WE CREATE YOUR TOMORROW!

Power Buster

- New tooling utilizing a specially designed serrated edges to increase productivity.
- AA (approach angle) : 45°and 10°available

KORLOY

Power Buster

Code system

PB	A	C	M	5	250	R/L	-	M

- **Power Buster**
- **Approach angle**
  A : 45°
  Z : 80°
- **Tool type**
  C : Cutter
- **Arbor type**
  M : Metric
  A : Inch
- **Insert I/C**
  5 : 15.875
- **Tool diameter**
  ØD : 250
- **Hand of tool**
  R : Right
  L : Left
- **Pitch type**
  M : Close pitch
  A : Coarse pitch

Features

- New tooling utilizing a specially designed serrated edges to increase productivity by reducing the cutting load.
- Double-sided 6 corner insert geometry ensures high rigidity, long tool life and cost efficiency.
- The serrated edges divide the chips into smaller pieces. This feature provides excellent chip control, reduces interference of the cutter and ensures good durability of the cutter body.
- AA (approach angle) : 45°and 80°available (same insert used)
- Application : High depth of cut and high feed rate (Steel, Cast iron)

Features of Insert

❶ Major cutting edge (Nick edge)

- Low cutting load
- Ideal for chip control, divides chips into small pieces for proper chip evacuation. Double sided 6 corner insert
- Ideal edge design for Steel and Cast iron rough milling

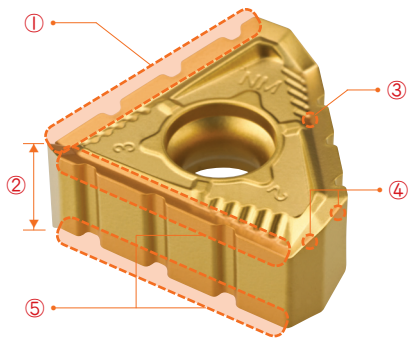
• Comparison of chip control and cutting force

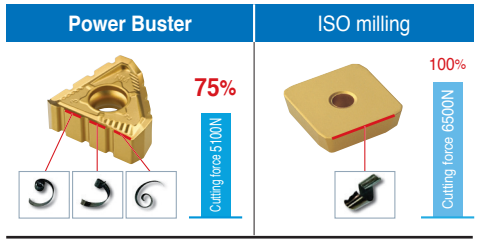
• **Work piece** : SCM440

• **Cutting condition** : vc=200m/min , ap=8mm
ae=90mm , fz=0.3mm/t

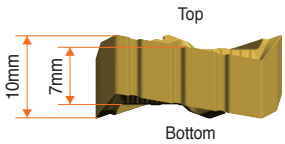
• **Tools : Power Buster** PBACA 5600R
Insert TMMX2710AZNR-NM

Milling Tool ADNA5600R
Insert SDCN 53AESN-RH



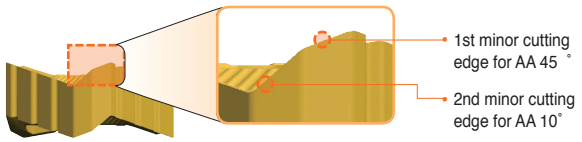


❷ Thick insert
- Thick insert guarantees high rigidity
- Balanced insert design for stable mounting

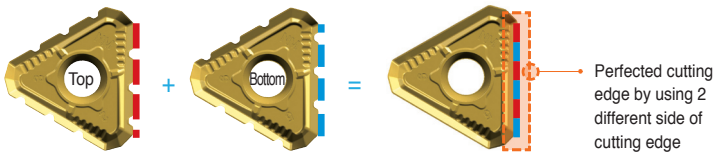


❸ NM Chip breaker
- High rake angle for low cutting force
- Good chip flow at various feed and depth of cut
- Inserts are protected with seats for a precise mounting.
- Low friction and good heat evacuation at high depth cut

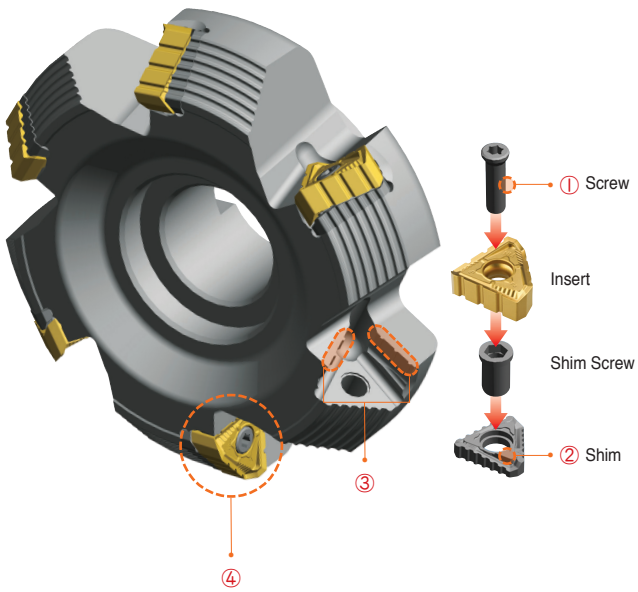
❹ Minor cutting edge
- High rake angle to avoid interference with chip
- Calculated minor cutting edge angle for both AA 45° & 10° cutter



❺ Mirror system
- Cutting edge on the both side of insert covers all overlapped cutting area

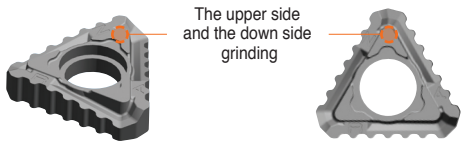


Features of Cutter



❶ Screw on clamping system
- Simple and strong screw on clamping system

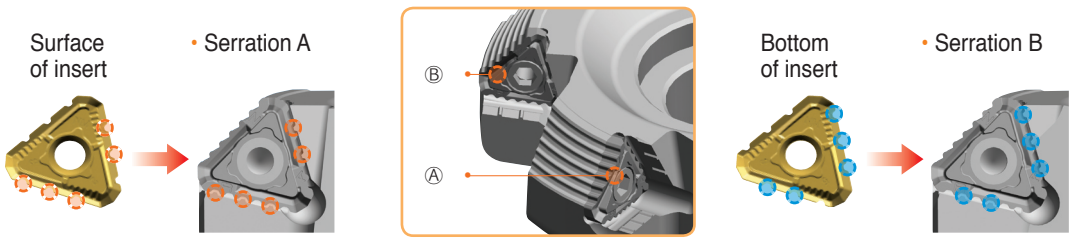
❷ Better rigidity & Stable Assembly system
- The shim protects the cutter from insert damage
- High accuracy shim ensures tighter clamping



Power Buster

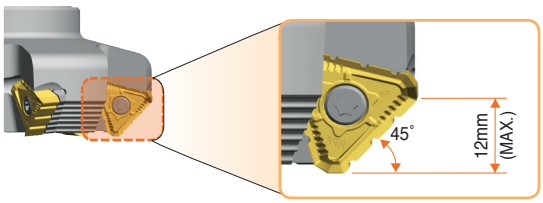
❸ Foolproof System

- Insert serrations match pocket design to prevent improper seating and alignment.



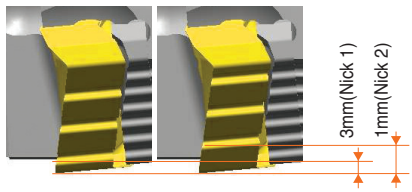
❹ Multi-application system

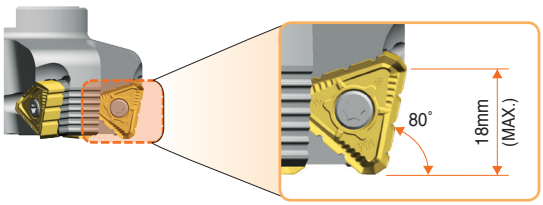
- Same insert for multi use (45˚and 80˚)



• AA 45˚

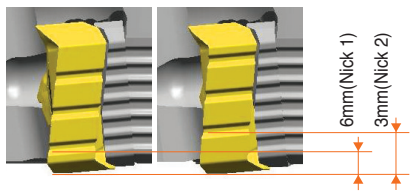
The nicks are effective with a depth of cut larger than 1mm





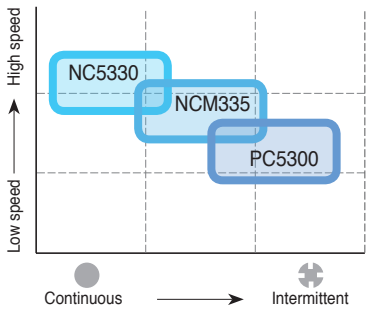
• AA 80˚

The nicks are effective with a depth of cut larger than 3mm



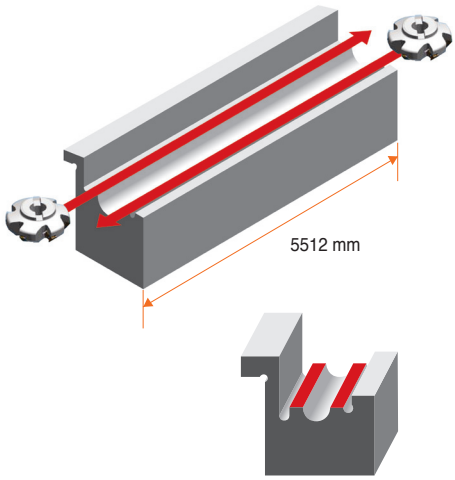
Recommended cutting condition

Workpiece	P (Steel)		K (Cast Iron)	
	vc (sfm)	vc (sfm)	vc (sfm)	fz (ipt)
NC5330	200(150~250)	0.1~0.30	200(150~300)	0.1~0.30
NCM335	180(150~250)	0.1~0.30	180(150~280)	0.1~0.35
PC5300	180(120~230)	0.1~0.30	180(120~250)	0.1~0.35

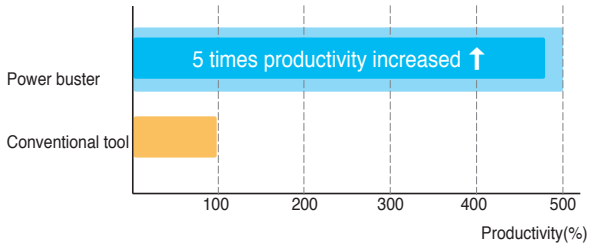


Power Buster Test

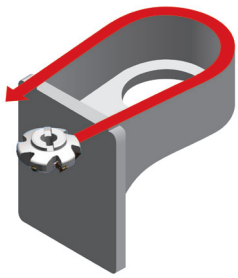
- **Cylinder block for ship engine(Cast iron)**
  - Cutting width(ae) = 160mm×2
  - Cutting depth(ap) = 20mm



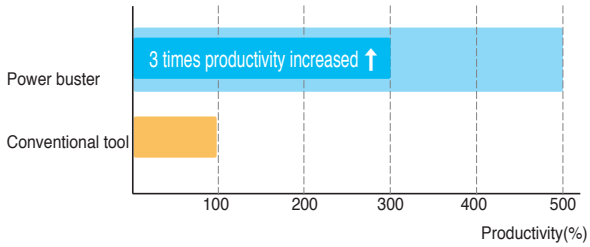
Item	Power Buster	Conventional tool
ØD	200mm	200mm
⦾	12teeth	12teeth
Grade	NC5330	PVD coating for Cast iron
vc	170m/min	130m/min
fz	0.24mm/t	0.16mm/t
ap	10mm x 2 passes	4mm x 5 passes
min	28.2min/ea	137.5min/ea



- **Heavy machinery part(Alloy steel)**
  - Cutting width(ae) = 35mm
  - Cutting depth(ap) = 10mm



Item	Power Buster	Conventional tool
ØD	125mm	100mm
⦾	8teeth	8teeth
Grade	NCM335	PVD coating for Steel
vc	180m/min	150m/min
fz	0.15mm/t	0.10mm/t
ap	5mm x 2 passes	2.5mm x 4 passes
min	5min/ea	14.7min/ea



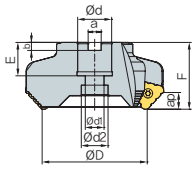
Power Buster

PBAC(M) 5000

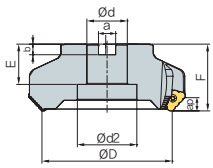
• AR : -7°
• RR : -12°~-18°

AA 45°

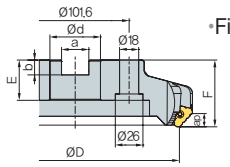
•Fig.1



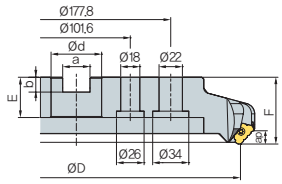
•Fig.2



•Fig.3



•Fig.4



(mm)

	Designation		◎	ØD	Ød	Ød$_1$	Ød$_2$	a	b	E	F	ap	Fig.
Coarse pitch	PBAC(M)	5080R/L	4	80	25.4(27)	14	20	9.5(12.4)	6(7)	25(22)	50	12	1
		5100R/L	4	100	31.75(32)	-	45	12.7(14.4)	8(8)	32(28)	50	12	2
		5125R/L	6	125	38.1(40)	-	56	15.9(16.4)	10(9)	38(32)	63	12	2
		5160R/L	8	160	50.8(40)	-	100	19(16.4)	11(9)	38(32)	63	12	2
		5200R/L	10	200	47.625(60)	-	-	25.4(25.7)	14(14)	38(38)	63	12	3
		5250R/L	12	250	47.625(60)	-	-	25.4(25.7)	14(14)	38(38)	63	12	3
		5315R/L	14	315	47.625(60)	-	-	25.4(25.7)	14(14)	38(38)	63	12	4
Close pitch	PBAC(M)	5080R/L-M	6	80	25.4(27)	14	20	9.5(12.4)	6(7)	25(22)	50	12	1
		5100R/L-M	6	100	31.75(32)	-	45	12.7(14.4)	8(8)	32(28)	50	12	2
		5125R/L-M	8	125	38.1(40)	-	56	15.9(16.4)	10(9)	38(32)	63	12	2
		5160R/L-M	10	160	50.8(40)	-	100	19(16.4)	11(9)	38(32)	63	12	2
		5200R/L-M	12	200	47.625(60)	-	-	25.4(25.7)	14(14)	38(38)	63	12	3
		5250R/L-M	14	250	47.625(60)	-	-	25.4(25.7)	14(14)	38(38)	63	12	3
		5315R/L-M	16	315	47.625(60)	-	-	25.4(25.7)	14(14)	38(38)	63	12	4

• Parts

Screw	Shim
FTGA0518	ST53AZR
Shim Screw	**Wrench**
SHXN0712F	TW20-100

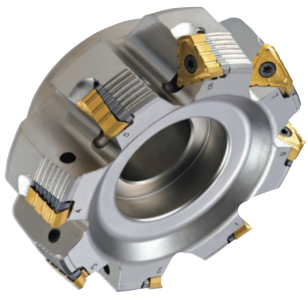
• Available Inserts

WNMX-MM

Designation		Coated									Cermet			Uncoated			
		NCM325	NCM335	NC5330	PC3500	PC5300	PC3545	PC9530	PC6510	PC215K	PD2000	CN2000	CN20	CN30	H01	G10E	A30	ST20E
TNMX	2710AZNR-NM		●	●														
	2710AZNL-NM																	

● : Stock item

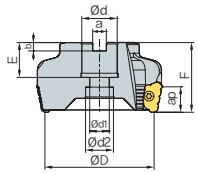
PBZC(M) 5000



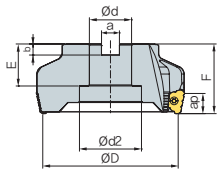
• AR : -7°
• RR : -12°~-18°

AA 80°

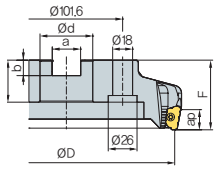
•Fig.1



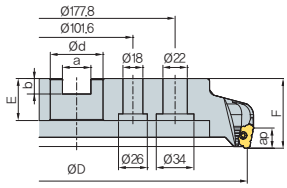
•Fig.2



•Fig.3



•Fig.4



(mm)

	Designation			ØD	Ød	Ød$_1$	Ød$_2$	a	b	E	F	ap	Fig.
Coarse pitch	PBZC(M)	5080R/L	4	80	25.4(27)	14	20	9.5(12.4)	6(7)	25(22)	50	18	1
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		5250R/L	12	250	47.625(60)	-	-	25.4(25.7)	14(14)	38(38)	63	18	3
		5315R/L	14	315	47.625(60)	-	-	25.4(25.7)	14(14)	38(38)	63	18	4
Close pitch	PBZC(M)	5080R/L-M	6	80	25.4(27)	14	20	9.5(12.4)	6(7)	25(22)	50	18	1
		5100R/L-M	6	100	31.75(32)	-	45	12.7(14.4)	8(8)	32(28)	50	18	2
		5125R/L-M	8	125	38.1(40)	-	56	15.9(16.4)	10(9)	38(32)	63	18	2
		5160R/L-M	10	160	50.8(40)	-	100	19(16.4)	11(9)	38(32)	63	18	2
		5200R/L-M	12	200	47.625(60)	-	-	25.4(25.7)	14(14)	38(38)	63	18	3
		5250R/L-M	14	250	47.625(60)	-	-	25.4(25.7)	14(14)	38(38)	63	18	3
		5315R/L-M	16	315	47.625(60)	-	-	25.4(25.7)	14(14)	38(38)	63	18	4

• Parts

Screw	Shim
FTGA0518	ST53AZR
Shim Screw	**Wrench**
SHXN0712F	TW20-100

• Available Inserts

WNMX-MM

Designation		Coated									Cermet			Uncoated			
		NCM325	NCM335	NC5330	PC3500	PC5300	PC3545	PC9530	PC6510	PC215K	PD2000	CN2000	CN20	CN30	H01	G10E	A30	ST20E
TNMX	2710AZNR-NM		●	●														
	2710AZNL-NM																	

● : Stock item

We create your tomorrow!

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May.10, 2013
TN13-EM-01

New serrated edge design increases productivity by reducing insert cutting load

Power Buster

- New tooling utilizing a specially designed serrated edge to increase productivity by reducing the cutting load.
- Double-sided 6 corner insert geometry ensures high rigidity, long tool life and cost efficiency
- The serrated edge divides the chips into smaller pieces. This feature provides excellent chip control, reduces interference of the cutter and ensures good durability of the cutter body.
- Two types of inserts are available-TNMX27 for PBA (Approach angle: 45°) and PBZ (AA: 80°), and TNMX30 for PBP (AA: 90°)
- Application: High depth of cut and feed rate (Steel, Cast iron)

Code system

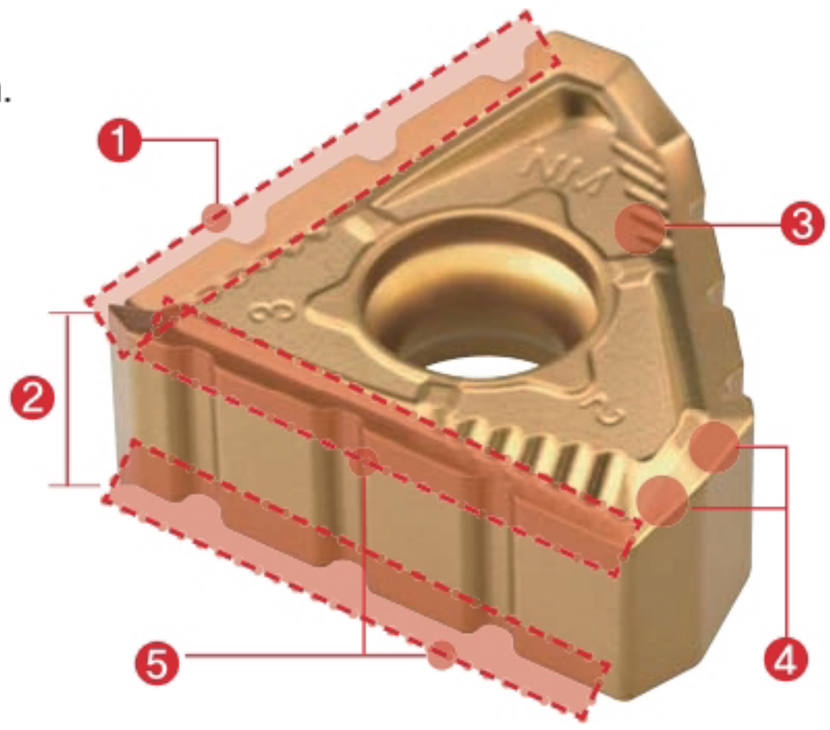
PB A C M 5 250 R/L – M

Power Buster	AA	Cutter type	Arbor type	Inscribed circle of insert	Tool Dia.	Hand	No of tooth
Power buster	A: 45° Z: 80° P: 90°	C: Cutter	M: Metric No code: Inch	5: 15.875 6: 17.462	ØD: 250	R: Right L: Left	No code: Coarse pitch M: Close pitch 8: 8 teeth

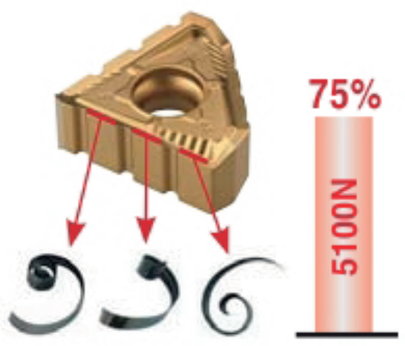
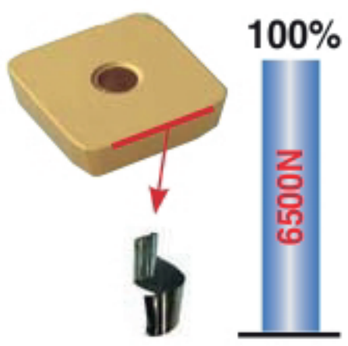
Features of insert

❶ Major cutting-edge (Serrated edge)

- Low cutting forces
- Ideal for chip control, divides chips into small pieces for proper chip evacuation. Double-sided 6 corner insert
- Ideal edge design for Steel and Cast iron rough milling



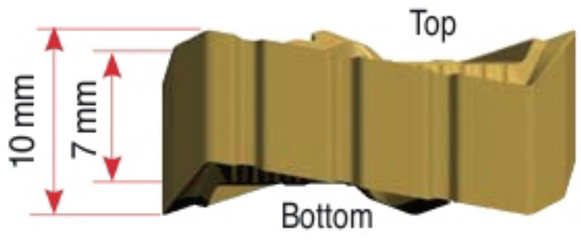
- **Comparison of chip control and cutting force**

Power Buster	ISO milling insert
	
75%	100%
5100N	6500N

■ **Workpiece** SCM440
■ **Cutting condition** vc = 200 m/min, ap = 8 mm, ae = 90 mm, fz = 0.3 mm/t

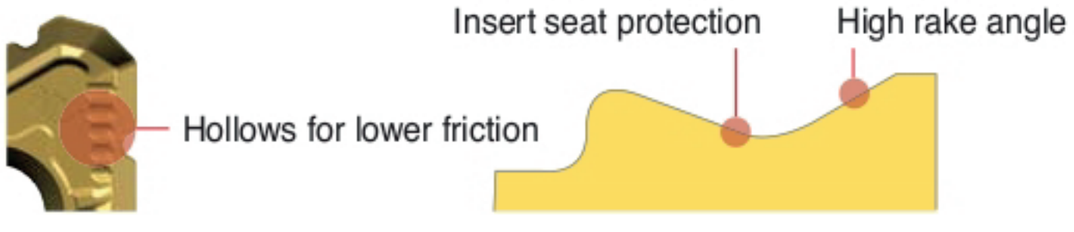
❷ Thicker insert

- Thick insert guarantees high rigidity
- Balanced insert design for stable mounting



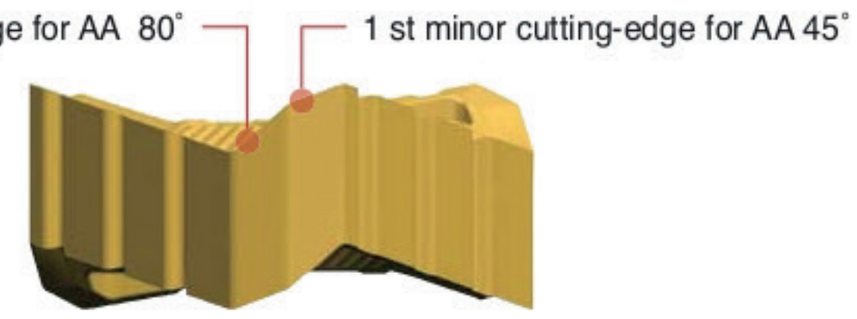
❸ NM Chip breaker

- High rake angle for low cutting force
- Good chip flow at various feed and depth of cut
- Inserts are protected with seats for a precise mounting
- Low friction and good heat evacuation at high depth cut



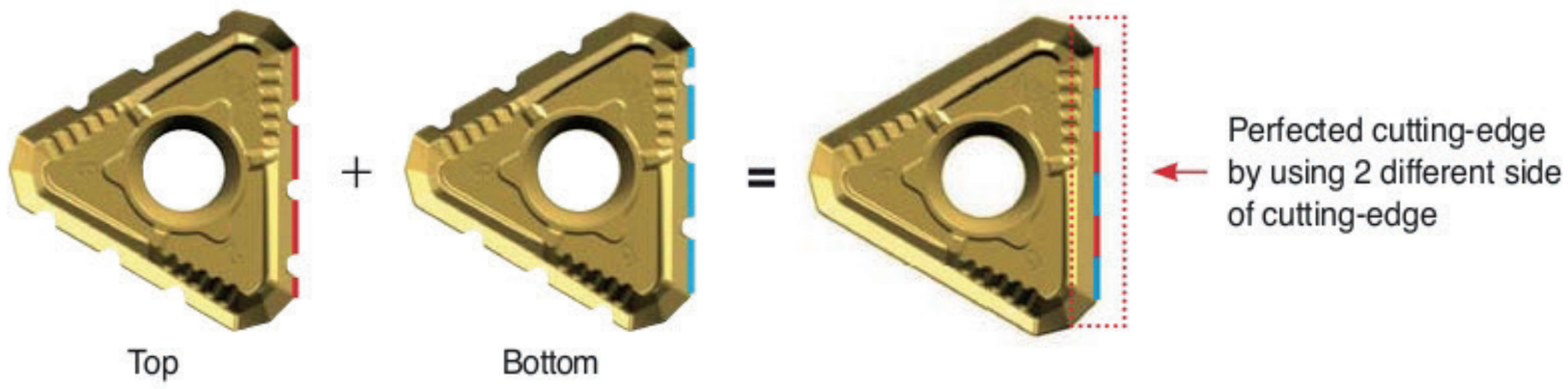
❹ Insert shape applied to PBA/Z cutters (AA: 45°/80°)

- High rake angle to avoid interference with chip
- Calculated minor cutting-edge angel for both AA 45° & 80° cutter



❺ Mirror system

- Cutting-edge on the both side of insert covers all overlapped cutting area



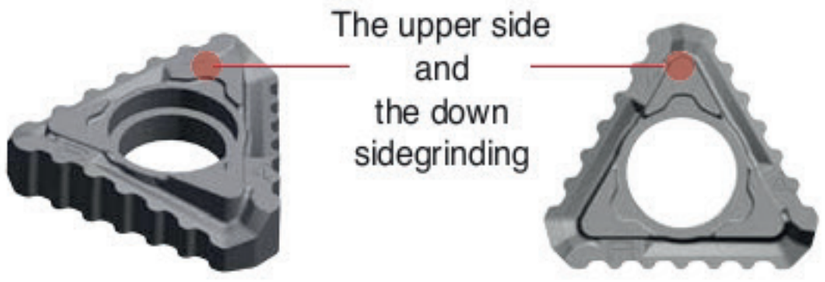
Features of cutter

❶ Screw-on clamping system

- Simple and strong screw on clamping system

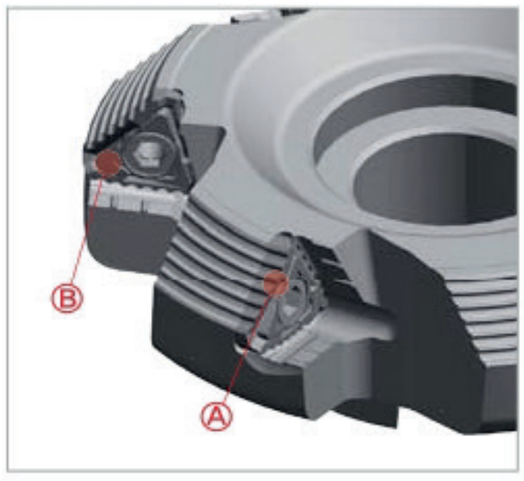
❷ Better rigidity & Stable Assembly system

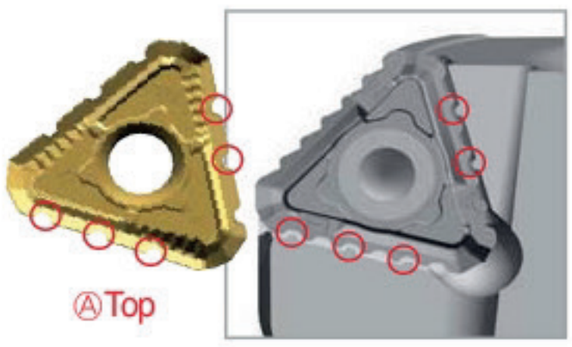
- The shim protects the cutter from insert damage
- High accuracy shim ensures tighter clamping

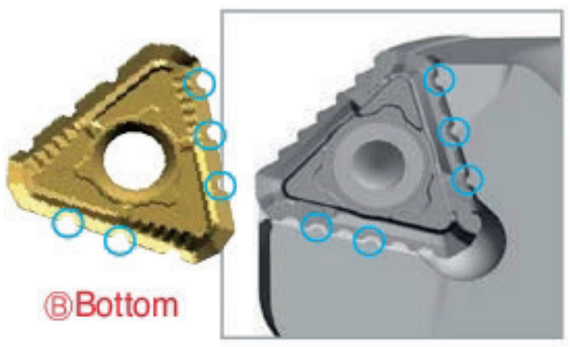


❸ Foolproof System

- Insert serrations match pocket design to prevent improper seating and alignment



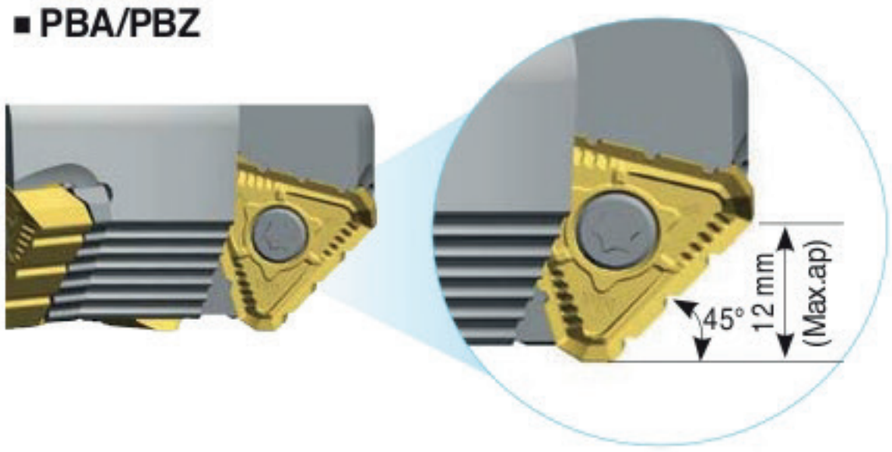


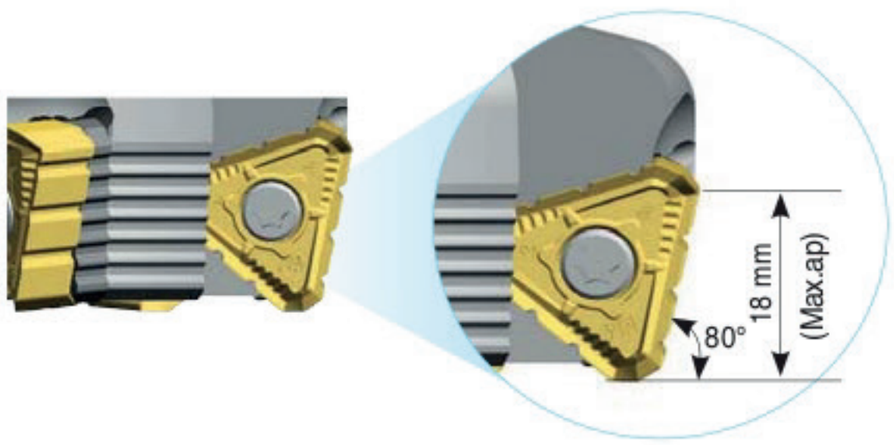


❹ Multi-application system

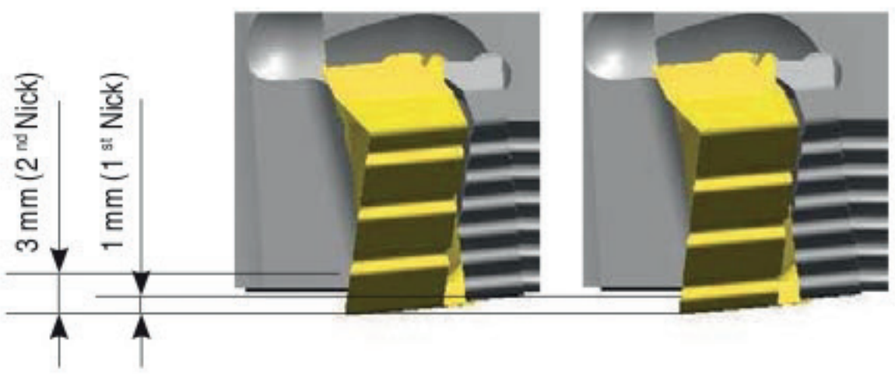
• Same insert for multi-use (45˚and 80˚)

■ PBA/PBZ

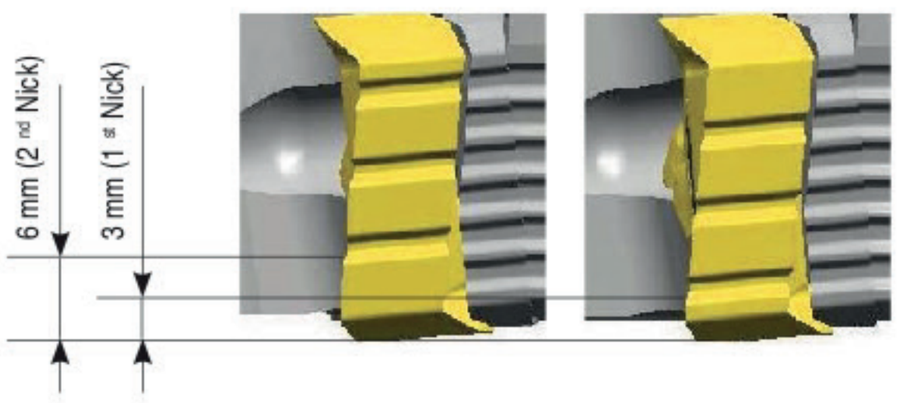




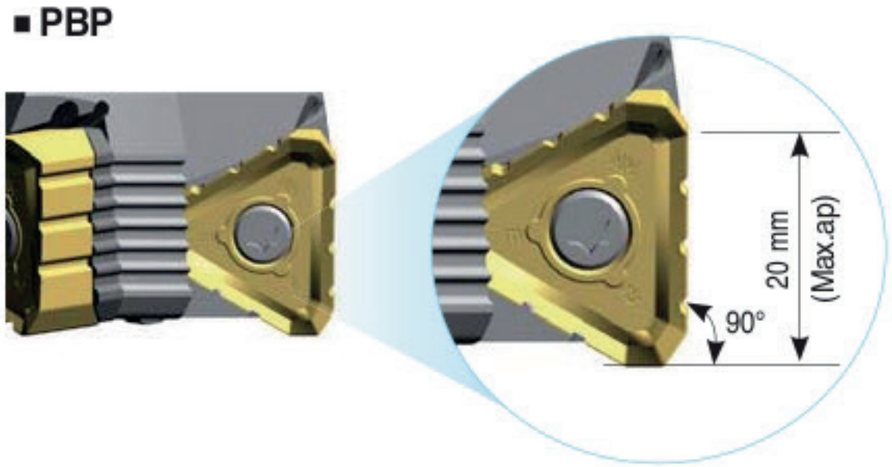
The serrations are effective with a depth of cut larger than 1 mm



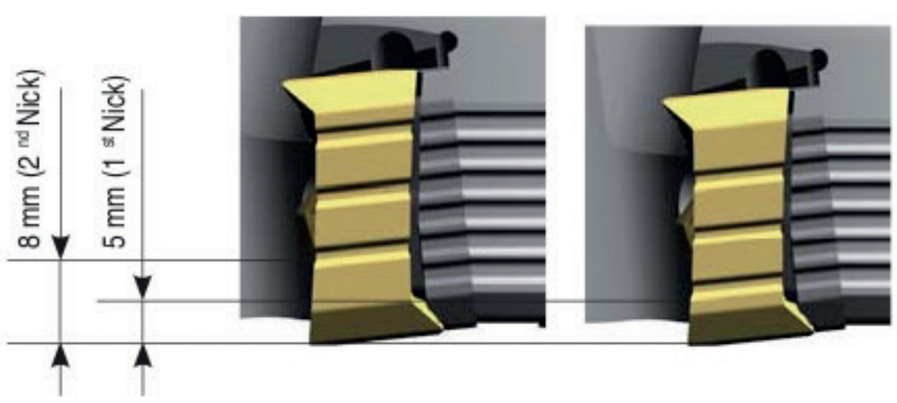
The serrations are effective with a depth of cut larger than 3 mm



■ PBP

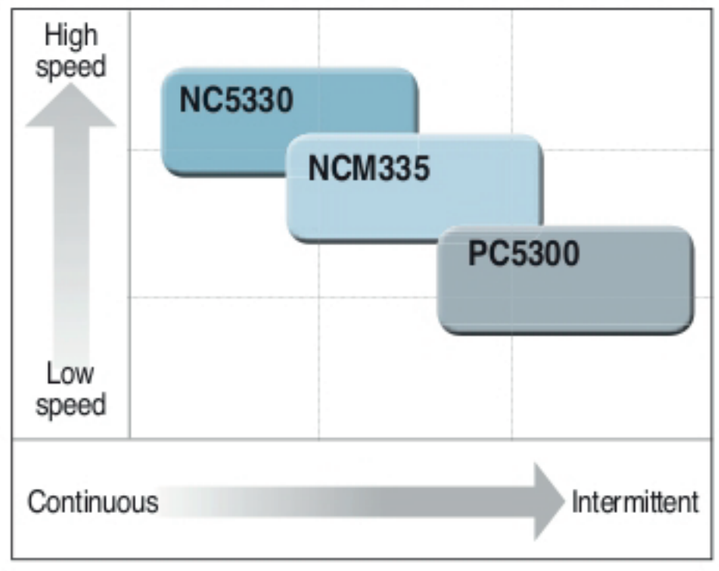


For the AA 90° cutter, nicks function properly at depth of cuts over 5 mm



Recommended cutting condition

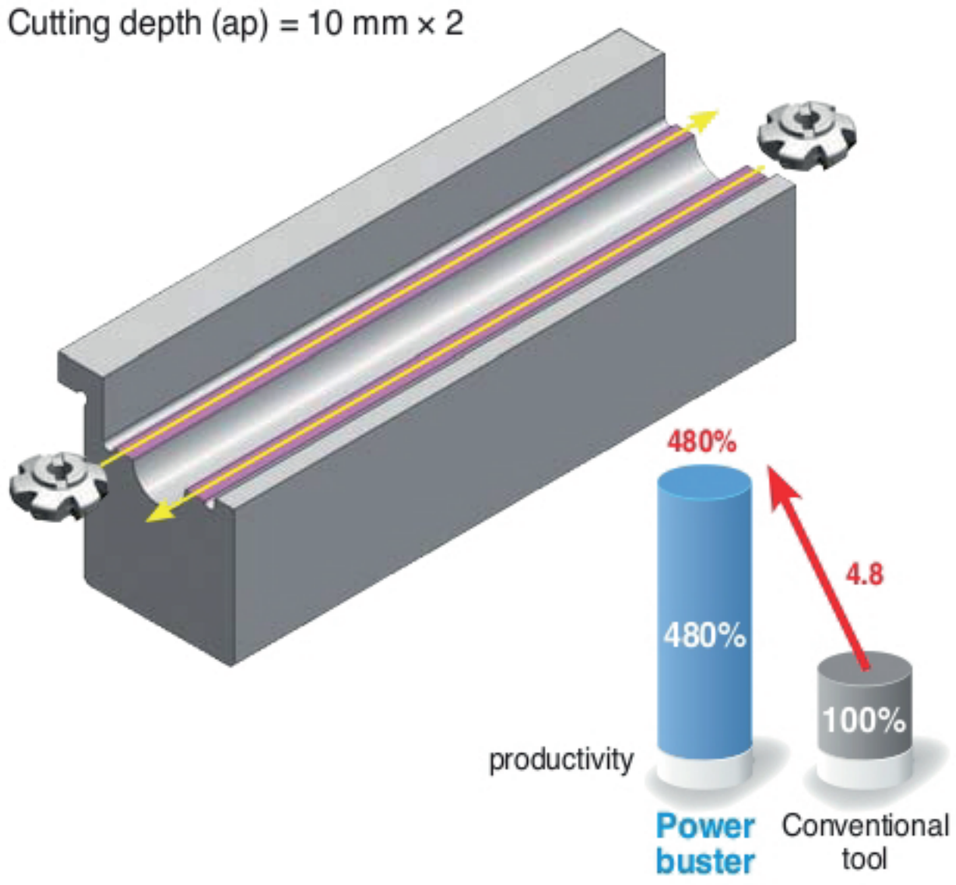
ISO	Workpiece		Material	NC5330	NCM335	PC5300
				fz (mm/t)		
				0.1-0.2-0.3	0.1-0.2-0.3	0.1-0.2-0.3
				vc (m/min)		
P	Carbon steel	-	SUM22, C = 0.1~25	400	335	280
		-	C = 0.30~55	365	305	255
		-	C = 0.55~80	340	285	240
	Low alloy steel (Alloy constituent < 5%)	-	SCM415(H), SCM420, SCM440	280	235	195
		Hardened		165	140	115
	High alloy steel (Alloy constituent > 5%)	Annealed	SKD61	210	180	150
		Hardened	SKH51, SKH55	175	145	120
K	Gray cast iron	Low tensile	FC200, FC250	125	-	145
		Hight tensile	FC300, FC350	105	-	120
		Ferric	FCD400, FCD500	80	-	95
		Pearlitic	FCD600, FCD700	75	-	85



Power Buster test

■ Cylinder block for ship engine (Cast iron)

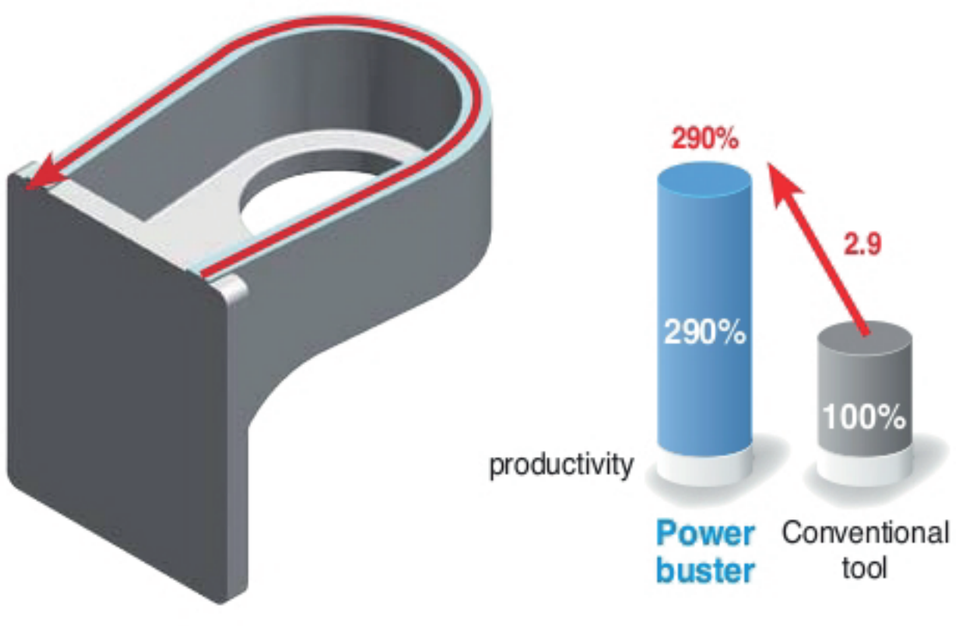
Cutting width (ae) = 160 mm × 2
Cutting depth (ap) = 10 mm × 2



Item	Power buster	Conventional tool
Diameter (ØD)	200 mm	200 mm
⦾	12 tooth	12 tooth
Grades	NC5330	PVD coating for Cast iron
vc	170 m/min	130 m/min
fz	0.24 mm/t	0.16 mm/t
ap	10 mm x 2 passes	4 mm x 5 passes
min	28.2 min/ea	137.5 min/ea
4.8 times productivity increased		• One-sided 4 corner insert (Without nick) • AA 45° cutter

■ Heavy machinery part (Alloy steel)

Cutting width (ae) = 160 mm × 2
Cutting depth (ap) = 10 mm × 2



Item	Power Buster	Conventional tool
Diameter (ØD)	125 mm	100 mm
⦾	8 tooth	8 tooth
Grades	NCM335	PVD coating for Cast iron
vc	180 m/min	150 m/min
fz	0.15 mm/t	0.10 mm/t
ap	5 mm x 2 passes	2.5 mm x 4 passes
min	5 min/ea	14.7 min/ea
2.9 times productivity increased		• Double-sided 8 corner insert (Without nick) • AA 45° cutter

PBAC(M)5000

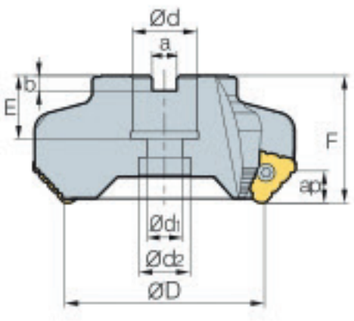


Fig. 1

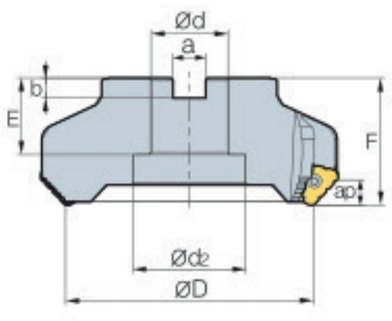


Fig. 2

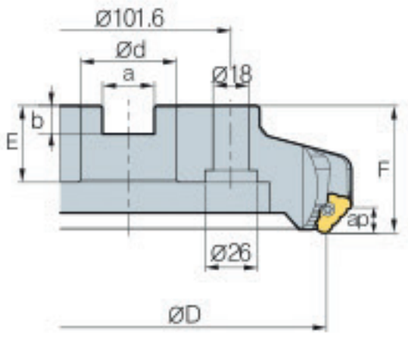


Fig. 3

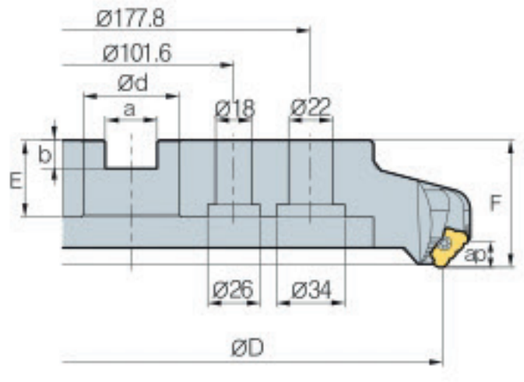
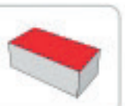


Fig. 4



AA
45°

- AR: -5°
- RR: -11°

(mm)

Designation			⊚	ØD	Ød	Ød1	Ød2	a	b	E	F	ap	Fig.
Coarse pitch	PBAC (PBACM)	5080R/L	4	80	25.4 (27)	14	20	9.5 (12.4)	6 (7)	25 (22)	50	12	1
		5100R/L	4	100	31.75 (32)	-	45	12.7 (14.4)	8 (8)	32 (28)	50	12	2
		5125R/L	6	125	38.1 (40)	-	56	15.9 (16.4)	10 (9)	38 (32)	63	12	2
		5160R/L	8	160	50.8 (40)	-	100	19 (16.4)	11 (9)	38 (32)	63	12	2
		5200R/L	10	200	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	12	3
		5250R/L	12	250	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	12	3
		5315R/L	14	315	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	12	4
Close pitch	PBAC (PBACM)	5080R/L-M	6	80	25.4 (27)	14	20	9.5 (12.4)	6 (7)	25 (22)	50	12	1
		5100R/L-M	6	100	31.75 (32)	-	45	12.7 (14.4)	8 (8)	32 (28)	50	12	2
		5125R/L-M	8	125	38.1 (40)	-	56	15.9 (16.4)	10 (9)	38 (32)	63	12	2
		5160R/L-M	10	160	50.8 (40)	-	100	19 (16.4)	11 (9)	38 (32)	63	12	2
		5200R/L-M	12	200	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	12	3
		5250R/L-M	14	250	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	12	3
		5315R/L-M	16	315	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	12	4

( )Metric size

Available inserts

TNMX-NM

Designation		Cermet		Coated										Uncoated			page
		CN2000	CN30	NCM325	NCM335	NC5330	NC5340	NC5350	PC3500	PC3600	PC9530	PC6510	PC5300	PC5400	ST30A	G10	H01	
TNMX	2710AZNR-NM					●			●		●		●					E26
	2710AZNL-NM																	

Available arbors

Designation		Available arbors	
		PBAC	PBACM
PBAC (PBACM)	5080R/L-□	BT□□-FMA25.4-□□	BT□□-FMC27-□□
	5100R/L-□	BT□□-FMA31.75-□□	BT□□-FMC32-□□
	5125R/L-□	BT□□-FMA38.1-□□	BT□□-FMB40-□□ BT□□-FMC40-□□
	5160R/L-□	BT□□-FMA50.8-□□	
	5200R/L-□	BT□□-FMA47.625-□□	BT□□-FMB60-□□
	5250R/L-□		
	5315R/L-□		

Parts

Specification	Screw	Shim	Shim screw	Wrench
Ø80~Ø315	FTGA0518	ST53AZR	SHXN0712F	TW20-100

Available inserts E26 Available arbors and bolt E371~E373

PBZC(M)5000

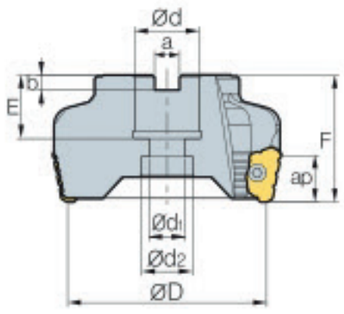


Fig. 1

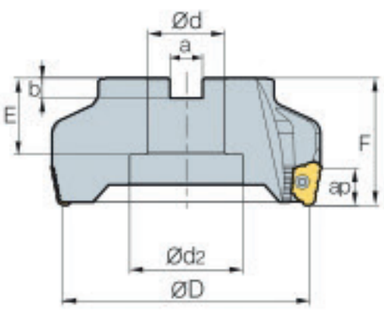


Fig. 2

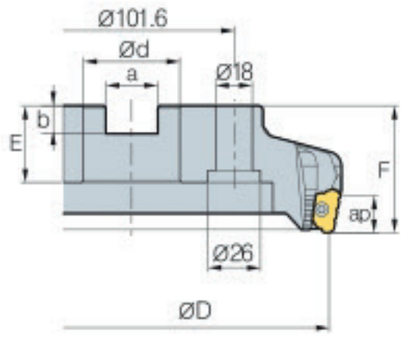


Fig. 3

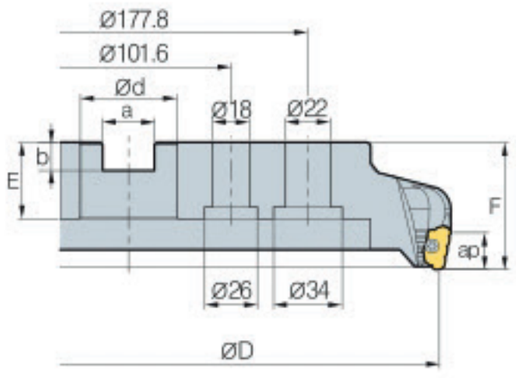
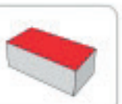


Fig. 4



AA
80°

- AR: -5°
- RR: -12°

(mm)

Designation			◎	ØD	Ød	Ød1	Ød2	a	b	E	F	ap	Fig.
Coarse pitch	PBZC (PBZCM)	5080R/L	4	80	25.4 (27)	14	20	9.5 (12.4)	6 (7)	25 (22)	50	18	1
		5100R/L	4	100	31.75 (32)	-	45	12.7 (14.4)	8 (8)	32 (28)	50	18	2
		5125R/L	6	125	38.1 (40)	-	56	15.9 (16.4)	10 (9)	38 (32)	63	18	2
		5160R/L	8	160	50.8 (40)	-	100	19 (16.4)	11 (9)	38 (32)	63	18	2
		5200R/L	10	200	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	18	3
		5250R/L	12	250	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	18	3
		5315R/L	14	315	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	18	4
Close pitch	PBZC (PBZCM)	5080R/L-M	6	80	25.4 (27)	14	20	9.5 (12.4)	6 (7)	25 (22)	50	18	1
		5100R/L-M	6	100	31.75 (32)	-	45	12.7 (14.4)	8 (8)	32 (28)	50	18	2
		5125R/L-M	8	125	38.1 (40)	-	56	15.9 (16.4)	10 (9)	38 (32)	63	18	2
		5160R/L-M	10	160	50.8 (40)	-	100	19 (16.4)	11 (9)	38 (32)	63	18	2
		5200R/L-M	12	200	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	18	3
		5250R/L-M	14	250	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	18	3
		5315R/L-M	16	315	47.625 (60)	-	-	25.4 (25.7)	14 (14)	38 (38)	63	18	4

( )Metric size

Available inserts

TNMX-NM

Designation		Cermet		Coated										Uncoated			page
		CN2000	CN30	NCM325	NCM335	NC5330	NC5340	NC5350	PC3500	PC3600	PC9530	PC6510	PC5300	PC5400	ST30A	G10	H01	
TNMX	2710AZNR-NM					●			●		●		●					E26
	2710AZNL-NM																	

Available arbors

Designation		Available arbors	
		PBZC	PBZCM
PBZC (PBZCM)	5080R/L-□	BT□□-FMA25.4-□□	BT□□-FMC27-□□
	5100R/L-□	BT□□-FMA31.75-□□	BT□□-FMC32-□□
	5125R/L-□	BT□□-FMA38.1-□□	BT□□-FMB40-□□
	5160R/L-□	BT□□-FMA50.8-□□	BT□□-FMC40-□□
	5200R/L-□	BT□□-FMA47.625-□□	BT□□-FMB60-□□
	5250R/L-□		
	5315R/L-□		

Parts

Specification	Screw	Shim	Shim screw	Wrench
Ø80~Ø315	FTGA0518	ST53AZR	SHXN0712F	TW20-100

Available inserts E26 Available arbors and bolt E371~E373

PBPCM6000 new

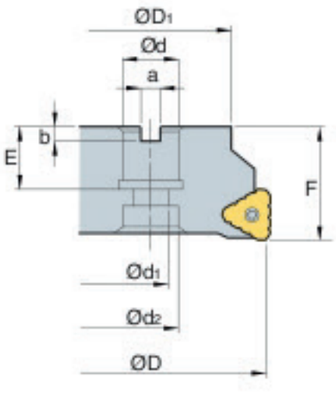


Fig. 1

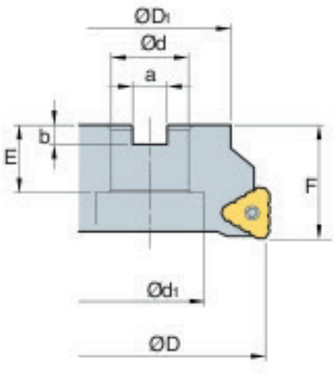


Fig. 2

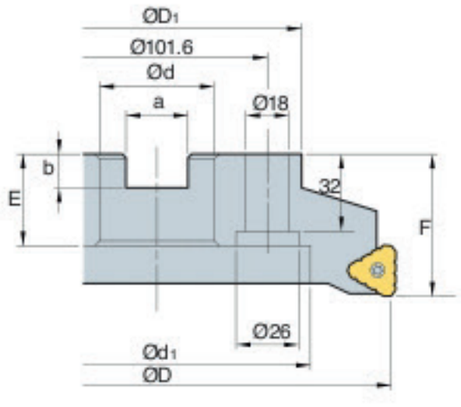


Fig. 3

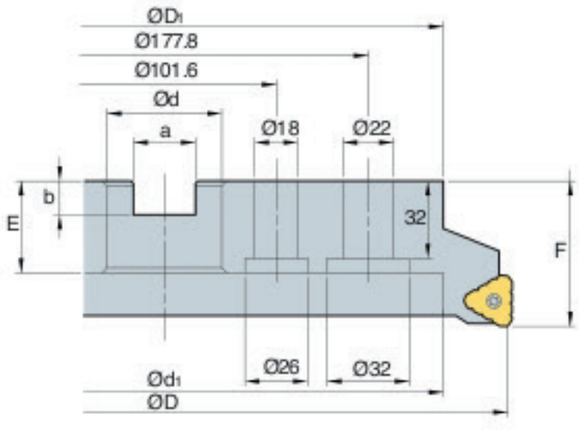


Fig. 4

AA
90°

- AR: -5°
- RR: -12°

(mm)

Designation			ØD	ØD1	Ød	Ød2	Ød2	a	b	E	F	ap	kg	Fig.
PBPCM	6080R-4	4	80	60	27	14	20	12.4	7	24	50	20	0.85	1
	6100R-6	6	100	70	32	-	54	14.4	8	30	50	20	1.16	2
	6125R-6	6	125	90	40	-	56	16.4	9	32	63	20	2.84	2
	6160R-8	8	160	107	40	-	90	16.4	9	32	63	20	3.58	3
	6200R-10	10	200	130	60	-	132	25.7	14	38	63	20	5.13	3
	6250R-12	12	250	180	60	-	180	25.7	14	38	63	20	9.6	3
	6315R-14	14	315	240	60	-	238	25.7	14	38	63	20	16.85	4

Available inserts

TNMX-NM

Designation		Cermet		Coated										Uncoated			page
		CN2000	CN30	NCM325	NCM335	NC5330	NC5340	NC5350	PC3500	PC3600	PC9530	PC6510	PC5300	PC5400	ST30A	G10	H01	
TNMX	3012PNR-NM																	E26

Available arbors

Designation		General arbor
PBPCM	6080R-4	BT□□ -FMC27-□□
	6100R-6	BT□□ -FMC32-□□
	6125R-6	BT□□ -FMC40-□□
	6160R-8	
	6200R-10	BT□□ -FMC60-□□
	6250R-12	
	6315R-14	

Parts

Specification	Screw	Shim	Shim screw	Wrench
Ø80~Ø315	FTGA0518	ST53PNR	SHXN0712F	TW20-100

Available inserts **E26** Available arbors and bolt **E371~E373**