NEW

MOLDINO
The Edge To Innovation

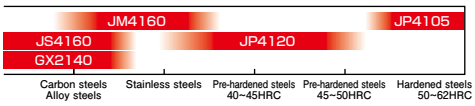
TD4N type

Radius Mill TD4N

JS4160 grade added for outstanding cutting performance when working with carbon or alloy steel

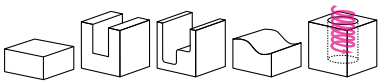
MOLDINO Tool Engineering, Ltd.
New Product News | No.1604E-18 | 2026-2

Technology



Applications

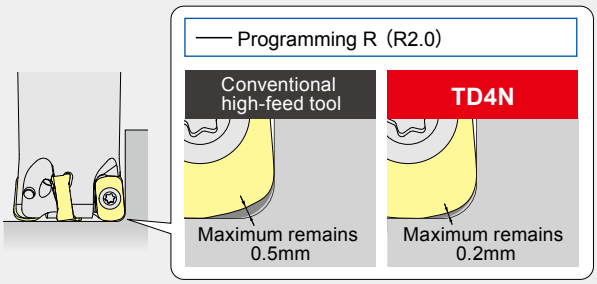
Roughing



Features 01 Reduces uncut remnants on work pieces

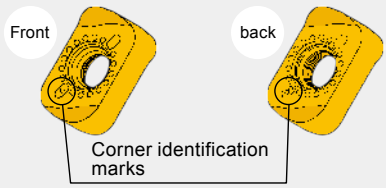
The cutting edge shape was reviewed for TD4N so that remains are reduced. This enables the load on the next process to be reduced by up to 40% compared to conventional products.

・Since it is difficult to create tool shape definitions in CAM for the complicated cutting edge shapes of high-feed tools, in many cases the tools are used with the definition for a simple R radius tool. The differences between this definition and the actual tool shape result in remains that cannot be checked on CAM and become more work for the next process.

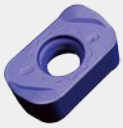


Features 02 Economical 4-corner inserts with chip breakers for various applications

・By making it possible to use both the front and back sides of inserts, 4 corners can be used. The inserts are provided with a large rake angle which exhibits an excellent cutting force reduction effect even when compared to general positive-shape inserts.

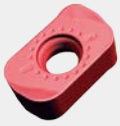


Features of insert breaker



C breaker

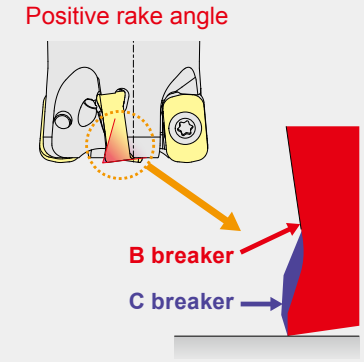
Corresponds to our general high-feed-type inserts (EDNW, EPNW, WDNW, SDNW), and is resistant to chip jamming, vibrations, and crater wear.



B breaker

Enables reduced cutting force when cutting work materials such as stainless steels, etc. that require free-cutting performance.

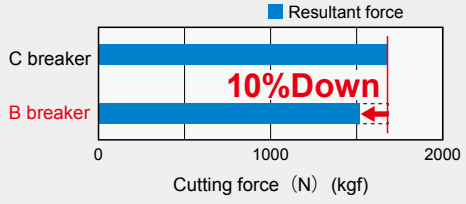
Magnified view of cutting edge cross section



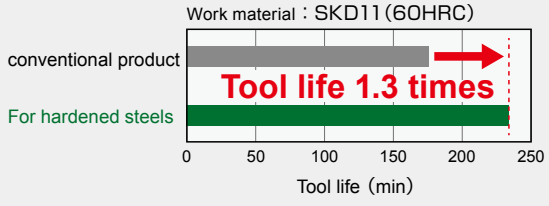
Features of insert for high-hardness materials

High-precision G-class insert suppresses dispersion in tool life.
Employs JP4105, a grade for high-hardness materials which provides long service life for machining 50HRC or harder matrials.

Comparison of cutting force

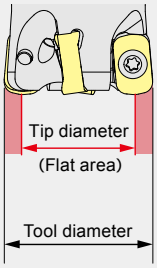


Tool life comparison with conventional products

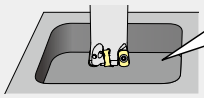


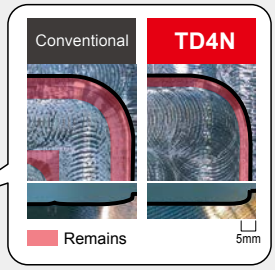
Features 03 Large tip diameter for excellent handling

- Compared to conventional high-feed tools, TD4N has a large tip diameter, which suppresses the generation of remains which easily occur on the bottom surface of machined areas. In addition, since the cutting width (*a*e) can be set to a large value, this is also effective for improving machining efficiency.



Photograph of machined surface at corner (viewed from above)

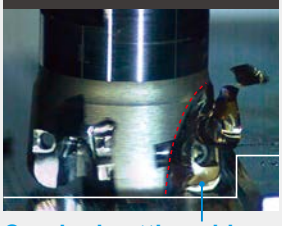




Features 04 Excellent chip discharge characteristics

- Reduces the occurrence of sudden problems due to jamming of cutting chips. In addition, good chip removal makes it possible to further improve cutting performance.

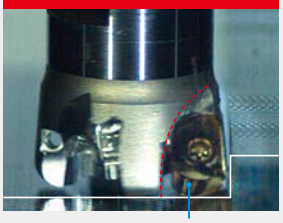
Tool with small chip pockets



If cutting chips are not discharged well, jamming of the cutting chips between the tool and wall occur, which can become the cause of sudden damage such as chipping, etc.

Crushed cutting chips

TD4N



Good chip discharge characteristics are achieved by providing large chip pockets and controlling the chip discharge direction.

Cutting chips which were discharged well

Features 05 Lineup of insert grades

PVD Technology Grade for machining high-hardness materials **JP4105**

- Employs an ultra-fine cemented carbide substrate and the new "AJ Coating" to improve wear resistance.
- Excellent wear resistance when machining high hardness materials of 50HRC or higher.

PVD Technology Grade for machining pre-hardened or hardened materials **JP4120**

- Employs a fine carbide substrate with an excellent balance between wear resistance and toughness and the new "AJ Coating" to provide improved wear resistance and chipping resistance.
- Highly versatile with excellent wear resistance and chipping resistance when machining steel materials with hardnesses of 30 to 50 HRC.

PVD Technology Grade for machining stainless-steel materials **JM4160**

- Employs a carbide substrate with high toughness and the new "AJ Coating" to improve wear resistance and chipping resistance when machining stainless-steel materials.
- Reduces the welding to work material that occurs when machining stainless steel materials.

PVD Technology General purpose for steel **JS4160**

- Features a coating with outstanding heat and welding resistance, reducing crater wear that occurs during high-efficiency cutting.
- Features a carbide base metal that combines toughness with heat resistance to ensure consistent long tool life and high efficiency in cutting.

CVD Technology General purpose for steel **GX2140**

- Smooth surfaced α-Al_2O_3 layer with improved chipping / welding resistance brings less sudden-tool-edge-chipping.
- Machining efficiency is improved for high-speed,high-feed-rate rough machining by using the layer with fine columnar structure.

Line Up

Shank type TD4N20○○□(32)-○

Numeric figure in a circle ○ and Alphabetical character comes in a square □.

Fig.1 (Standard type)

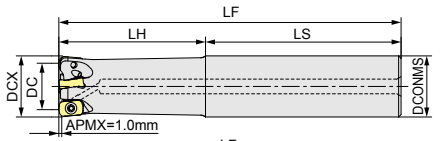
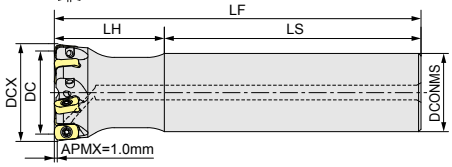


Fig.2 (Undercut type)

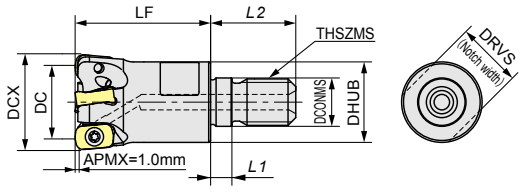


With air hole

Type		Item code	Stock	No.of flutes	Size (mm) DCX	DC	LF	LH	LS	DCONMS	Shape	Recommended insert
Shank type	Regular	TD4N2016S-2	●	2	16	10	100	30	70	16	Fig.1	ENMU0603ER-B/C ENGU0603ER-C
		TD4N2017S-2	●	2	17	11	100	30	70	16	Fig.2	
		TD4N2018S-2	●	2	18	12	100	30	70	16		
		TD4N2020S-3	●	3	20	14	130	50	80	20	Fig.1	
		TD4N2021S-3	●	3	21	15	130	50	80	20	Fig.2	
		TD4N2022S-3	●	3	22	16	130	50	80	20		
		TD4N2025S-4	●	4	25	19	140	60	80	25	Fig.1	
		TD4N2030S-4	●	4	30	24	150	70	80	32		
		TD4N2032S-5	●	5	32	26	150	70	80	32		
		TD4N2035S-5	●	5	35	29	150	45	105	32	Fig.2	
		TD4N2040S32-6	●	6	40	34	150	45	105	32		
	Long	TD4N2016L-2	●	2	16	10	150	50	100	16	Fig.1	
		TD4N2018L-2	●	2	18	12	150	25	125	16	Fig.2	
		TD4N2020L-3	●	3	20	14	160	80	80	20	Fig.1	
		TD4N2022L-3	●	3	22	16	160	30	130	20	Fig.2	
		TD4N2025L-4	●	4	25	19	180	100	80	25	Fig.1	
		TD4N2028L-4	●	4	28	22	180	35	145	25	Fig.2	
		TD4N2032L-5	●	5	32	26	200	120	80	32	Fig.1	
		TD4N2035L-5	●	5	35	29	200	40	160	32	Fig.2	
		TD4N2040L32-6	●	6	40	34	220	45	175	32	Fig.2	

Modular type TD4N20○○M-○

Numeric figure comes in a circle ○.



With air hole

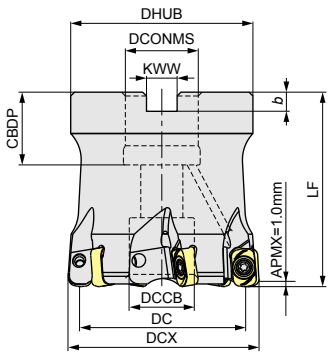
Item code	Stock	No.of flutes	Size (mm) DCX	DC	LF	L1	L2	DCONMS	DHUB	THSZMS	DRVS	Recommended insert
TD4N2016M-2	●	2	16	10	25	5.5	17	8.5	12.8	M8	10	ENMU0603ER-B/C ENGU0603ER-C
※TD4N2017M-2	●	2	17	11	25	5.5	17	8.5	12.8	M8	10	
※TD4N2018M-2	●	2	18	12	25	5.5	17	8.5	12.8	M8	10	
TD4N2020M-3	●	3	20	14	30	5.5	19	10.5	17.8	M10	15	
※TD4N2021M-3	●	3	21	15	30	5.5	19	10.5	17.8	M10	15	
※TD4N2022M-3	●	3	22	16	30	5.5	19	10.5	17.8	M10	15	
TD4N2025M-4	●	4	25	19	35	5.5	22	12.5	20.8	M12	17	
※TD4N2026M-4	●	4	26	20	35	5.5	22	12.5	20.8	M12	17	
※TD4N2028M-4	●	4	28	22	35	5.5	22	12.5	20.8	M12	17	
TD4N2030M-4	●	4	30	24	40	6	23	17	28.8	M16	22	
TD4N2032M-5	●	5	32	26	40	6	23	17	28.8	M16	22	
※TD4N2033M-5	●	5	33	27	40	6	23	17	28.8	M16	22	
※TD4N2035M-5	●	5	35	29	40	6	23	17	28.8	M16	22	
※TD4N2040M-6	●	6	40	34	40	6	23	17	28.8	M16	22	
※TD4N2042M-6	●	6	42	36	40	6	23	17	28.8	M16	22	

【Note】 When ※ and carbide shank are used together as a set, there is no interference.
Do not apply lubricants to the threaded section or end surface sections in contact with the dedicated shank/arbor for modular mills.

★ : Stocked Items of New products. ● : Stocked Items.

Bore type TD4N20○○B□-○

Numeric figure in a circle ○ and Alphabetical character comes in a square □ .



With air hole

Type	Item code	Stock	No.of flutes	Size (mm)									Recommended insert
				DCX	DC	DHUB	LF	CBDP	KWW	*b*	DCONMS	DCCB	
Internal diameter inch size	**TD4N2050B-6**	●	6	50	44	47	50	19	8.4	5	22.225	17	ENMU0603ER-B/C ENGU0603ER-C
Internal diameter mm size	**TD4N2050BM-6**	●	6	50	44	47	50	20	10.4	6.3	22	17	

【Note】Arbor screw is not included.

Insert

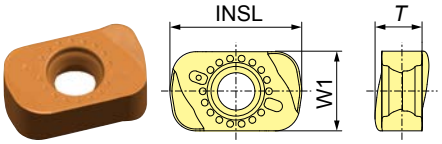


Fig.1 ENMU0603ER-B

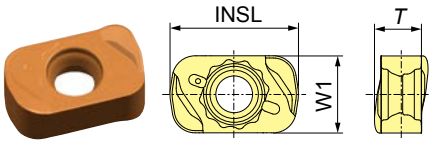


Fig.2 ENMU0603ER-C

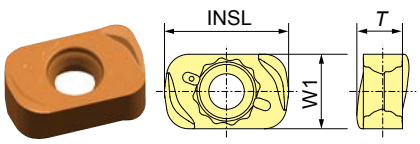


Fig.3 ENGU0603ER-C

P	Carbon steels		■		■		■	■ : General cutting, First recommendation
M	SUS, etc.			■				▣ : General cutting, Second recommendation
K	FC・FCD Cast irons		■		▣		▣	
H	Hardened steels	■	▣					

Item code	Tolerance class	AJ Coating			JS Coating		GX Coating	Size (mm)			Shape
		JP4105	JP4120	JM4160	JS4160	JS4045	GX2140	INSL	W1	*T*	
ENMU0603ER-B	M		●	●	★	△	●	10	6	3.7	Fig.1
ENMU0603ER-C	M		●	●	★	△	●				Fig.2
ENGU0603ER-C	G	●									Fig.3

【Note】Please note that the GX Coating and JS Coating do not cause a reaction in conductive touch sensors.

Parts

Parts	Clamp screw		Screw driver	Screw anti-seizure agent
Shape		Fastening torque (N・m)		
Item code	T08-2507A	1.1	104-T8	P-37

【Note】
The clamp screw is a consumable part. Since replacement life depends on the use environment, it is recommended that it be replaced at an early stage.

△ : The sale ends when all the stock is out.

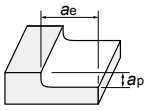
Recommended Cutting Conditions

※ Red indicates primary recommended insert grade.

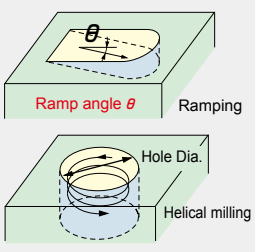
Work material	Recommended inserts grade	Tool dia. DCX / Overhang	φ16 (2 flutes) ～3DCX	φ16 (2 flutes) 4DCX～7DCX	φ20 (3 flutes) ～3DCX	φ20 (3 flutes) 4DCX～7DCX	φ25 (4 flutes) ～3DCX	φ25 (4 flutes) 4DCX～7DCX	φ32 (5 flutes) ～3DCX	φ32 (5 flutes) 4DCX～7DCX	φ40 (6 flutes) ～3DCX	φ40 (6 flutes) 4DCX～7DCX	φ50 (6 flutes) ～3DCX	φ50 (6 flutes) 4DCX～7DCX
Carbon steels Alloy steels <30HRC	※ GX2140 JS4160	*n* (min-1)	3380	2990	2710	2390	2170	1910	1690	1490	1350	1190	1082	955
		Vc(m/min)	170	150	170	150	170	150	170	150	170	150	170	150
		Vf(mm/min)	6760	4780	8130	5730	10410	9160	10140	8940	9720	8560	7792	6875
		fz(mm/t)	1	0.8	1	0.8	1.2	1.2	1.2	1.2	1.2	1.2	1.2	1.2
		ap(mm)	0.6	0.6	0.6	0.6	0.6	0.6	0.5	0.5	0.5	0.5	0.5	0.5
		ae(mm)	10	10	14	14	19	19	22	22	28	28	35	35
		Q (cm3/min)	41	29	68	48	119	104	112	98	136	120	136	120
Alloy steels Tool steels 30～40HRC	JS4160 JP4120	*n* (min-1)	2990	2590	2390	2070	1910	1660	1490	1290	1190	1040	955	828
		Vc(m/min)	150	130	150	130	150	130	150	130	150	130	150	130
		Vf(mm/min)	5980	4140	7170	4960	7640	6640	7450	6450	7140	6240	5730	4966
		fz(mm/t)	1	0.8	1	0.8	1	1	1	1	1	1	1	1
		ap(mm)	0.6	0.6	0.6	0.6	0.6	0.6	0.5	0.5	0.5	0.5	0.5	0.5
		ae(mm)	10	10	14	14	19	19	22	22	28	28	35	35
		Q (cm3/min)	36	25	60	42	116	76	82	71	100	87	100	87
Pre-Hardened steels Alloy steels 40～50HRC	JP4120	*n* (min-1)	1990	1790	1590	1430	1270	1150	1000	900	800	720	637	573
		Vc(m/min)	100	90	100	90	100	90	100	90	100	90	100	90
		Vf(mm/min)	3980	2860	4770	3430	5080	3680	5000	3600	4800	3450	3820	2750
		fz(mm/t)	1	0.8	1	0.8	1	0.8	1	0.8	1	0.8	1	0.8
		ap(mm)	0.6	0.5	0.6	0.5	0.6	0.5	0.5	0.5	0.5	0.5	0.5	0.5
		ae(mm)	10	10	14	14	19	19	22	22	28	28	35	35
		Q (cm3/min)	24	14	40	24	58	35	55	40	67	48	67	48
Stainless steels SUS	JM4160	*n* (min-1)	1990	1790	1590	1430	1270	1150	1000	900	800	720	637	573
		Vc(m/min)	100	90	100	90	100	90	100	90	100	90	100	90
		Vf(mm/min)	3980	2860	4770	3430	5080	3680	5000	3600	4800	3450	3820	2750
		fz(mm/t)	1	0.8	1	0.8	1	0.8	1	0.8	1	0.8	1	0.8
		ap(mm)	0.6	0.5	0.6	0.5	0.6	0.5	0.5	0.5	0.5	0.5	0.5	0.5
		ae(mm)	10	10	14	14	19	19	22	22	28	28	35	35
		Q (cm3/min)	24	14	40	24	58	35	55	40	67	48	67	48
Cast irons FC FCD	JP4120 GX2140	*n* (min-1)	3980	3580	3180	2870	2550	2290	1990	1790	1590	1430	1273	1146
		Vc(m/min)	200	180	200	180	200	180	200	180	200	180	200	180
		Vf(mm/min)	9550	7160	11440	8610	12240	9160	11940	8950	11440	8580	9167	6875
		fz(mm/t)	1.2	1	1.2	1	1.2	1	1.2	1	1.2	1	1.2	1
		ap(mm)	0.8	0.6	0.8	0.6	0.8	0.6	0.8	0.6	0.8	0.6	0.8	0.6
		ae(mm)	10	10	14	14	19	19	22	22	28	28	35	35
		Q (cm3/min)	76	43	128	72	186	104	210	118	256	144	256	144
High-hardened steels 50～55HRC	JP4105 JP4120	*n* (min-1)	1590	1390	1270	1110	1020	890	800	700	640	560	509	446
		Vc(m/min)	80	70	80	70	80	70	80	70	80	70	80	70
		Vf(mm/min)	1270	890	1530	1070	1630	1140	1590	1110	1530	1070	1222	856
		fz(mm/t)	0.4	0.32	0.4	0.32	0.4	0.32	0.4	0.32	0.4	0.32	0.4	0.32
		ap(mm)	0.3	0.2	0.3	0.2	0.3	0.2	0.3	0.2	0.3	0.2	0.3	0.2
		ae(mm)	10	10	14	14	19	19	24	24	30	30	38	38
		Q (cm3/min)	4	2	6	3	9	5	11	6	14	7	14	7
High-hardened steels 55～62HRC	JP4105	*n* (min-1)	1190	1190	950	950	760	760	600	600	480	480	382	382
		Vc(m/min)	60	60	60	60	60	60	60	60	60	60	60	60
		Vf(mm/min)	～720	～570	～860	～690	～920	～730	～900	～720	～860	～690	～688	～550
		fz(mm/t)	～0.3	～0.24	～0.3	～0.24	～0.3	～0.24	～0.3	～0.24	～0.3	～0.24	～0.3	～0.24
		ap(mm) 55~57HRC	～0.3	～0.15	～0.3	～0.15	～0.3	～0.15	～0.3	～0.15	～0.3	～0.15	～0.3	～0.15
		ap(mm) 58~62HRC	～0.2	～0.1	～0.2	～0.1	～0.2	～0.1	～0.2	～0.1	～0.2	～0.1	～0.2	～0.1
		ae(mm)	10	10	14	14	19	19	24	24	30	30	38	38
		Q (cm3/min)	～2	～1	～4	～2	～5	～3	～6	～4	～8	～4	～8	～3

【Note】

① Use the appropriate coolant for the work material and machining shape.
② Conditions are for general guidance on shoulder face milling. In actual machining conditions please adjust the parameters according to your actual machine and work-piece conditions. Especially when the chip discharge or vibration is a problem in Slotting or near machining, please adjust the cutting conditions as follows.
· Reduce depth of cut(*ap*) to 50 to 70%.
· Reduce number of revolution(*n*) and feed rate(*vf*) to 50 to 70%.
③ Please note that the GX Coating and JS Coating do not cause a reaction in conductive touch sensors.
④ JP4105 is for the high-hardness steels. It is not suitable for Non-heat-treated steel material.
⑤ The machinability of hardened steels (55 - 62HRC) can vary significantly depending on the particular steel type and tool overhang. Adjust the table feed rate and cutting depth *ap* to suit machining conditions.
⑥ For strongly interrupted cutting, when unsupported length is long, or for wet cutting, JM4160 is recommended.
⑦ GX2140 should be used for dry cutting.
⑧ To prevent tool damage due to chip clogging, always use a chip removal method such as an air blower, etc.
⑨ Ensure to exchange the insert at the correct time to ensure safety of the tool-body.
⑩ The following equation can be used to determine the metal removal rate per unit time *Q*:
Q(cm3/min)=*ap*(mm) × *ae*(mm) × *Vf*(mm/min) ／1000



Regarding ramping and helical milling diameter



Tool dia.DCX (mm)	φ16	φ18	φ20	φ22	φ25	φ28	φ32	φ35	φ40	φ42	φ50
Maximum ramp angle θ (°)	0.8	0.8	0.8	0.8	0.8	0.6	0.5	0.5	0.3	0.3	0.2
Hole Dia. (mm)	24～30	28～34	32～38	36～42	42～48	48～54	56～62	62～68	72～78	76～82	92～98

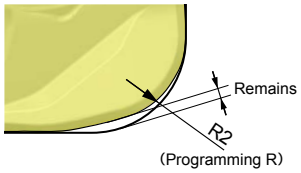
Cutting depth per rotation should be set to *ap* = 1 mm or less.

【Note】① It is recommended that the tool be used while performing sufficient chip removal and checking that there are no abnormal vibrations.
② The ramp angle θ should be set within the ranges listed above.
Use at ramp angles of 0.5° or less for tool diameters up to φ35, and 0.2° or less for tool diameters φ40 or more is recommended.
③ For hole diameters outside the ranges listed above, a pilot hole should be drilled before milling.

Points requiring care when creating the machining program

・In CAM, define the tool shape as an R2.0 radius shape.

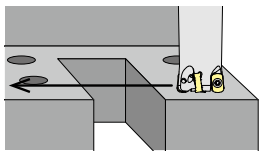
	Programming R (mm)	Remains (mm)	Over Cut (mm)
	R3.0	0	0.4
Recommended	R2.0	0.2	0
	R1.5	0.3	0

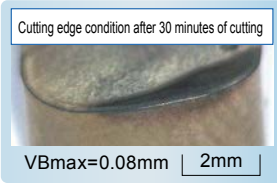


Field data

01 Shortened machining time

Interrupted machining





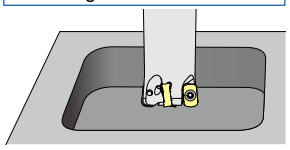
【Work material】
Pre-hardened steels (40HRC)
【Tool】
TD4N2032S-5(φ32-5 flutes)
ENMU0603ER-B(JP4120)

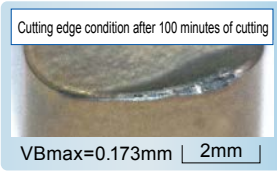
【Cutting conditions】
Vc=100m/min
Vf=9000mm/min(*fz*=1.8mm/t)
ap×*ae*=0.6×20mm
Air-blow

●90-minute machining time shortened to approx. 30 minutes.

02 Improved tool life

Pocketing



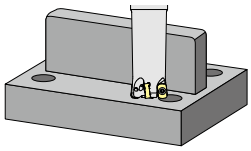


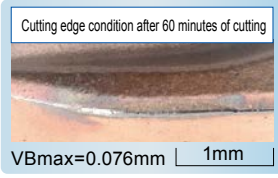
【Work material】
Carbon steels
【Tool】
TD4N2020S-3(φ20-3 flutes)
ENMU0603ER-B(JP4120)

【Cutting conditions】
Vc=140m/min
Vf=5000mm/min(*fz*=0.75mm/t)
ap×*ae*=0.8×10mm
Emulsion oil

●Completed machining with normal wear without large chipping.

Hardened steels machining





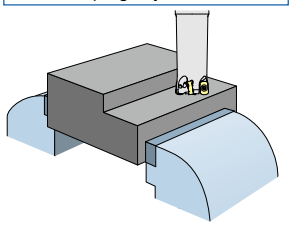
【Work material】
High-hardened steels(60HRC)
【Tool】
TD4N2025M-4(φ25-4 flutes)
ENGU0603ER-C (JP4105)

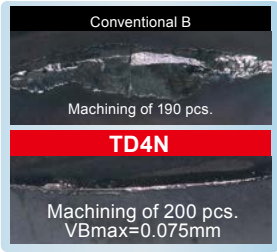
【Cutting conditions】
Vc=80m/min
Vf=1220mm/min(*fz*=0.3mm/t)
ap×*ae*=0.2×15mm
Air-blow

●Even after 60 minutes machining, wear is small and possible to use continuously.

03 High-performance machining when clamp rigidity is weak.

Low clamp rigidity





【Work material】
Mild steels
【Tool】
TD4N2032S-5(φ32-5 flutes)
ENMU0603ER-C (JS4045)

【Cutting conditions】
Vc=200m/min
Vf=8000mm/min(*fz*=0.8mm/t)
ap×*ae*=0.5×20mm
Emulsion oil

●Even after machining 200 pcs., wear is small and good.

High-feed tools lineup

Type	Feature				Holder	Insert			Programming R (mm)	APMX (mm)
	Economical (No. of corners)	High accuracy (Less uncut remnants)	Supports for high-hardened steel	Efficiency (No. of Flutes)	Tool dia. (mm)	No. of corners	Shape	Inscribed circle code		
TR2F		○	○ ~62HRC	◎ High Efficiency multiflutes	φ16~52	2		06	2.0	0.5
TD4N	◎	◎	○ ~62HRC	◎ High Efficiency multiflutes	φ16~40	4		06	2.0	1.0
ASR Multi-Flutes		○	○ ~62HRC	◎ High Efficiency multiflutes	φ16~66	2		06	2.0	1.5
								12	3.0	2.0
ASRF mini	◎		○ ~62HRC	○ General	φ20~63	4		07	2.0	1.2
ASR		○	○ ~60HRC	○ General	φ20~100	2		08~15	3.0	2.0
ASRT	○	○	○ ~62HRC	○ General	φ25~100	3		09~14		
ASRF	◎		○ ~60HRC	○ General	φ32~100	4		12	4.5	
TD6N	◎	○	~50HRC	○ General	φ50~125	6		14	3.0	1.5
								14		3.0
TR4F	◎		○ ~62HRC	○ General	φ32~125	4		12		1.2
								15		2.0

※ Various other tools for roughing are also available.
※ For more information on tool specifications, please refer to our general catalog or visit our website. (http://www.moldino.com)

MOLDINO

The Edge To Innovation

The diagrams and table data are examples of test results, and are not guaranteed values.
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⚠ Attentions on Safety

1. Attentions regarding handling

(1) When removing the tool from the case (package), be careful not to drop it on your foot or drop it onto the tips of your bare fingers.
(2) When actually setting the inserts, be careful not to touch the cutting flute directly with your bare hands.

2. Attentions regarding mounting

(1) When preparing for use, be sure that the inserts are firmly mounted in place and that they are firmly mounted on the arbor, etc.
(2) If abnormal chattering occurs during use, stop the machine immediately and remove the cause of the chattering.

3. Attentions during use

(1) Before use, confirm the dimensions and direction of rotation of the tool and milling work material.
(2) The numerical values in the standard cutting conditions table should be used as criteria when starting new work. The cutting conditions should be adjusted as appropriate when the cutting depth is large, the rigidity of the machine being used is low, or according to the conditions of the work material.
(3) The inserts are made of a hard material. During use, they may break and fly off. In addition, cutting chips may also fly off. Since there is a danger of injury to workers, fire, or eye damage from such flying pieces, a safety cover should be installed and safety equipment such as safety glasses should be worn to create a safe environment for work.
・Do not use where there is a risk of fire or explosion.
・Do not use non-water-soluble cutting oils. Such oils may result in fire.
(4) Do not use the tool for any purpose other than that for which it is intended, and do not modify it.

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