



6-corner shoulder cutter series

# PSTW

Volume 3

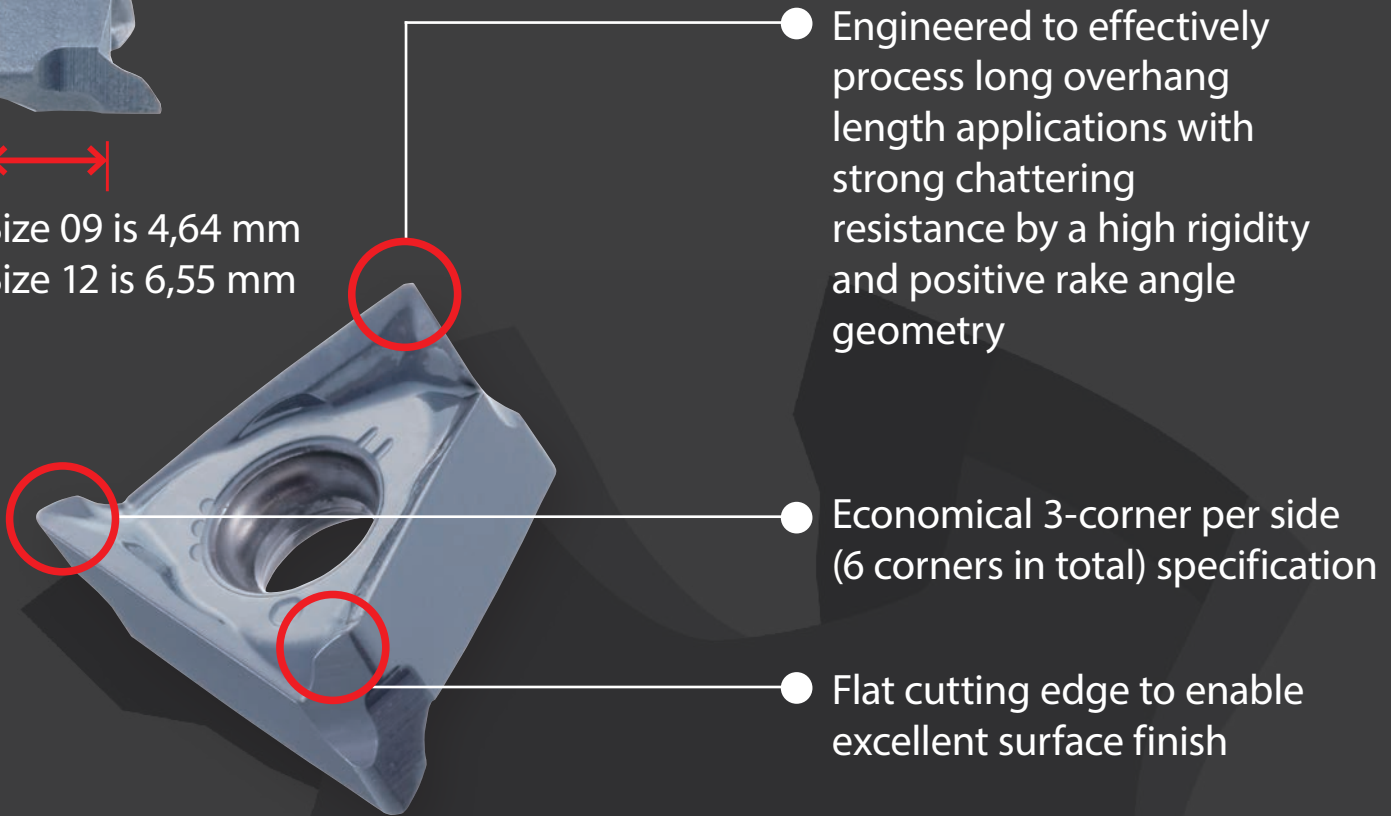


# KEY FEATURES: PHOENIX PSTW

## Double-sided 6-corner (90°) insert



Size 09 is 4,64 mm  
Size 12 is 6,55 mm



● Engineered to effectively process long overhang length applications with strong chattering resistance by a high rigidity and positive rake angle geometry

● Economical 3-corner per side (6 corners in total) specification

● Flat cutting edge to enable excellent surface finish

A body design engineered for high efficiency machining



**1**

Maximum depth of cut:  
Size 09 is 9 mm,  
size 12 is 12 mm

**2**

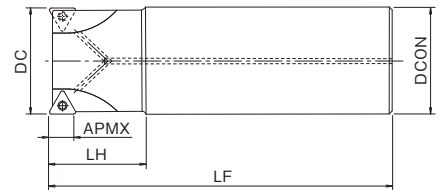
Chip pocket uniquely designed for heavy machining to enable maximum efficiency

# PSTW SS

Milling | Indexables

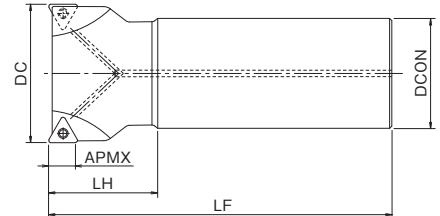


Type 1



- 90° shoulder cutter
- 6-corner Shoulder Cutter
- Straight Shank Type
- 25 - 40 mm

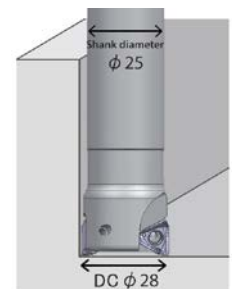
Type 2



EDP	Designation	ZEFP	DC	DCON	LF	LH	APMX	Type	Applicable Inserts	Specification	Price
7803014 <small>NEW</small>	PSTW09R025SS25-2S	2	25	25	120	35	9	1	①	With coolant hole	
7803015 <small>NEW</small>	PSTW09R025SS25-2L	2	25	25	170	70	9	1	①	With coolant hole	
7803016 <small>NEW</small>	PSTW09R025SS25-3S	3	25	25	120	35	9	1	①	With coolant hole	
7803017 <small>NEW</small>	PSTW09R026SS25-2L	2	26*	25	170	35	9	2	①	With coolant hole	
7803018 <small>NEW</small>	PSTW09R028SS25-2L	2	28*	25	170	35	9	2	①	With coolant hole	
7803019 <small>NEW</small>	PSTW09R028SS25-3S	3	28*	25	120	35	9	2	①	With coolant hole	
7803020 <small>NEW</small>	PSTW09R030SS32-2L	2	30	32	190	90	9	1	①	With coolant hole	
7803021 <small>NEW</small>	PSTW09R030SS32-3S	3	30	32	130	45	9	1	①	With coolant hole	
7803022 <small>NEW</small>	PSTW09R032SS32-3S	3	32	32	130	45	9	1	①	With coolant hole	
7803023 <small>NEW</small>	PSTW09R032SS32-3L	3	32	32	190	45	9	1	①	With coolant hole	
7803024 <small>NEW</small>	PSTW09R032SS32-4S	4	32	32	125	40	9	1	①	With coolant hole	
7803025 <small>NEW</small>	PSTW09R033SS32-3L	3	33*	32	190	35	9	2	①	With coolant hole	
7803026 <small>NEW</small>	PSTW09R035SS32-3L	3	35*	32	190	35	9	2	①	With coolant hole	
7803027 <small>NEW</small>	PSTW09R035SS32-4S	4	35*	32	130	35	9	2	①	With coolant hole	
7803028 <small>NEW</small>	PSTW09R040SS32-4S	4	40	32	140	50	9	2	①	With coolant hole	
7803029 <small>NEW</small>	PSTW09R040SS32-4L	4	40	32	190	45	9	2	①	With coolant hole	
7803030 <small>NEW</small>	PSTW09R040SS32-5S	5	40	32	140	50	9	2	①	With coolant hole	

\* Reduced Shank Type

The outer diameter of the reduced shank type is larger than the shank diameter, making it highly effective in the processing of die and mold applications that require vertical wall milling or pocketing.



## Accessories & spare parts

Applicable cutter	Clamping screw	Applicable Inserts	Power screw	Applicable Inserts	Wrench	Applicable Inserts
PSTW BORE Ø 50~125	7808129	FS40511 (Torx 15) ②	TN*U12...		TN*U12...	7808208 T15-D (Torx 15) ②
PSTW SS Ø25~40 PSTW BORE Ø40~63	7808097	FS30668 (Torx 8) ①	TN*U09...		TN*U09...	7808205 T8-D (Torx 8) ①
PSTW BORE Ø50			7808151	PS1031 (M10X31) ②	TN*U12...	

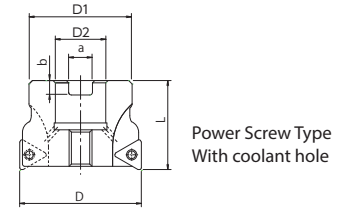
# PSTW BORE

Milling | Indexables

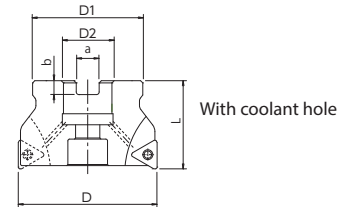


- 90° shoulder cutter
- Double sided 6 corners inserts
- Bore type
- 50 - 125 mm

Type 1



Type 2



EDP	Designation	Z	D	D1	D2	L	a	b	Type	Applicable Inserts	Specification	Price
7803031 <small>NEW</small>	PSTW09R040M16-4	4	40	38	16	40	8,4	5,6	2	①	With coolant hole	
7803032 <small>NEW</small>	PSTW09R040M16-5	5	40	38	16	40	8,4	5,6	2	①	With coolant hole	
7803033 <small>NEW</small>	PSTW09R050M22-4	4	50	45	22	40	10,4	6,3	2	①	With coolant hole	
7803034 <small>NEW</small>	PSTW09R050M22-6	6	50	45	22	40	10,4	6,3	2	①	With coolant hole	
7803035 <small>NEW</small>	PSTW09R063M22-5	5	63	50	22	40	10,4	6,3	2	①	With coolant hole	
7803036 <small>NEW</small>	PSTW09R063M22-7	7	63	50	22	40	10,4	6,3	2	①	With coolant hole	
7803100	PSTW12R050M22-3	3	50	45	22	40	10,4	6,3	1	②	With coolant hole	
7803101	PSTW12R050M22-4	4	50	45	22	40	10,4	6,3	1	②	With coolant hole	
7803102	PSTW12R063M22-3	3	63	50	22	40	10,4	6,3	2	②	With coolant hole	
7803103	PSTW12R063M22-5	5	63	50	22	40	10,4	6,3	2	②	With coolant hole	
7803110	PSTW12R080M27-5	5	80	60	27	50	12,4	7	2	②	With coolant hole	
7803111	PSTW12R080M27-6	6	80	60	27	50	12,4	7	2	②	With coolant hole	
7803112	PSTW12R100M32-5	5	100	70	32	50	14,4	8	2	②	With coolant hole	
7803113	PSTW12R100M32-7	7	100	70	32	50	14,4	8	2	②	With coolant hole	
7803114	PSTW12R125M40-7	7	125	90	40	63	16,4	9	2	②	With coolant hole	
7803115	PSTW12R125M40-9	9	125	90	40	63	16,4	9	2	②	With coolant hole	

Milling | Indexables



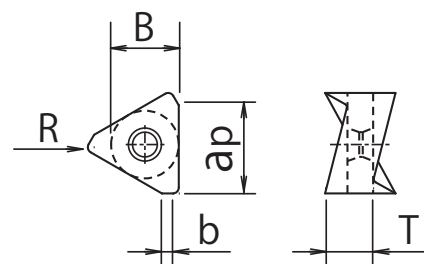
90 degrees

## Accessories & spare parts

Applicable cutter	Clamping screw	Applicable Inserts	Power screw	Applicable Inserts	Wrench	Applicable Inserts
PSTW BORE Ø 50~125	7808129	FS40511 (Torx 15) ②	TN*U12...		TN*U12...	7808208 T15-D (Torx 15) ②
PSTW SS Ø25~40 PSTW BORE Ø40~63	7808097	FS30668 (Torx 8) ①	TN*U09...		TN*U09...	7808205 T8-D (Torx 8) ①
PSTW BORE Ø50			7808151 PS1031 (M10X31) ②	TN*U12...		

# PSTW INSERTS

Milling | Indexables



- 90° shoulder cutter
- Double sided 6 corners inserts

	EDP	Designation	Z	B	T	R	b	ap max	Grade	P		M		K		N		S		H		Price
										dry	⊖	dry	⊖	GG	GGG	dry	⊖	dry	⊖	dry	⊖	
①	7813104	<small>NEW</small> TNHU090404FR-NM	6	7,46	4,64	0,4	1,15	12	CK010								⊖					
②	7811087	TNHU120608ER-NM	6	10,8	6,55	0,8	1,25	12	CK010								⊖					
①	7821091	<small>NEW</small> TNKU090404ER-GM	6	7,46	4,64	0,4	1,2	12	XC3020	⊖				⊖	⊖							
②	7827088	TNKH120608ER-GM	6	10,8	6,55	0,8	1,5	12	XC3020	⊖				⊖	⊖							
①	7821092	<small>NEW</small> TNKU090404ER-GM	6	7,46	4,64	0,4	1,2	12	XP3025		⊖			⊖	⊖							
②	7828088	TNKH120608ER-GM	6	10,8	6,55	0,8	1,5	12	XP3025		⊖			⊖	⊖							
①	7821095	<small>NEW</small> TNKU090404ER-GL	6	7,46	4,64	0,4	1,2	12	XC3030	⊖				⊖	⊖							
②	7825089	TNKH120608ER-GL	6	10,8	6,55	0,8	1,5	12	XC3030	⊖				⊖	⊖							
①	7821093	<small>NEW</small> TNKU090404ER-GM	6	7,46	4,64	0,4	1,2	12	XC3030	⊖				⊖	⊖							
②	7825088	TNKH120608ER-GM	6	10,8	6,55	0,8	1,5	12	XC3030	⊖				⊖	⊖							
①	7813101	<small>NEW</small> TNKU090404ER-GL	6	7,46	4,64	0,4	1,2	12	XP3035	⊖	⊖		⊖	⊖	⊖	⊖						
②	7814089	TNKH120608ER-GL	6	10,8	6,55	0,8	1,5	12	XP3035	⊖	⊖		⊖	⊖	⊖	⊖						
①	7813097	<small>NEW</small> TNKU090404ER-GM	6	7,46	4,64	0,4	1,2	12	XP3035	⊖	⊖		⊖	⊖	⊖	⊖						
①	7813105	<small>NEW</small> TNKU090408ER-GM	6	7,46	4,64	0,8	0,9	12	XP3035	⊖	⊖		⊖	⊖	⊖	⊖						
①	7813107	<small>NEW</small> TNKU090412ER-GM	6	7,46	4,64	1,2	0,6	12	XP3035	⊖	⊖		⊖	⊖	⊖	⊖						
②	7814094	TNKH120612ER-GM	6	10,8	6,55	1,2	1,0	12	XP3035	⊖	⊖		⊖	⊖	⊖	⊖						
②	7814095	TNKH120616ER-GM	6	10,8	6,55	1,6	0,75	12	XP3035	⊖	⊖		⊖	⊖	⊖	⊖						
②	7814096	TNKH120620ER-GM	6	10,8	6,55	2,0	0,60	12	XP3035	⊖	⊖		⊖	⊖	⊖	⊖						
②	7814088	TNKH120608ER-GM	6	10,8	6,55	0,8	1,5	12	XP3035	⊖	⊖		⊖	⊖	⊖	⊖						
①	7813098	<small>NEW</small> TNKU090404ER-GM	6	7,46	4,64	0,4	1,2	12	XP2040	⊖	⊖		⊖	⊖	⊖	⊖			⊖	⊖		
①	7813106	<small>NEW</small> TNKU090408ER-GM	6	7,46	4,64	0,8	0,9	12	XP2040	⊖	⊖		⊖	⊖	⊖	⊖			⊖	⊖		
①	7813108	<small>NEW</small> TNKU090412ER-GM	6	7,46	4,64	1,2	0,6	12	XP2040	⊖	⊖		⊖	⊖	⊖	⊖			⊖	⊖		
②	7813088	TNKH120608ER-GM	6	10,8	6,55	0,8	1,5	12	XP2040	⊖	⊖		⊖	⊖	⊖	⊖			⊖	⊖		
②	7813094	TNKH120612ER-GM	6	10,8	6,55	1,2	1,0	12	XP2040	⊖	⊖		⊖	⊖	⊖	⊖			⊖	⊖		
②	7813095	TNKH120616ER-GM	6	10,8	6,55	1,6	0,75	12	XP2040	⊖	⊖		⊖	⊖	⊖	⊖			⊖	⊖		
②	7813096	TNKH120620ER-GM	6	10,8	6,55	2,0	0,60	12	XP2040	⊖	⊖		⊖	⊖	⊖	⊖			⊖	⊖		
①	7813100	<small>NEW</small> TNKU090404ER-GL	6	7,46	4,64	0,4	1,2	12	XP2040	⊖	⊖		⊖	⊖	⊖	⊖			⊖	⊖		
②	7813089	TNKH120608ER-GL	6	10,8	6,55	0,8	1,5	12	XP2040	⊖	⊖		⊖	⊖	⊖	⊖			⊖	⊖		
①	7813099	<small>NEW</small> TNKU090404ER-GM	6	7,46	4,64	0,4	1,2	12	XC1015					⊖	⊖							
②	7812088	TNKH120608ER-GM	6	10,8	6,55	0,8	1,5	12	XC1015					⊖	⊖							
①	7813102	<small>NEW</small> TNKU090404ER-GR	6	7,46	4,64	0,4	1,2	12	XC1015					⊖	⊖							
②	7812090	TNKH120608ER-GR	6	10,8	6,55	0,8	1,5	12	XC1015					⊖	⊖							
①	7821094	<small>NEW</small> TNKU090404ER-GM	6	7,46	4,64	0,4	1,2	12	XP1020					⊖	⊖							
②	7821088	TNKH120608ER-GM	6	10,8	6,55	0,8	1,5	12	XP1020					⊖	⊖							
①	7821096	<small>NEW</small> TNKU090404ER-GR	6	7,46	4,64	0,4	1,2	12	XP1020					⊖	⊖							
②	7821090	TNKH120608ER-GR	6	10,8	6,55	0,8	1,5	12	XP1020					⊖	⊖							
①	7813103	<small>NEW</small> TNKU090404ER-SM	6	7,46	4,64	0,4	1,2	12	XC5040				⊖						⊖			
②	7816091	TNKH120608ER-SM	6	10,8	6,55	0,8	1,5	12	XC5040				⊖						⊖			

## Cutting conditions

	Work Material	Tensile Strength / Hardness	Milling Speed Vc (m/min)	Insert size			
				TN*U09...		TN*U12...	
				Feed per Tooth fz (mm/t)	Depth of Cut ap (mm)	Feed per Tooth fz (mm/t)	Depth of Cut ap (mm)
P	Mild Steel-Carbon Steel (S5400-S10C)	~180HB	180 (100~250)	0,12 (0,05~0,2)	2	0,15 (0,05~0,25)	3
	Carbon Steel-Alloy Steel (S50C-SCM440)	~280HB	180 (100~250)	0,12 (0,05~0,2)	2	0,15 (0,05~0,25)	3
	Die Steel (SKD11-SKD61)	~280HB	150 (80~200)	0,1 (0,05~0,18)	2	0,12 (0,05~0,2)	3
M	Stainless Steel (Dry) (SUS304-SUS420)	~250HB	150 (80~200)	0,08 (0,05~0,16)	1,5	0,1 (0,05~0,18)	2
	Stainless Steel (Wet) (SUS304,SUS420)	~250HB	80 (60~120)	0,08 (0,05~0,16)	1,5	0,1 (0,05~0,18)	2
K	Cast Iron (FC250)	~350N/mm <sup>2</sup>	200 (100~350)	0,15 (0,05~0,25)	2	0,2 (0,1~0,3)	3
	Ductile Cast Iron (FCD400)	~800N/mm <sup>2</sup>	180 (100~270)	0,12 (0,05~0,2)	2	0,15 (0,05~0,25)	3
N	Aluminium Alloy	~13%Si	300 (200~1.500)	0,12 (0,08~0,25)	2	0,15 (0,1~0,3)	3
S	Superalloy (Wet) (Inconel®718)	-	35 (25~60)	0,06 (0,04~0,1)	0,8	0,08 (0,05~0,15)	1
	Titanium Alloy (Ti-Al-4V)	-	40 (30~120)	0,06 (0,04~0,1)	1	0,08 (0,05~0,15)	1,5
H	Pre-hardened Steel (NAK80)	40~43HRC	100 (50~150)	0,08 (0,06~0,15)	1	0,1 (0,08~0,2)	1,5
	Steel for Die Casting (DAC55-DH31)	43~48HRC	80 (40~120)	0,06 (0,05~0,13)	0,8	0,08 (0,06~0,15)	1
	Hardened Steel (SKD11)	50~55HRC	60 (40~90)	0,05 (0,04~0,08)	0,4	0,06 (0,05~0,1)	0,5

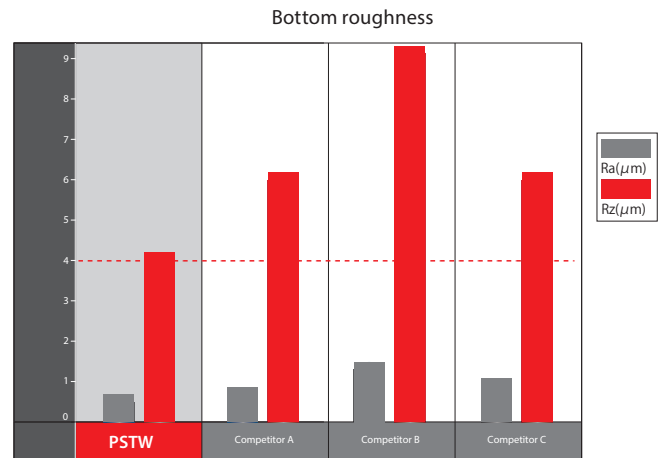


# PHOENIX PSTW

Milling | Indexables

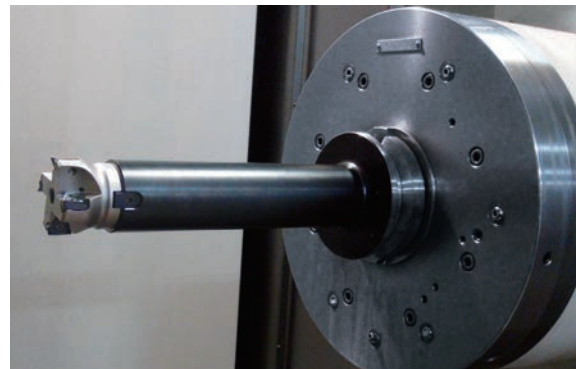
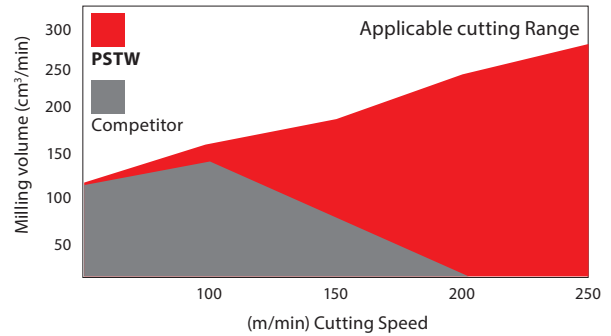
## Excellent surface roughness

Tool	PSTW12R050M22-4 (Ø 50 x 4 flutes)
Insert Grade	TN KU120608ER-GM (XP3035)
Work Material	S50C
Cutting Speed	200m/min (1,274min <sup>-1</sup> )
Feed	510mm/min (0.1mm/t)
Depth of cut	a <sub>p</sub> =0.2mm a <sub>e</sub> =32mm
Coolant	Air Blow
Machine	Horizontal Machining Center



## High efficiency even in long overhang length applications

Tool	PSTW12R050M22-4 (Ø 50 x 4 flutes)	(Ø 50 x 5 flutes) Competitor's Single Sided Insert Cutter
Insert grade	TN KU120608ER-GM (XP3035)	Coated Carbide Insert
Work Material	S50C	
Cutting Method	Slot Milling	
Depth of cut	a <sub>p</sub> =3mm a <sub>e</sub> =50mm	
Overhang length	190mm(3.8D)	
Coolant	Air Blow	
Machine	Horizontal Machining Center	



## Insert variation based on application

Chipbreaker	NM	GL	GM	GR	SM
	Aluminium Alloy & Non-Ferrous metal	Low-resistance machining	Multi-purpose machining & General steel milling	Intermitted machining & Cast iron machining	Superalloy & Difficult-to-machine material
Application					

Milling | Indexables

Inserts

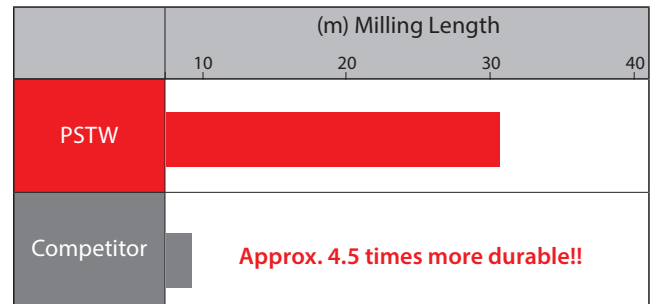
# PROCESSING DATA

Milling | Indexables

## Long tool life in S50C

Tool	<b>PSTW09R025SS25-3S</b> (Ø25 x 3 flutes)	Competitor (Ø25 x 3 flutes)
Insert Grade	TNKU090604ER-GM (XP3035)	Coated Carbide Insert
Work Material	S50C	
Cutting Speed	180m/min(2.290 min <sup>-1</sup> )	
Feed	825 mm/min(0,12mm/t)	
Depth of Cut	ap=2mm ae=16mm	
Coolant	Air Blow	
Machine	Vertical Machining Center	

The PSTW demonstrates greater wear resistance and achieves approximately 4,5 times the durability versus the competitor tool.



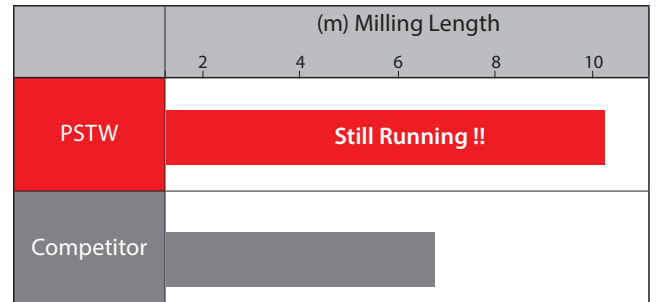
After machining 7m



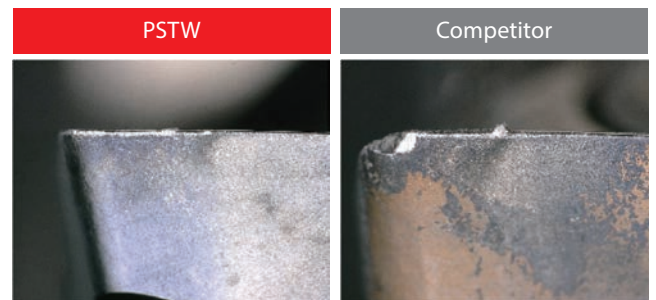
## Long tool life in SUS304

Tool	<b>PSTW09R025SS25-3S</b> (Ø25 x 3 flutes)	Competitor (Ø25 x 3 flutes)
Insert Grade	TNKU090604ER-GL (XP2040)	Coated Carbide Insert
Work Material	SUS304	
Cutting Speed	150m/min(1.910 min <sup>-1</sup> )	
Feed	460 mm/min(0,08mm/t)	
Depth of Cut	ap=1,5mm ae=16mm	
Coolant	Air Blow	
Machine	Vertical Machining Center	

The PSTW demonstrates about 1.5 times the durability versus the competitor tool, and its inserts exhibit no chipping and can continued to be used after milling 10,5 m.



After machining 7m



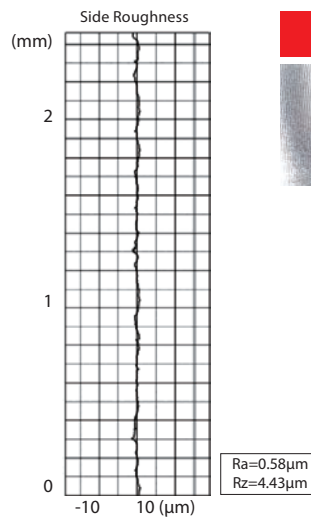
# PROCESSING DATA

Milling | Indexables

## High-precision machining of press mold slide surface

Tool	PSTW12R050M22-4 (Ø50 x 4 flutes)
Insert Grade	TNKH120608ER-GR (XP1020)
Work Material	FCD500
Cutting Speed	300m/min (1,910min <sup>-1</sup> )
Feed	1,700mm/min (0.2mm/t)
Depth of Cut	ap=0.5mm ae=0.3mm
Overhang Length	240mm
Coolant	Air Blow
Machine	Double Column Machining Center

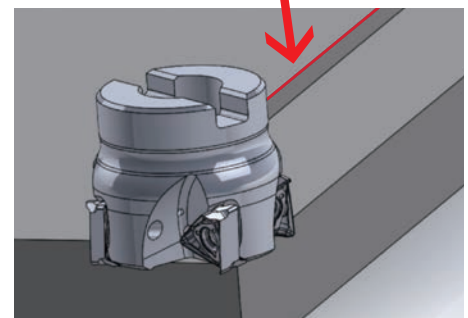
The PSTW was able to achieve excellent surface precision during side finishing, satisfying the required run-out accuracy of under 10µm.



## High efficiency machining of SUS304 (Stainless steel)

Tool	PSTW12R050M22-4 (Ø50 x 4 flutes)	Competitor's Single Sided Insert Cutter (Ø50 x 5 flutes)
Insert Grade	TNKH120608ER-GL (XP2040)	Coated Carbide Insert
Work Material	SUS304	
Cutting Speed	150m/min(955min <sup>-1</sup> )	
Feed	700mm/min(0.18mm/t)	700mm/min(0.15mm/t)
Depth of Cut	ap=5mm ae=35mm	ap=3mm ae=35mm
Coolant	Water Soluble	
Machine	Double Column Machining Center	

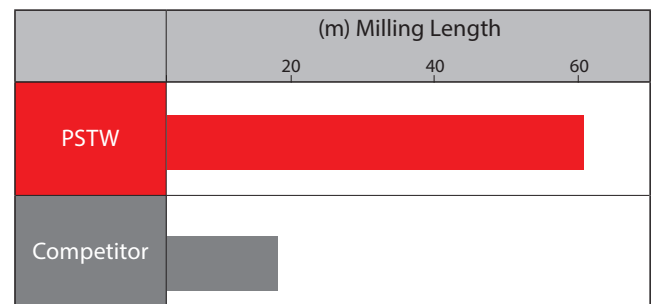
With the increase of depth of cut (ap), the competitor tool exhibited chattering and burrs, which hindered further efficiency improvement. Whereas the PSTW, even with one less corner, was able to increase machining efficiency by 67%, allowing high productivity.



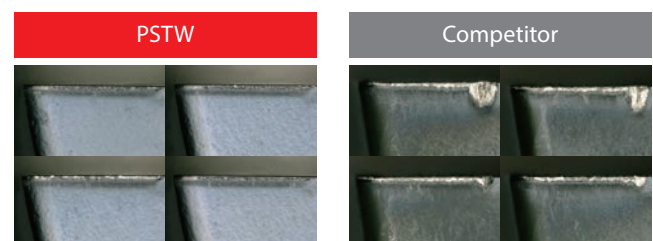
## Rough milling of construction machinery control valve

Tool	PSTW12R063M22-5 (Ø63 x 5 flutes)	Competitor's Double Sided Insert Cutter (Ø63x 5 flutes)
Insert Grade	TNKH120608ER-GR (XP1020)	Coated Carbide Insert
Work Material	FCD500	
Cutting Speed	180m/min(910min <sup>-1</sup> )	
Feed	1,000mm/min(0.22mm/t)	
Depth of Cut	ap=3mm ae=45mm	
Coolant	Air Blow	
Machine	Horizontal Machining Center	

The PSTW demonstrated much greater wear resistance versus the competitor tool. In particular, it was able to effectively suppress wear progress of the cutting edge and achieved 3.5 times the durability versus the competitor.



After machining 17m





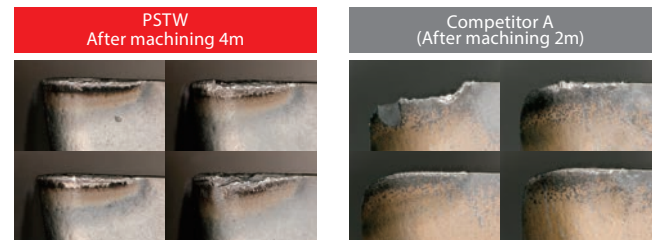
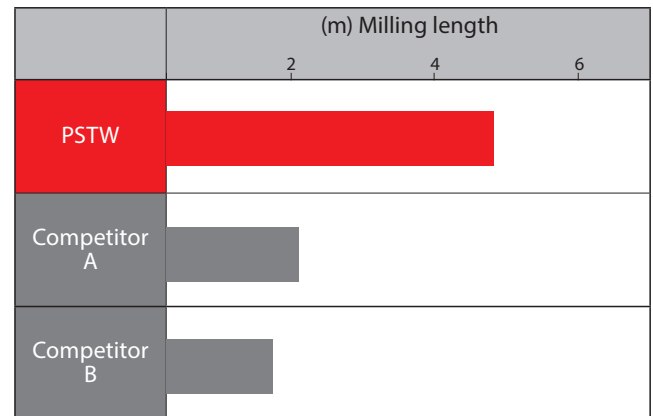
# PROCESSING DATA

Milling | Indexables

## Long tool life in Ti-6Al-4V

Tool	<b>PSTW12R050M22-4</b> (Ø50 x 4 flutes)	Competitor's Double Sided Insert Cutter A,B (Ø50x 4 flutes)
Insert Grade	TN KU120608ER-5M (XC5040)	Coated Carbide Insert
Work Material	Ti-6Al-4V	
Cutting Speed	40m/min(255min <sup>-1</sup> )	
Feed	82mm/min(0.08mm/t)	
Depth of Cut	a <sub>p</sub> =1.5mm a <sub>e</sub> =20mm	
Coolant	Air Blow	
Machine	Horizontal Machining Center	

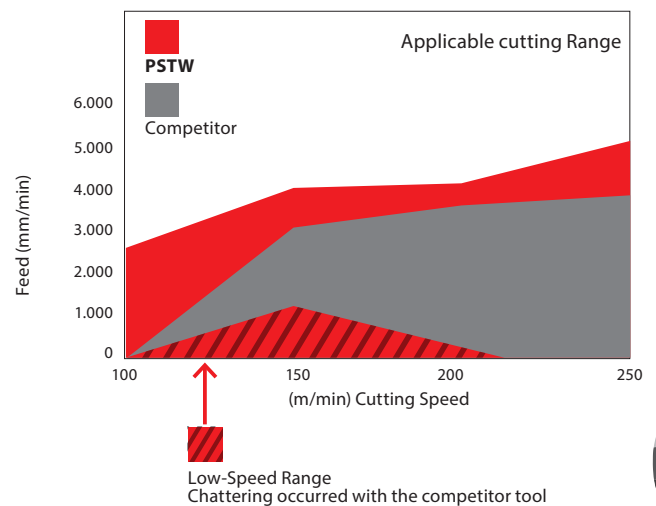
The PSTW (XC5040) was able to suppress wear resistance to prolong durability whereas the competitor equivalent product (double sided triangle insert) exhibited early wear and chipping.



## Highly efficient stable processing of long overhang length of 300 mm (5D)

Tool	<b>PSTW12R063M22-5</b> (Ø63 x 5 flutes)	Competitor's Double Sided Insert Cutter (Ø63 x 4 flutes)
Insert Grade	TN KU120608ER-GM (XC3030)	Coated Carbide Insert
Work Material	FC250	
Depth of Cut	a <sub>p</sub> =2mm a <sub>e</sub> =44mm	
Overhang Length	300mm (5D)	
Coolant	Air Blow	
Machine	Horizontal Machining Center	

In this test, the PSTW achieved higher efficiency versus the competitor tool in the processing of long overhang length of L/D=5. Furthermore, due to the lack of sharpness in the cutting edge, the competitor tool had poor contact with the workpiece in the low-speed machining range, resulting in chattering (lined area on graph). With an ultra sharp cutting edge, the PSTW was able to achieve stable performance even in the low-speed cutting range.



Milling | Indexables  
Processing Data

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