

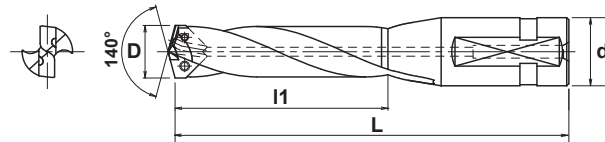
# Indexable S-Cut

**INCH**

## TSD-AMS Type (3XD)-

- Same features as the brazed S-Cut drill, except insert is indexable with double screw mounting which allows for high repeatability.

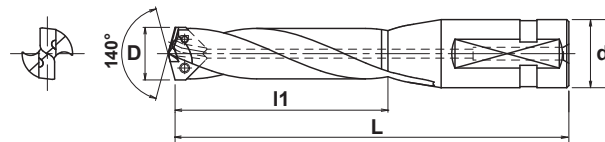
Diameter	Tolerance
3/4" -up to 1-3/16"	+0 / -0.021



### Specifications

CATALOG NUMBER	STK	DIMENSIONS				INSERT	PARTS	
		D	I1	L	d		SCREW	WRENCH
TSD-0750-AMS	•	3/4"	2.992	5.944	1.00	TS-0750	ESW-206 (2)	T-08
TSD-0781-AMS	•	25/32"	3.149	6.141	1.00	TS-0781	ESW-206 (2)	T-08
TSD-0812-AMS	•	13/16"	3.307	6.338	1.00	TS-0812	ESW-206 (2)	T-08
TSD-0875-AMS	•	7/8"	3.464	6.535	1.00	TS-0875	DSW-307H (2)	T-10
TSD-0938-AMS	•	15/16"	3.779	7.086	1.25	TS-0938	DSW-307H (2)	T-10
TSD-1000-AMS	•	1"	3.937	7.283	1.25	TS-1000	DSW-309 (2)	T-10
TSD-1047-AMS	•	1-3/64"	4.251	7.677	1.25	TS-1047	DSW-309 (2)	T-10
TSD-1062-AMS	•	1-1/16"	4.251	7.677	1.25	TS-1062	DSW-309 (2)	T-10
TSD-1093-AMS	•	1-3/32"	4.409	7.874	1.25	TS-1093	CSW-3595 (2)	T-15
TSD-1125-AMS	•	1-1/8"	4.566	8.070	1.25	TS-1125	CSW-3595 (2)	T-15
TSD-1188-AMS	•	1-3/16"	4.724	8.267	1.25	TS-1188	CSW-3595 (2)	T-15

## TSD-AML Type (5XD)-



### Specifications

CATALOG NUMBER	STK	DIMENSIONS				INSERT	PARTS	
		D	I1	L	d		SCREW	WRENCH
TSD-0750-AML		3/4"	4.566	7.519	1.00	TS-0750	ESW-206 (2)	T-08
TSD-0781-AML		25/32"	4.724	7.716	1.00	TS-0781	ESW-206 (2)	T-08
TSD-0812-AML		13/16"	4.881	7.913	1.00	TS-0812	ESW-206 (2)	T-08
TSD-0875-AML		7/8"	5.236	8.307	1.00	TS-0875	DSW-307H (2)	T-10
TSD-0938-AML		15/16"	5.748	9.055	1.25	TS-0938	DSW-307H (2)	T-10
TSD-1000-AML		1"	5.905	9.251	1.25	TS-1000	DSW-309 (2)	T-10
TSD-1125-AML		1-1/8"	6.929	10.430	1.25	TS-1125	CSW-3595 (2)	T-15
TSD-1188-AML		1-3/16"	7.086	10.620	1.25	TS-1188	CSW-3595 (2)	T-15



**INCH**

# Indexable S-Cut

## Insert

	CATALOG NUMBER	DIMENSIONS	STOCK	
		D	JC5025	
	TS-0750	3/4"	•	
	TS-0781	25/32"	•	
	TS-0812	13/16"	•	
	TS-0875	7/8"	•	
	TS-0938	15/16"	•	
	TS-1000	1"	•	
	TS-1047	1-3/64"	•	
	TS-1062	1-1/16"	•	
	TS-1093	1-3/32"	•	
	TS-1125	1-1/8"	•	
	TS-1188	1-3/16"	•	

## Recommended Cutting Data

Work Material	Rate	Tool Diameter										
		.750	.781	.812	.875	.938	1.000	1.047	1.062	1.093	1.125	1.187
Low Carbon Steel AISI 1020	RPM	1,530	1,470	1,410	1,310	1,220	1,150	1,090	1,080	1,050	1,020	960
	IPM	15.3	14.7	14.1	13.1	12.2	13.8	13.1	13.0	12.6	12.2	11.5
Med. Carbon Steel AISI 1050	RPM	1,270	1,220	1,180	1,090	1,020	950	910	900	870	850	800
	IPM	15.2	14.6	14.2	13.1	12.2	11.4	10.9	10.8	10.4	10.2	9.6
Med. Carbon Steel (Heat Treated/45RC)	RPM	1,020	980	940	870	810	760	730	720	700	680	640
	IPM	6.1	5.9	5.6	5.2	4.9	4.6	4.4	4.3	4.2	4.1	3.8
Alloy Steel AISI 4140	RPM	1,270	1,220	1,180	1,090	1,020	950	910	900	870	850	800
	IPM	12.7	12.2	11.8	10.9	10.2	11.4	10.9	10.8	10.4	10.2	9.6
Alloy Tool Steel AISI H-13	RPM	770	740	710	660	610	580	550	540	530	510	490
	IPM	7.7	7.4	7.1	6.6	6.1	5.8	5.5	5.4	5.3	5.1	4.9
Hardened Alloy (Heat Treated/45RC)	RPM	510	490	470	440	410	380	370	360	350	340	320
	IPM	4.08	3.92	3.76	3.52	3.28	3.04	2.96	2.88	2.8	2.72	2.56
Stainless Steel AISI 304	RPM	1,020	980	940	870	810	760	730	720	700	680	640
	IPM	10.2	9.8	9.4	8.7	8.1	7.6	7.3	7.2	7.0	6.8	6.4
Cast Iron	RPM	1,530	1,470	1,410	1,310	1,220	1,150	1,090	1,080	1,050	1,020	960
	IPM	23.0	22.1	21.2	19.7	18.3	17.3	16.4	16.2	15.8	15.3	14.4
Aluminum Alloy 6160 Heat Treated	RPM	1,530	1,470	1,410	1,310	1,220	1,150	1,090	1,080	1,050	1,020	960
	IPM	12.2	11.8	11.3	10.5	9.8	9.2	8.7	8.6	8.4	8.2	7.7