,00	56
32,00	60
40,00	70

WARNING

During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece.

When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force.

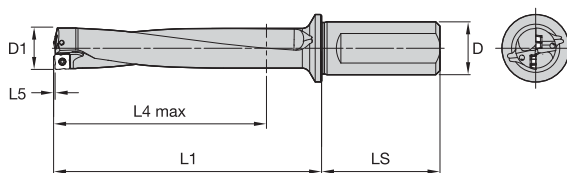
Provide adequate shielding to protect bystanders.



Top Cut 4

5xD • SLR Shanks

Order Number	Catalog Number	D1	D	L1	L4 Max	L5	LS	SSC	Periphery Insert	Center Insert
5537874	TCF120R5SLR20MA	12,00	20	79,4	60,4	0,43	50,00	A	TCF040204AP	TCF040203AC
5537875	TCF125R5SLR20MA	12,50	20	82,0	63,0	0,45	50,00	A	TCF040204AP	TCF040203AC
5537876	TCF127R5SLR20MA	12,70	20	84,0	64,0	0,46	50,00	A	TCF040204AP	TCF040203AC
5537877	TCF130R5SLR20MA	13,00	20	85,5	65,5	0,47	50,00	A	TCF040204AP	TCF040203AC
5537878	TCF135R5SLR20MA	13,50	20	89,0	68,0	0,48	50,00	A	TCF040204AP	TCF040203AC
5577948	TCF140R5SLR25MB	14,00	25	90,5	70,5	0,49	56,00	B	TCF050204BP	TCF060203BC
5577949	TCF145R5SLR25MB	14,50	25	93,0	73,0	0,52	56,00	B	TCF050204BP	TCF060203BC
5577950	TCF150R5SLR25MB	15,00	25	96,5	75,5	0,55	56,00	B	TCF050204BP	TCF060203BC
5577951	TCF155R5SLR25MB	15,50	25	100,1	78,1	0,56	56,00	B	TCF050204BP	TCF060203BC
5577952	TCF160R5SLR25MB	16,00	25	102,6	80,6	0,58	56,00	B	TCF050204BP	TCF060203BC
5577953	TCF165R5SLR25MB	16,50	25	106,1	83,1	0,60	56,00	B	TCF050204BP	TCF060203BC
5577954	TCF170R5SLR25MB	17,00	25	108,6	85,6	0,61	56,00	B	TCF050204BP	TCF060203BC
5577955	TCF175R5SLR25MB	17,50	25	112,1	88,1	0,63	56,00	B	TCF050204BP	TCF060203BC
5577956	TCF180R5SLR25MB	18,00	25	114,6	90,6	0,64	56,00	B	TCF050204BP	TCF060203BC
5577957	TCF185R5SLR25MB	18,50	25	118,2	93,2	0,65	56,00	B	TCF050204BP	TCF060203BC
5578844	TCF190R5SLR25MC	19,00	25	120,7	95,7	0,68	56,00	C	TCF070306CP	TCF070304CC
5578845	TCF195R5SLR25MC	19,50	25	124,2	98,2	0,71	56,00	C	TCF070306CP	TCF070304CC
5578846	TCF200R5SLR25MC	20,00	25	126,7	100,7	0,72	56,00	C	TCF070306CP	TCF070304CC
5578847	TCF205R5SLR25MC	20,50	25	130,2	103,2	0,74	56,00	C	TCF070306CP	TCF070304CC
5578848	TCF210R5SLR25MC	21,00	25	133,8	105,8	0,75	56,00	C	TCF070306CP	TCF070304CC
5578849	TCF220R5SLR25MC	22,00	25	139,8	110,8	0,78	56,00	C	TCF070306CP	TCF070304CC
5578850	TCF225R5SLR25MC	22,50	25	142,3	113,3	0,79	56,00	C	TCF070306CP	TCF070304CC
5578851	TCF230R5SLR25MC	23,00	25	145,8	115,8	0,80	56,00	C	TCF070306CP	TCF070304CC
5537838	TCF240R5SLR25MD	24,00	25	148,9	120,9	0,87	56,00	D	TCF080308DP	TCF090305DC
5537839	TCF250R5SLR32MD	25,00	32	155,9	125,9	0,91	60,00	D	TCF080308DP	TCF090305DC
5537840	TCF260R5SLR32MD	26,00	32	161,9	130,9	0,94	60,00	D	TCF080308DP	TCF090305DC
5537841	TCF265R5SLR32MD	26,50	32	165,5	133,5	0,95	60,00	D	TCF080308DP	TCF090305DC
5537842	TCF270R5SLR32MD	27,00	32	168,0	136,0	0,97	60,00	D	TCF080308DP	TCF090305DC
5537843	TCF280R5SLR32MD	28,00	32	174,0	141,0	0,99	60,00	D	TCF080308DP	TCF090305DC
5537844	TCF290R5SLR32MD	29,00	32	180,0	146,0	1,02	60,00	D	TCF080308DP	TCF090305DC
5537958	TCF300R5SLR32ME	30,00	32	183,1	151,1	1,09	60,00	E	TCF100408EP	TCF120405EC
5537959	TCF310R5SLR32ME	31,00	32	189,1	156,1	1,12	60,00	E	TCF100408EP	TCF120405EC
5537960	TCF320R5SLR32ME	32,00	32	195,2	161,2	1,15	60,00	E	TCF100408EP	TCF120405EC
5537961	TCF330R5SLR40ME	33,00	40	202,2	166,2	1,18	70,00	E	TCF100408EP	TCF120405EC
5537962	TCF340R5SLR40ME	34,00	40	208,2	171,2	1,21	70,00	E	TCF100408EP	TCF120405EC
5537963	TCF350R5SLR40ME	35,00	40	214,2	176,2	1,24	70,00	E	TCF100408EP	TCF120405EC
5537964	TCF360R5SLR40ME	36,00	40	220,3	181,3	1,27	70,00	E	TCF100408EP	TCF120405EC
5578629	TCF370R5SLR40MF	37,00	40	226,3	186,3	1,35	70,00	F	TCF120412FP	TCF150406FC
5578640	TCF375R5SLR40MF	37,50	40	228,9	188,9	1,36	70,00	F	TCF120412FP	TCF150406FC
5578641	TCF380R5SLR40MF	38,00	40	232,4	191,4	1,38	70,00	F	TCF120412FP	TCF150406FC
5578642	TCF390R5SLR40MF	39,00	40	238,4	196,4	1,41	70,00	F	TCF120412FP	TCF150406FC
5578643	TCF400R5SLR40MF	40,00	40	243,4	201,4	1,45	70,00	F	TCF120412FP	TCF150406FC
5578644	TCF410R5SLR40MF	41,00	40	249,5	206,5	1,48	70,00	F	TCF120412FP	TCF150406FC
5578645	TCF420R5SLR40MF	42,00	40	255,5	211,5	1,51	70,00	F	TCF120412FP	TCF150406FC
5578646	TCF430R5SLR40MF	43,00	40	261,5	216,5	1,53	70,00	F	TCF120412FP	TCF150406FC
5578647	TCF440R5SLR40MF	44,00	40	267,6	221,6	1,56	70,00	F	TCF120412FP	TCF150406FC
5578648	TCF450R5SLR40MF	45,00	40	273,6	226,6	1,59	70,00	F	TCF120412FP	TCF150406FC
5578751	TCF460R5SLR40MG	46,00	40	274,7	231,7	1,67	70,00	G	TCF150512GP	TCF180508GC
5578752	TCF470R5SLR40MG	47,00	40	280,7	236,7	1,70	70,00	G	TCF150512GP	TCF180508GC
5578753	TCF480R5SLR40MG	48,00	40	286,7	241,7	1,73	70,00	G	TCF150512GP	TCF180508GC
5578754	TCF490R5SLR40MG	49,00	40	292,8	246,8	1,76	70,00	G	TCF150512GP	TCF180508GC
5578755	TCF500R5SLR40MG	50,00	40	297,8	251,8	1,79	70,00	G	TCF150512GP	TCF180508GC
5578756	TCF505R5SLR40MG	50,50	40	301,3	254,3	1,80	70,00	G	TCF150512GP	TCF180508GC
5578757	TCF510R5SLR40MG	51,00	40	303,8	256,8	1,81	70,00	G	TCF150512GP	TCF180508GC
5578758	TCF520R5SLR40MG	52,00	40	309,8	261,8	1,84	70,00	G	TCF150512GP	TCF180508GC
5578759	TCF530R5SLR40MG	53,00	40	315,9	266,9	1,87	70,00	G	TCF150512GP	TCF180508GC
5578760	TCF540R5SLR40MG	54,00	40	321,9	271,9	1,89	70,00	G	TCF150512GP	TCF180508GC
5578761	TCF550R5SLR40MG	55,00	40	326,9	276,9	1,92	70,00	G	TCF150512GP	TCF180508GC
5578762	TCF560R5SLR40MG	56,00	40	332,9	281,9	1,94	70,00	G	TCF150512GP	TCF180508GC
5538659	TCF570R5SLR40MH	57,00	40	333,1	287,1	2,06	70,00	H	TCF180614HP	TCF210608HC



Top Cut 4

5xD • SLR Shanks • *Continued*

Order Number	Catalog Number	D1	D	L1	L4 Max	L5	LS	SSC	Periphery Insert	Center Insert
5538680	TCF580R5SLR40MH	58,00	40	339,1	292,1	2,09	70,00	H	TCF180614HP	TCF210608HC
5538681	TCF590R5SLR40MH	59,00	40	345,1	297,1	2,12	70,00	H	TCF180614HP	TCF210608HC
5538682	TCF600R5SLR40MH	60,00	40	350,1	302,1	2,15	70,00	H	TCF180614HP	TCF210608HC
5538683	TCF610R5SLR40MH	61,00	40	356,2	307,2	2,18	70,00	H	TCF180614HP	TCF210608HC
5538684	TCF620R5SLR40MH	62,00	40	362,2	312,2	2,20	70,00	H	TCF180614HP	TCF210608HC
5538685	TCF630R5SLR40MH	63,00	40	368,2	317,2	2,23	70,00	H	TCF180614HP	TCF210608HC
5538686	TCF640R5SLR40MH	64,00	40	373,3	322,3	2,26	70,00	H	TCF180614HP	TCF210608HC
5538687	TCF650R5SLR40MH	65,00	40	379,3	327,3	2,28	70,00	H	TCF180614HP	TCF210608HC
5538688	TCF660R5SLR40MH	66,00	40	385,3	332,3	2,31	70,00	H	TCF180614HP	TCF210608HC
5538689	TCF670R5SLR40MH	67,00	40	390,3	337,3	2,33	70,00	H	TCF180614HP	TCF210608HC
5538700	TCF680R5SLR40MH	68,00	40	396,4	342,4	2,36	70,00	H	TCF180614HP	TCF210608HC

D	LS
20,00	50
25,00	56
32,00	60
40,00	70

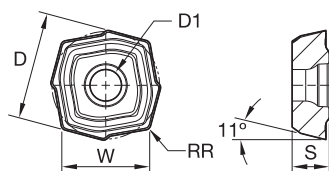
WARNING

During through-hole operations, a slug or disc is produced as the tool breaks through the workpiece.

When the drill is stationary and the workpiece is rotating, this slug may be hurled from the chuck by centrifugal force.

Provide adequate shielding to protect bystanders.





P	Blue	○	●
M	Yellow	○	●
K	Red	○	●
N	Green	○	●
S	Orange	○	●
H	Grey	○	●

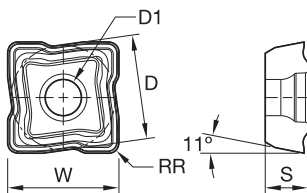
● Primary
 ○ Secondary

Top Cut 4

Center Inserts • Roughing V34

Catalog Number	D	D1	W	S	RR	SSC	WU25CH	WU40PH
TCF040203ACV34	4,47	2,10	3,65	2,00	0,300	A	5541817	5541818
TCF060203BCV34	6,00	2,40	4,90	2,40	0,300	B	5542602	5542604
TCF070304CCV34	7,59	2,60	6,20	2,80	0,400	C	5542642	5542643
TCF090305DCV34	9,55	2,80	7,80	3,00	0,500	D	5538554	5538555
TCF120405ECV34	12,00	3,40	9,80	3,60	0,500	E	5538603	5538604
TCF150406FCV34	14,94	4,80	12,20	4,20	0,600	F	5542623	5542624
TCF180508GCV34	17,88	6,00	14,60	5,40	0,800	G	5542475	5542476
TCF210608HCV34	21,68	7,50	17,70	6,50	0,800	H	5542002	5542003

NOTE: For application-specific insert selection, please refer to the application data on page 22.
 SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.



P	Blue	○	●
M	Yellow	○	●
K	Red	○	●
N	Green	○	●
S	Orange	○	●
H	Grey	○	●

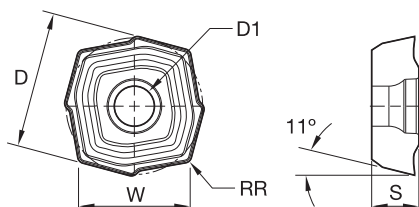
- Primary
- Secondary

Top Cut 4

Periphery Inserts • Roughing V34

Catalog Number	D	D1	W	S	RR	SSC	WP10CH	WU25CH	WU40PH
TCF040204APV34	4,14	2,10	4,40	2,00	0,400	A	5541843	5541841	5541842
TCF050204BPV34	5,07	2,40	5,40	2,40	0,400	B	5542620	5542608	5542609
TCF070306CPV34	6,67	2,60	7,10	2,80	0,600	C	5542648	5542646	5542647
TCF080308DPV34	8,08	2,80	8,60	3,00	0,800	D	5538600	5538558	5538559
TCF100408EPV34	9,96	3,40	10,60	3,60	0,800	E	5538610	5538608	5538609
TCF120412FPV34	12,59	4,80	13,40	4,20	1,200	F	5542629	5542627	5542628
TCF150512GPV34	15,13	6,00	16,10	5,40	1,200	G	5542601	5542479	5542600
TCF180614HPV34	18,04	7,50	19,20	6,50	1,400	H	5542008	5542006	5542007

NOTE: For application-specific insert selection, please refer to the application data on page 22.
SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.



- Primary
- Secondary

P	
M	
K	
N	
S	
H	

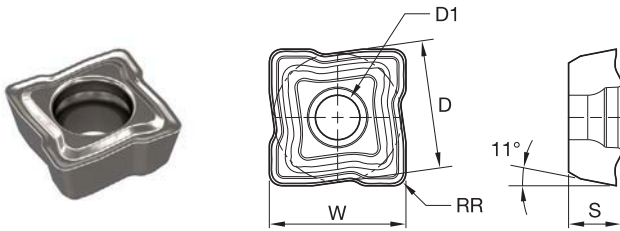
Top Cut 4

Center Inserts • Aluminum V36

Catalog Number	D	D1	W	S	RR	SSC	WN10PH
TCF040203ACV36	4,47	2,10	3,65	2,00	0,300	A	6407887
TCF060203BCV36	6,00	2,40	4,90	2,40	0,300	B	6372041
TCF070304CCV36	7,59	2,60	6,20	2,80	0,400	C	6372042
TCF090305DCV36	9,55	2,80	7,80	3,00	0,500	D	6372045
TCF120405ECV36	12,00	3,40	9,80	3,60	0,500	E	6372047
TCF150406FCV36	14,94	4,80	12,20	4,20	0,600	F	6346757
TCF180508GCV36	17,88	6,00	14,60	5,40	0,800	G	6407890
TCF210608HCV36	21,68	7,50	17,70	6,50	0,800	H	6372049

NOTE: For application-specific insert selection, please refer to the application data on page 22.

SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.



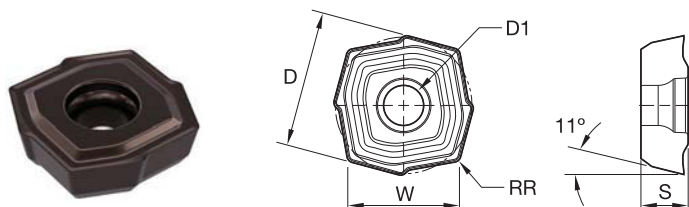
Top Cut 4

Periphery Inserts • Aluminum V36

P	Primary	●
M	Secondary	○
K		
N		
S		
H		

Catalog Number	D	D1	W	S	RR	SSC	WN10PH
TCF040204APV36	4,14	2,10	4,40	2,00	0,400	A	6407888
TCF050204BPV36	5,07	2,40	5,40	2,40	0,400	B	6371850
TCF070306CPV36	6,67	2,60	7,10	2,80	0,600	C	6372043
TCF080308DPV36	8,08	2,80	8,60	3,00	0,800	D	6372044
TCF100408EPV36	9,96	3,40	10,60	3,60	0,800	E	6372046
TCF120412FPV36	12,59	4,80	13,40	4,20	1,200	F	6348893
TCF150512GPV36	15,13	6,00	16,10	5,40	1,200	G	6407889
TCF180614HPV36	18,04	7,50	19,20	6,50	1,400	H	6372048

NOTE: For application-specific insert selection, please refer to the application data on page 22.
SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.



Top Cut 4

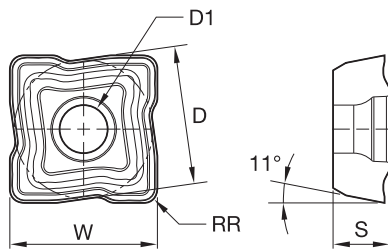
Center Inserts • Roughing V36

- Primary
- Secondary

P	○	●	○
M	○	●	●
K	○	●	●
N	○	●	●
S	○	●	●
H	○	●	●

Catalog Number	D	D1	W	S	RR	SSC	WU25CH	WU40PH	WM35PH
TCF040203ACV36	4,47	2,10	3,65	2,00	0,300	A	5541819	5541840	7301397
TCF060203BCV36	6,00	2,40	4,90	2,40	0,300	B	5542606	5542607	7301398
TCF070304CCV36	7,59	2,60	6,20	2,80	0,400	C	5542644	5542645	7301399
TCF090305DCV36	9,55	2,80	7,80	3,00	0,500	D	5538556	5538557	7301400
TCF120405ECV36	12,00	3,40	9,80	3,60	0,500	E	5538606	5538607	7301421
TCF150406FCV36	14,94	4,80	12,20	4,20	0,600	F	5542625	5542626	7301422
TCF180508GCV36	17,88	6,00	14,60	5,40	0,800	G	5542477	5542478	7301423
TCF210608HCV36	21,68	7,50	17,70	6,50	0,800	H	5542004	5542005	7301424

NOTE: For application-specific insert selection, please refer to the application data on page 22.
SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.



P	●	○	○	○
M	●	○	○	○
K	●	○	○	○
N	●	○	○	○
S	●	○	○	○
H	●	○	○	○

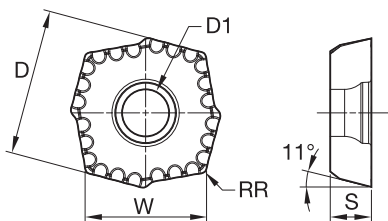
● Primary
○ Secondary

Top Cut 4

Periphery Inserts • Roughing V36

Catalog Number	D	D1	W	S	RR	SSC	WIJ25CH	WIJ40PH	WM35PH
TCF040204APV36	4,14	2,10	4,40	2,00	0,400	A	5541844	5541845	7301433
TCF050204BPV36	5,07	2,40	5,40	2,40	0,400	B	5542621	5542622	7301435
TCF070306CPV36	6,67	2,60	7,10	2,80	0,600	C	5542649	5542650	7301436
TCF080308DPV36	8,08	2,80	8,60	3,00	0,800	D	5538601	5538602	7301437
TCF100408EPV36	9,96	3,40	10,60	3,60	0,800	E	5538611	5538612	7301438
TCF120412FPV36	12,59	4,80	13,40	4,20	1,200	F	5542640	5542641	7301439
TCF150512GVPV36	15,13	6,00	16,10	5,40	1,200	G	5542603	5542605	7301440
TCF180614HPV36	18,04	7,50	19,20	6,50	1,400	H	5542009	5542020	7301441

NOTE: For application-specific insert selection, please refer to the application data on page 22.
SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.



P	Blue	●	○
M	Yellow	●	○
K	Red	●	○
N	Green	●	○
S	Orange	●	○
H	Grey	●	○

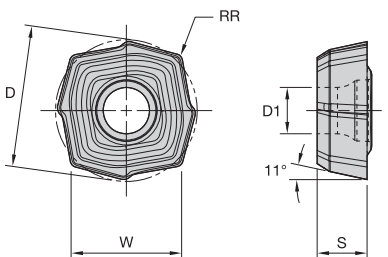
● Primary
 ○ Secondary

Top Cut 4

Center Inserts • Long Chip Materials V38

Catalog Number	D	D1	W	S	RR	SSC	WU40PH	WM35PH
TCF040203ACV38	4,47	2,10	3,65	2,00	0,300	A	6429458	7301425
TCF060203BCV38	6,00	2,40	4,90	2,40	0,300	B	6429459	7301426
TCF070304CCV38	7,59	2,60	6,20	2,80	0,400	C	6429460	7301427
TCF090305DCV38	9,55	2,80	7,80	3,00	0,500	D	6429461	7301428
TCF120405ECV38	12,00	3,40	9,80	3,60	0,500	E	6429462	7301429
TCF150406FCV38	14,94	4,80	12,20	4,20	0,600	F	6429463	7301430
TCF180508GCV38	17,88	6,00	14,60	5,40	0,800	G	6324383	7301431
TCF210608HCV38	21,68	7,50	17,70	6,50	0,800	H	6429464	7301432

NOTE: For application-specific insert selection, please refer to the application data on page 22.
SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.



P	Blue	●	○
M	Yellow	●	○
K	Red	●	○
N	Green	●	○
S	Orange	●	○
H	Grey	●	○

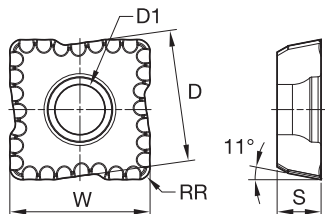
● Primary
 ○ Secondary

Top Cut 4

Center Inserts • Universal DU

Catalog Number	D	D1	W	S	RR	SSC	WU20PH
TCF070304CCDU	7,59	2,60	6,20	2,80	0,400	C	6858590
TCF090305DCDU	9,55	2,80	7,80	3,00	0,500	D	6858611
TCF120405ECDU	12,00	3,40	9,80	3,60	0,500	E	6858612
TCF150406FCDU	14,94	4,80	12,20	4,20	0,600	F	6858613

NOTE: For application-specific insert selection, please refer to the application data on page 22.
SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.



P	●	●	○
M	●	●	●
K	●	○	●
N	●	●	●
S	●	●	●
H	●	●	●

- Primary
- Secondary

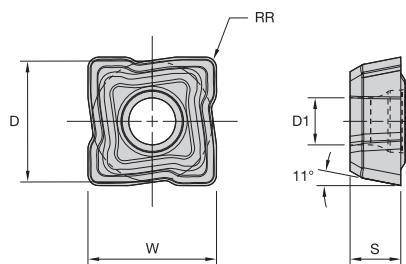
Top Cut 4

Periphery Inserts • Long Chip Materials V38

Catalog Number	D	D1	W	S	RR	SSC	WU25CH	WU40PH	WM35PH
TCF040204APV38	4,14	2,10	4,40	2,00	0,400	A	6429424	6429425	7301442
TCF050204BPV38	5,07	2,40	5,40	2,40	0,400	B	6429426	6429427	7301443
TCF070306CPV38	6,67	2,60	7,10	2,80	0,600	C	6429466	6429428	7301444
TCF080308DPV38	8,08	2,80	8,60	3,00	0,800	D	6429429	6429430	7301445
TCF100408EPV38	9,96	3,40	10,60	3,60	0,800	E	6429451	6429452	7301446
TCF120412FPV38	12,59	4,80	13,40	4,20	1,200	F	6429453	6429454	7301447
TCF150512GPV38	15,13	6,00	16,10	5,40	1,200	G	6429455	6324381	7301448
TCF180614HPV38	18,04	7,50	19,20	6,50	1,400	H	6429456	6429457	7301450

NOTE: For application-specific insert selection, please refer to the application data on page 22.

SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.



P	●	●
M	●	●
K	●	●
N	●	●
S	●	●
H	●	●

- Primary
- Secondary

Top Cut 4

Periphery Inserts • Universal DU

Catalog Number	D	D1	W	S	RR	SSC	WU20PH
TCF070306CPDU	6,67	2,60	7,10	2,80	0,600	C	6858586
TCF080308DPDU	8,08	2,80	8,60	3,00	0,800	D	6858587
TCF100408EPDU	9,96	3,40	10,60	3,60	0,800	E	6858588
TCF120412FPDU	12,59	4,80	13,40	4,20	1,200	F	6858589

NOTE: For application-specific insert selection, please refer to the application data on page 22.

SSC = Pocket Seat Reference. To correspond with the SSC on the toolholder.

Top Cut 4 • Insert Selection Guide

Material Group	Geometry	Light Machining		General Purpose		Heavy Machining	
		periphery insert	center insert	periphery insert	center insert	periphery insert	center insert
P1	V38/DU	WU25CH	WU40PH/WU20PH	WU40PH/WU20PH	WU40PH/WU20PH	WU40PH/WU20PH	WU40PH/WU20PH
P2–P4	V34/DU	WPK10CH	WU40PH/WU20PH	WU25CH/WU20PH	WU40PH/WU20PH	WU40PH/WU20PH	WU40PH/WU20PH
P5–P6	V36/DU	WU25CH	WU40PH/WU20PH	WU40PH/WU20PH	WU40PH/WU20PH	WU40PH/WU20PH	WU40PH/WU20PH
M1–M3	V36/DU	WM35PH/WU25CH	WM35PH/WU40PH/WU20PH	WM35PH/WU40PH/WU20PH	WM35PH/WU40PH/WU20PH	WM35PH/WU40PH/WU20PH	WM35PH/WU40PH/WU20PH
K1–K3	V34/DU	WPK10CH	WU40PH/WU20PH	WU40PH/WU20PH	WU40PH/WU20PH	WU40PH/WU20PH	WU40PH/WU20PH
N1–N4	V36	WN10PH	WN10PH	WN10PH	WN10PH	WN10PH	WN10PH
S1–S4	V38/DU	WM35PH/WU40PH/WU20PH	WM35PH/WU40PH/WU20PH	WM35PH/WU40PH/WU20PH	WM35PH/WU40PH/WU20PH	WM35PH/WU40PH/WU20PH	WM35PH/WU40PH/WU20PH

NOTE: All speed conditions are for stable conditions. For unstable conditions, it is suggested to reduce starting speeds by 10%. For interrupted cuts, reduce speed by 20%.

For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above data.

For 5 x D, diameter range 12–23,99mm (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above data.

For 5 x D, diameter range 25–68mm (insert sizes D to H), it is highly recommended to start with feed and speed values reduced by 15% less than above data.

For 4 x D and 5 x D, it is recommended to reduce feed rate during entry and exit by 30–50%.

Top Cut 4 • Drill Depth • X-Offset Capabilities • Hole Tolerance

Insert size	Diameter Range (mm)	2 x D and 3 x D		4 x D		5 x D	
		X-offset value max. in mm	D1 max value	X-offset value max. in mm	D1 max value	X-offset value max.	D1 max value
A	12,00–13,99	0,5	D1 + 1mm	0,5	D1 + 1mm	—	—
B	14,00–18,99	0,5	D1 + 1mm	0,5	D1 + 1mm	—	—
C	19,00–23,99	0,5	D1 + 1mm	0,5	D1 + 1mm	—	—
D	24,00–29,99	0,8	D1 + 1,6mm	0,8	D1 + 1mm	—	—
E	30,00–36,99	0,8	D1 + 1,6mm	0,8	D1 + 1mm	—	—
F	37,00–45,99	0,8	D1 + 1,6mm	0,8	D1 + 1mm	—	—
G	46,00–56,99	1	D1 + 2mm	0,8	D1 + 1mm	—	—
H	57,00–68,00	1	D1 + 2mm	0,8	D1 + 1mm	—	—

NOTE: All speed conditions are for stable conditions. For unstable conditions, it is suggested to reduce starting speeds by 10%. For interrupted cuts, reduce speed by 20%.

For 4 x D, it is highly recommended to start with feed and speed values reduced by 10% less than above data.

For 5 x D, diameter range .473–.938" (insert sizes A to C), it is highly recommended to start with feed and speed values reduced by 20% less than above data.

For 5 x D, diameter range .969–2.5" (inserts sizes D to H), it is highly recommended to start with feed and speed values reduced by 15% less than above data.

For 4 x D and 5 x D, it is recommended to reduce feed rate during entry and exit by 30–50%.

Top Cut 4 • Screw Torque

Insert size	Periphery Insert	Center Insert	Torx Size	Tightening Torque Nm
A	TCF040204AP	TCF040203AC	T5	0,40
B	TCF050204BP	TCF060203BC	T6	0,53
C	TCF070306CP	TCF070304CC	T7	0,90
D	TCF080308DP	TCF090305DC	T8	1,10
E	TCF100408EP	TCF120405EC	T9	2,00
F	TCF120412FP	TCF150406FC	T15	4,00
G	TCF150512GP	TCF180508GC	T20	6,30
H	TCF180614HP	TCF210608HC	T25	8,80

Top Cut 4 • Cutting Data • Metric

TOP CUT 4 METRIC								Recommended Feed Rate by Diameter (2 & 3 L/D)													
Material Group	Material Sub-group	Geometry	Grade		Cutting Speed - V _c			Inboard Insert Outboard Insert Insert Ø (mm)	TCF040203AC TCF040204AP 12.00–13.99mm			TCF060203BC TCF050204BP 14.00–18.99mm			TCF070304CC TCF070306CP 19.00–23.99mm			TCF090305DC TCF080308DP 24.00–29.99mm			
					Range - m/min																
			Center	Periphery	min	Starting Value	max	Feed - f _z mm/rev	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	
P	0	V38	WM35PH	WM35PH	280	305	325	mm/rev	0.05	0.07	0.09	0.05	0.08	0.11	0.05	0.09	0.12	0.06	0.1	0.14	
P	1	V34	WU40PH	WPK10CH	280	305	325	mm/rev	0.06	0.10	0.14	0.07	0.11	0.14	0.07	0.12	0.17	0.08	0.15	0.22	
P	2	V34	WU40PH	WPK10CH	280	305	325	mm/rev	0.06	0.10	0.14	0.07	0.12	0.16	0.07	0.12	0.17	0.08	0.15	0.22	
P	3	V34	WU40PH	WPK10CH	235	265	290	mm/rev	0.06	0.10	0.14	0.07	0.12	0.16	0.07	0.12	0.17	0.08	0.15	0.22	
P	4	V34	WU40PH	WPK10CH	200	235	270	mm/rev	0.06	0.10	0.14	0.07	0.12	0.16	0.07	0.12	0.17	0.08	0.15	0.22	
P	5	V36	WU40PH	WU25CH	160	180	200	mm/rev	0.06	0.10	0.14	0.07	0.12	0.16	0.07	0.12	0.17	0.08	0.15	0.22	
P	6	V36	WU40PH	WU25CH	160	180	200	mm/rev	0.06	0.10	0.14	0.07	0.12	0.16	0.07	0.12	0.17	0.08	0.15	0.22	
M	1	V36	WM35PH	WM35PH	120	165	210	mm/rev	0.05	0.07	0.09	0.05	0.08	0.11	0.05	0.09	0.12	0.06	0.10	0.14	
M	2	V36	WM35PH	WM35PH	110	150	190	mm/rev	0.05	0.07	0.09	0.05	0.08	0.11	0.05	0.09	0.12	0.06	0.10	0.14	
M	3	V36	WM35PH	WM35PH	90	130	170	mm/rev	0.04	0.07	0.08	0.04	0.07	0.09	0.04	0.08	0.11	0.05	0.09	0.12	
K	1	V34	WU40PH	WPK10CH	180	225	270	mm/rev	0.07	0.11	0.15	0.08	0.13	0.17	0.09	0.17	0.24	0.09	0.60	1.10	
K	2	V34	WU40PH	WPK10CH	160	200	235	mm/rev	0.07	0.11	0.15	0.08	0.13	0.17	0.09	0.17	0.24	0.09	0.17	0.25	
K	3	V34	WU40PH	WPK10CH	160	200	235	mm/rev	0.07	0.11	0.15	0.08	0.13	0.17	0.09	0.17	0.24	0.09	0.17	0.25	
N	1	V36	WN10PH	WN10PH	315	450	585	mm/rev	0.06	0.10	0.14	0.07	0.12	0.16	0.08	0.14	0.19	0.08	0.15	0.22	
N	2	V36	WN10PH	WN10PH	270	360	450	mm/rev	0.06	0.10	0.14	0.07	0.12	0.16	0.08	0.14	0.19	0.08	0.15	0.22	
N	3	V36	WN10PH	WN10PH	270	360	450	mm/rev	0.06	0.10	0.14	0.07	0.12	0.16	0.08	0.14	0.19	0.08	0.15	0.22	
S	1	V36	WM35PH	WM35PH	55	65	70	mm/rev	0.05	0.06	0.07	0.05	0.07	0.09	0.05	0.08	0.11	0.06	0.09	0.11	
S	2	V36	WM35PH	WM35PH	45	55	65	mm/rev	0.05	0.06	0.07	0.05	0.07	0.09	0.05	0.08	0.11	0.06	0.09	0.11	
S	3	V36	WM35PH	WM35PH	65	75	80	mm/rev	0.05	0.06	0.07	0.05	0.07	0.09	0.05	0.08	0.11	0.06	0.09	0.11	
S	4	V36	WM35PH	WM35PH	65	75	80	mm/rev	0.05	0.06	0.07	0.05	0.07	0.09	0.05	0.08	0.11	0.06	0.09	0.11	

TOP CUT 4 METRIC								Recommended Feed Rate by Diameter (2 & 3 L/D)													
Material Group	Material Sub-group	Geometry	Grade		Cutting Speed - V _c			Inboard Insert Outboard Insert Insert Ø (mm)	TCF120405EC TCF100408EP 30.00–36.99mm			TCF150406FC TCF120412FP 37.00–45.99mm			TCF180508GC TCF150512GP 46.00–56.99mm			TCF210608HC TCF180614HP 57.00–68.00mm			
					Range - m/min				min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	min
			Center	Periphery	min	Starting Value	max	Feed - f _z mm/rev	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	min	Starting Value	max	
P	0	V38	WM35PH	WM35PH	280	305	325	mm/rev	0.07	0.12	0.16	0.07	0.13	0.18	0.08	0.13	0.18	0.08	0.14	0.20	
P	1	V34	WU40PH	WPK10CH	280	305	325	mm/rev	0.09	0.17	0.24	0.10	0.19	0.28	0.10	0.20	0.29	0.11	0.21	0.31	
P	2	V34	WU40PH	WPK10CH	280	305	325	mm/rev	0.09	0.17	0.24	0.10	0.19	0.28	0.10	0.20	0.29	0.11	0.21	0.31	
P	3	V34	WU40PH	WPK10CH	235	265	290	mm/rev	0.09	0.17	0.24	0.10	0.19	0.28	0.10	0.20	0.29	0.11	0.21	0.31	
P	4	V34	WU40PH	WPK10CH	200	235	270	mm/rev	0.09	0.17	0.24	0.10	0.19	0.28	0.10	0.20	0.29	0.11	0.21	0.31	
P	5	V36	WU40PH	WU25CH	160	180	200	mm/rev	0.09	0.17	0.24	0.10	0.19	0.28	0.10	0.20	0.29	0.11	0.21	0.31	
P	6	V36	WU40PH	WU25CH	160	180	200	mm/rev	0.09	0.17	0.24	0.10	0.19	0.28	0.10	0.20	0.29	0.11	0.21	0.31	
M	1	V36	WM35PH	WM35PH	120	165	210	mm/rev	0.07	0.12	0.16	0.07	0.12	0.17	0.08	0.14	0.19	0.08	0.15	0.21	
M	2	V36	WM35PH	WM35PH	110	150	190	mm/rev	0.07	0.12	0.16	0.07	0.12	0.17	0.08	0.14	0.19	0.08	0.15	0.21	
M	3	V36	WM35PH	WM35PH	90	130	170	mm/rev	0.06	0.10	0.14	0.06	0.11	0.15	0.07	0.12	0.16	0.07	0.13	0.18	
K	1	V34	WU40PH	WPK10CH	180	225	270	mm/rev	0.10	0.19	0.27	0.11	0.20	0.29	0.11	0.21	0.31	0.12	0.24	0.34	
K	2	V34	WU40PH	WPK10CH	160	200	235	mm/rev	0.10	0.19	0.27	0.11	0.20	0.29	0.11	0.21	0.31	0.12	0.24	0.34	
K	3	V34	WU40PH	WPK10CH	160	200	235	mm/rev	0.10	0.19	0.27	0.11	0.20	0.29	0.11	0.21	0.31	0.12	0.24	0.34	
N	1	V36	WN10PH	WN10PH	315	450	585	mm/rev	0.09	0.17	0.24	0.10	0.19	0.27	0.10	0.20	0.29	0.11	0.21	0.31	
N	2	V36	WN10PH	WN10PH	270	360	450	mm/rev	0.09	0.17	0.24	0.10	0.19	0.27	0.10	0.20	0.29	0.11	0.21	0.31	
N	3	V36	WN10PH	WN10PH	270	360	450	mm/rev	0.09	0.17	0.24	0.10	0.19	0.27	0.10	0.20	0.29	0.11	0.21	0.31	
S	1	V36	WM35PH	WM35PH	55	65	70	mm/rev	0.07	0.10	0.13	0.07	0.11	0.14	0.08	0.12	0.15	0.08	0.13	0.17	
S	2	V36	WM35PH	WM35PH	45	55	65	mm/rev	0.07	0.10	0.13	0.07	0.11	0.14	0.08	0.12	0.15	0.08	0.13	0.17	
S	3	V36	WM35PH	WM35PH	65	75	80	mm/rev	0.07	0.10	0.13	0.07	0.11	0.14	0.08	0.12	0.15	0.08	0.13	0.17	
S	4	V36	WM35PH	WM35PH	65	75	80	mm/rev	0.07	0.10	0.13	0.07	0.11	0.14	0.08	0.12	0.15	0.08	0.13	0.17	

Application Data • Top Cut 4

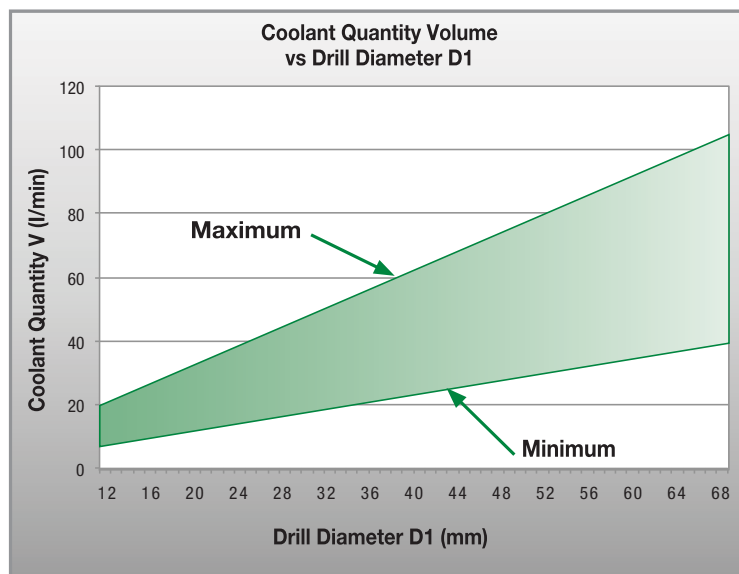
Top Cut 4 • Drill Depth • $2 \times D/3 \times D$ • Hole Tolerance Table

Insert size	Diameter Range (mm)	Hole Tolerance (mm)
A	12,00–13,99	+/- 0,20
B	14,00–18,99	+/- 0,20
C	19,00–23,99	+/- 0,20
D	24,00–29,99	+/- 0,20
E	30,00–36,99	+/- 0,20
F	37,00–45,99	+/- 0,25
G	46,00–56,99	+/- 0,25
H	57,00–68,00	+/- 0,28

Top Cut 4 • Drill Depth • $4 \times D/5 \times D$ • Hole Tolerance Table

Insert size	Diameter Range (mm)	Hole Tolerance (mm)
A	12,00–13,99	+/- 0,35
B	14,00–18,99	+/- 0,35
C	19,00–23,99	+/- 0,35
D	24,00–29,99	+/- 0,35
E	30,00–36,99	+/- 0,35
F	37,00–45,99	+/- 0,38
G	46,00–56,99	+/- 0,38
H	57,00–68,00	+/- 0,42

Coolant Requirement/Recommendation





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