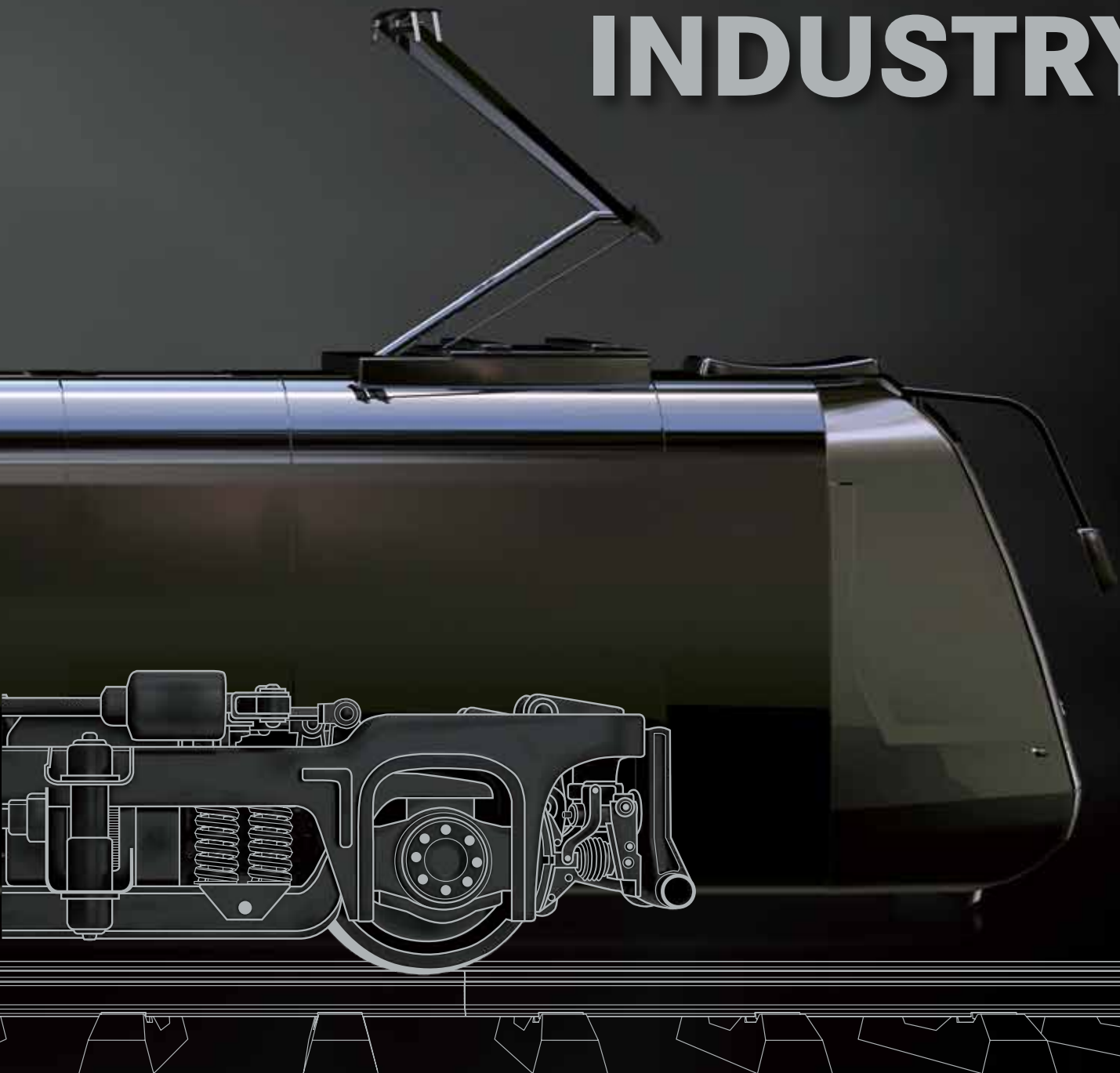


Technical Information **KORLOY**

RAILWAY INDUSTRY



RAILWAY INDUSTRY



Axle



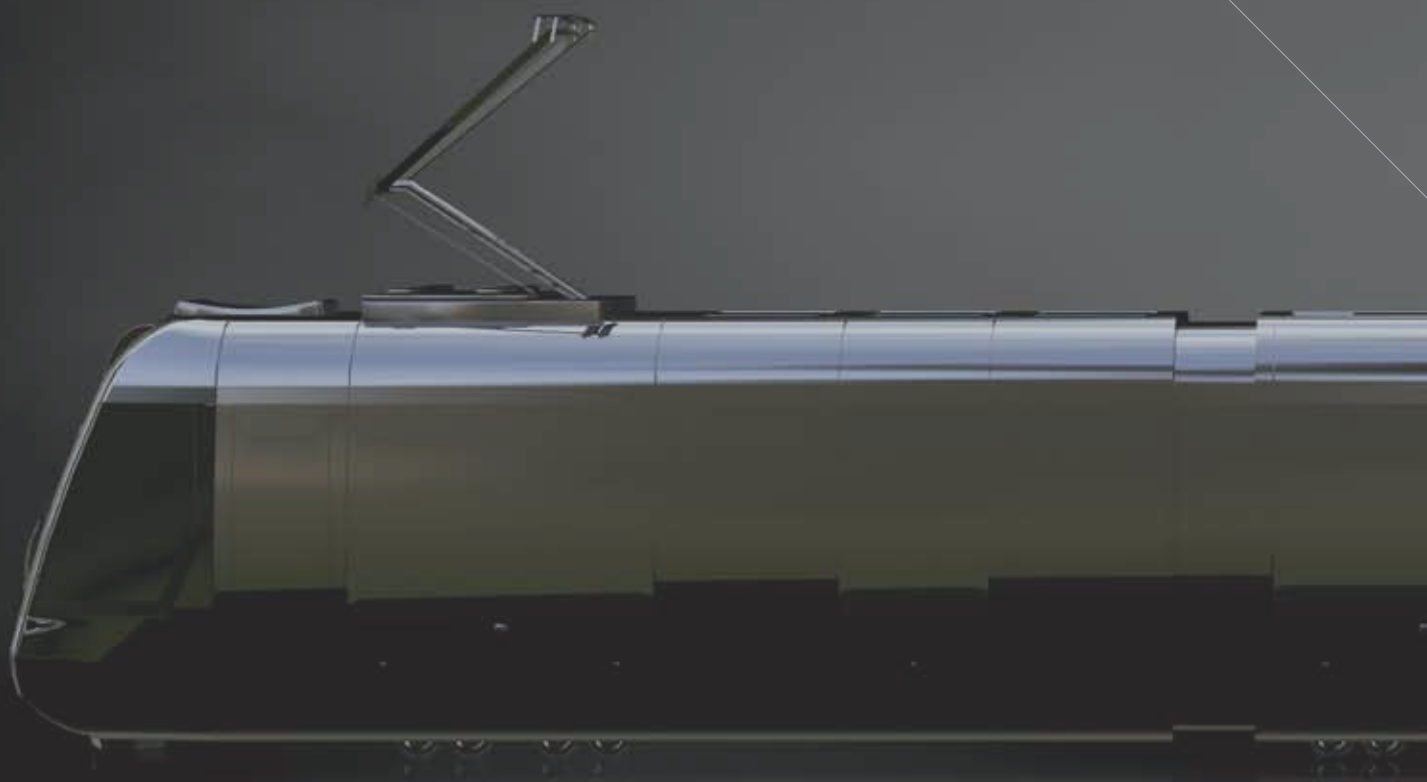
Wheel

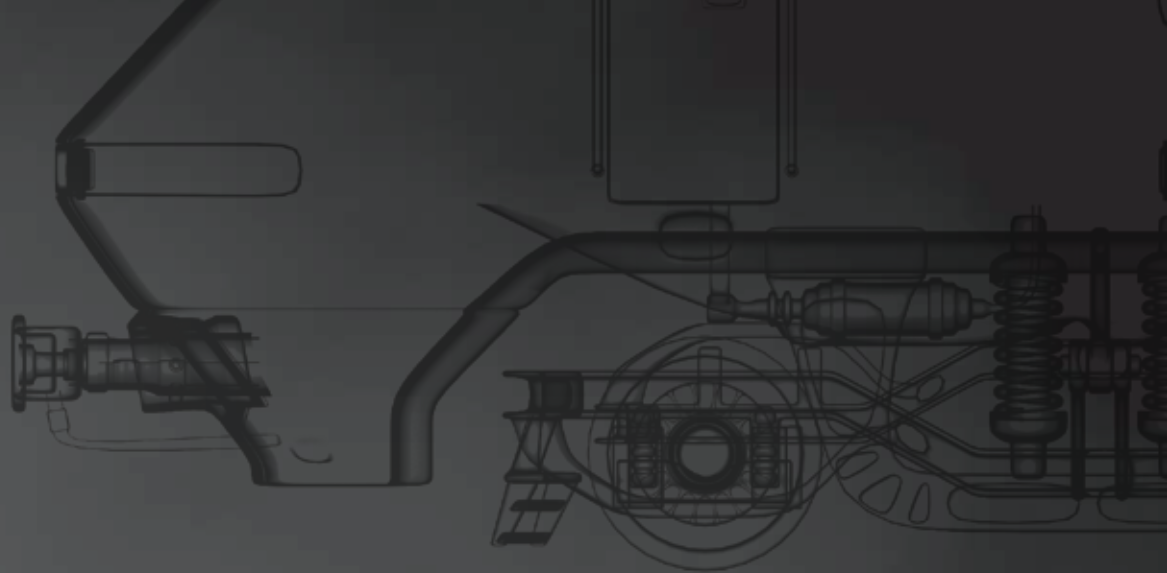


Wheel Repair

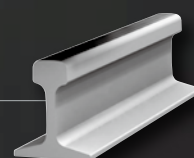


Bogie





- 01 — Rail Repair
- 02 — Axle
- 03 — Wheel
- 04 — Rail & Crossing
- 05 — Wheel Repair
- 06 — Bogie



Rail Repair

RAILWAY INDUSTRY

Contents

RAILWAY INDUSTRY

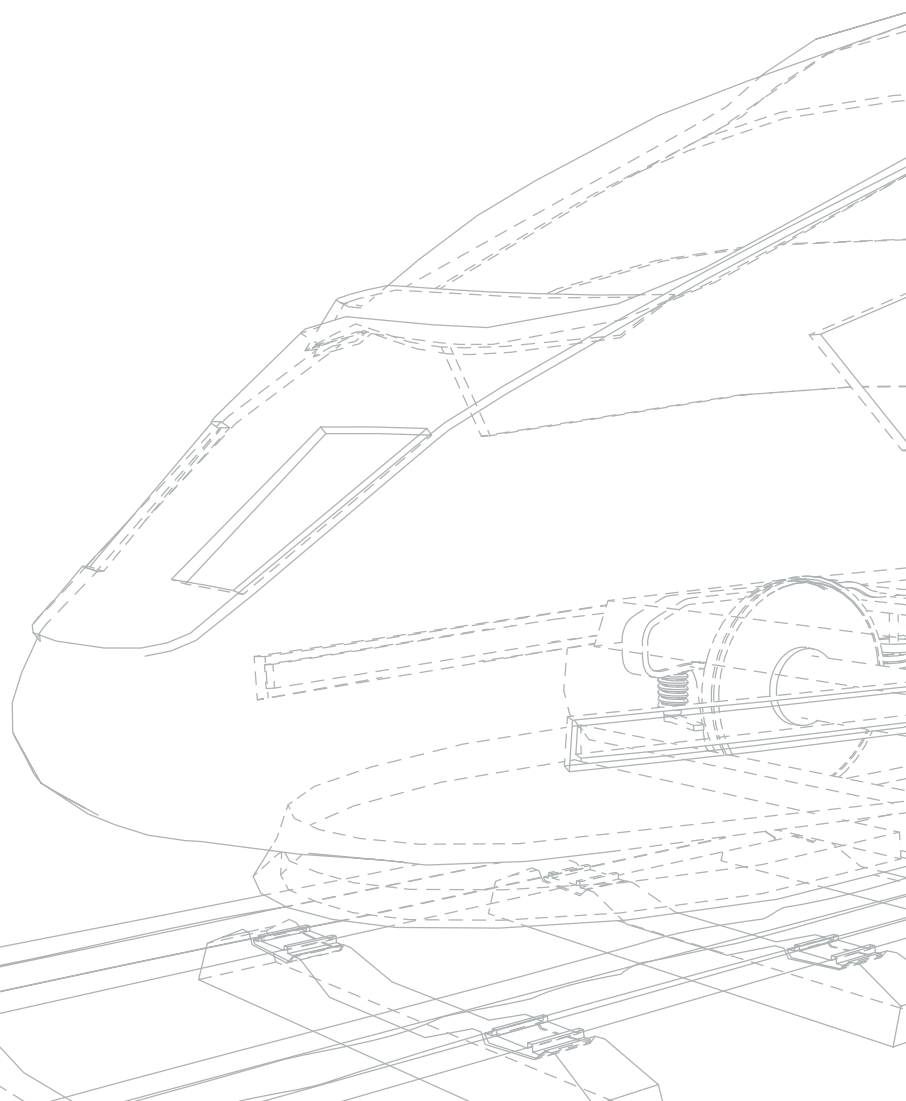
Part 1

**Railway Structural
Components and
Applicable Tools**

1	Rail Repair	006
2	Axle	008
3	Wheel	010
4	Rail & Crossing	012
5	Wheel Repair	014
6	Bogie	016
7	Chip Breaker	020



**Railway
Industry**



RAILWAY INDUSTRY

Part 2

Application Example

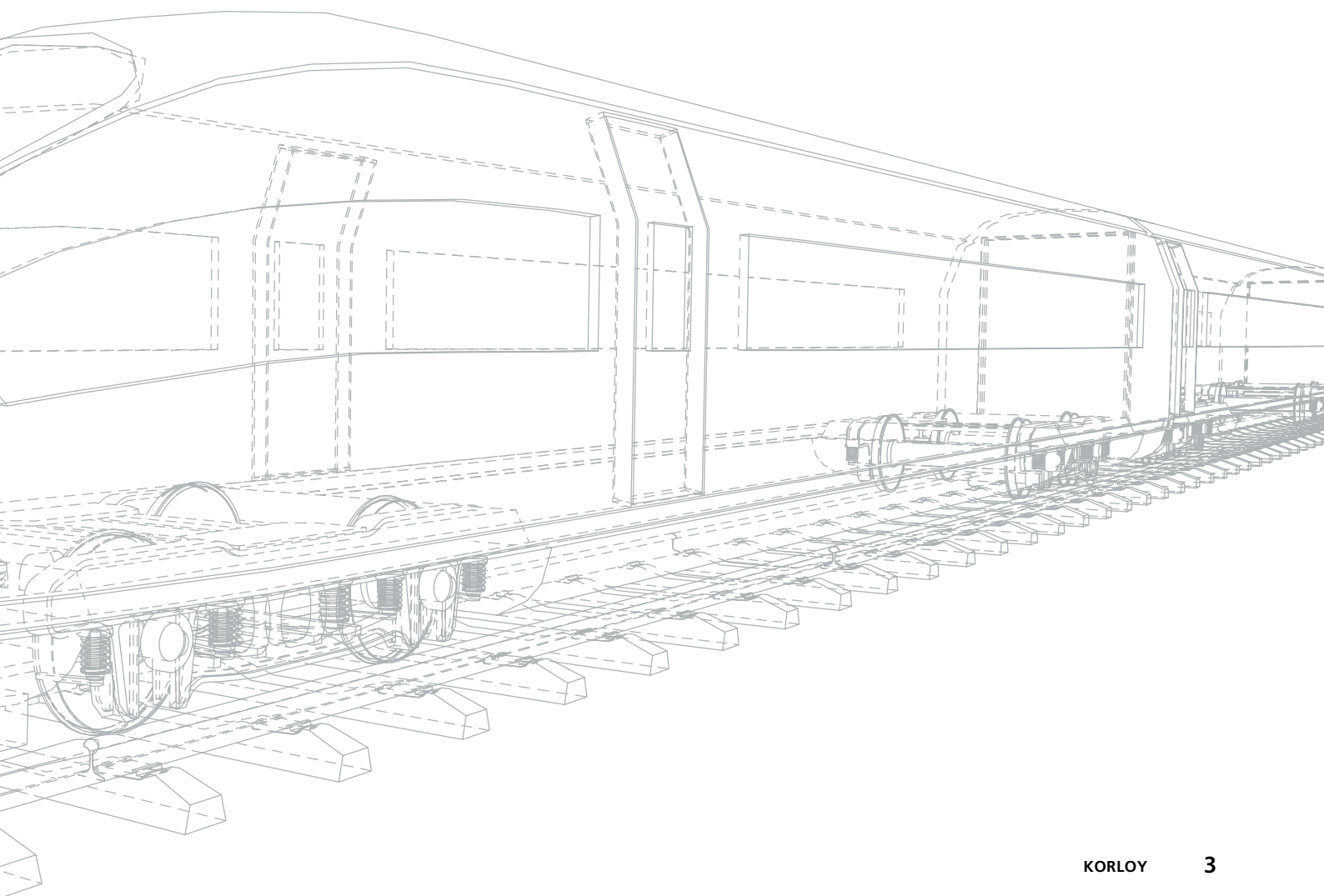
1	Cutting Conditions for Axle	020
2	Cutting Conditions for Wheel	022
3	Cutting Conditions for Bogie	024

RAILWAY INDUSTRY

Part 3

Product Details

1	Turning	028
2	Milling	030
3	Drilling	033



A blurred, high-speed photograph of a train moving from left to right, creating a sense of motion. The train is dark, and the background is a mix of grey and blue tones. The image is used as a background for the title page.

RAILWAY INDUSTRY

Part 1

RAILWAY INDUSTRY

Part 1

Railway Structural Components and Applicable Tools

01	Rail Repair	006
02	Axle	008
03	Wheel	010
04	Rail & Crossing	012
05	Wheel Repair	014
06	Bogie	016
07	Chip Breaker	017

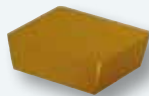
01 Cutter for Rail Repair

<Wedge type(60KgK-SMRP-RW)>

The number of edges : 128

Cutters for repairing the shape of rail with abnormal wear

⇒ Product Details: P.28~34



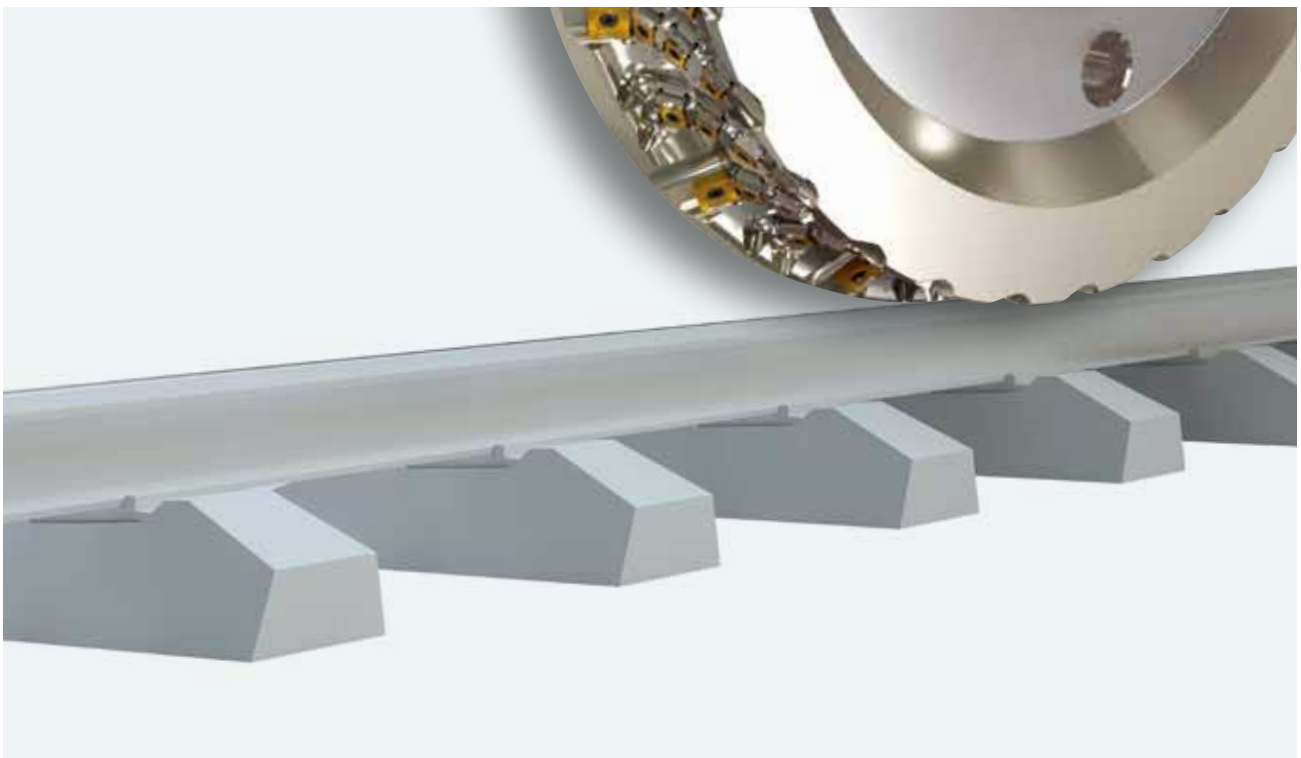
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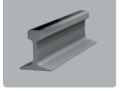


Railway Industry

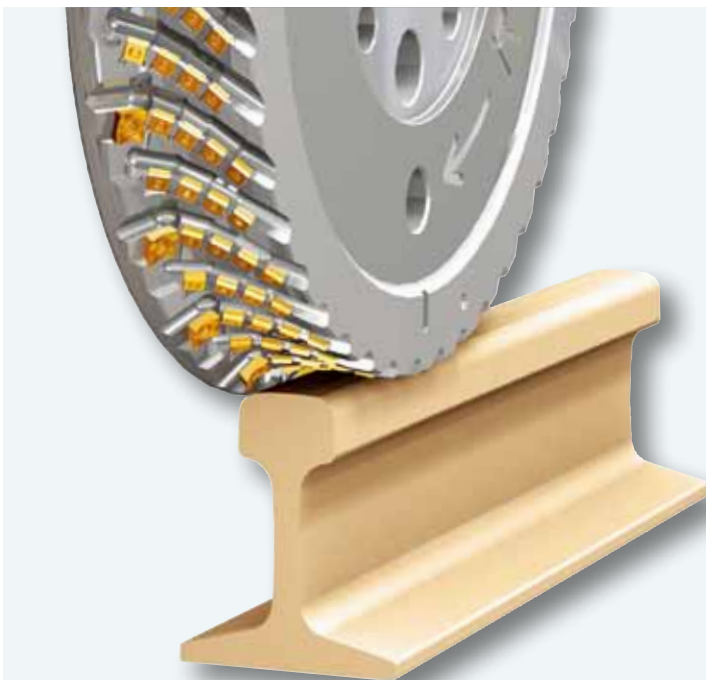
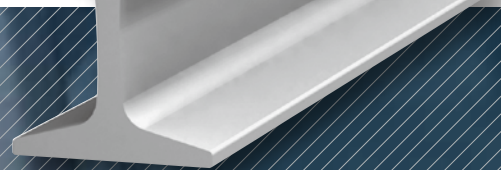
1

Rail Repair





RAILWAY
INDUSTRY



02 Cutter for Rail Repair

<Screw on type(60KgK-SMRP-RS01)>

The number of edges : 198

Cutters for repairing the shape of rail with abnormal wear

⇒ Product Details: P.28~34



< LPE/SPEW type >

01 Inserts for Heavy Duty Machining

<SNMM>

[External / Profile]

Turning for heavy duty machining

➡ Application Example: P.20~22

➡ Product Details: P.28~34



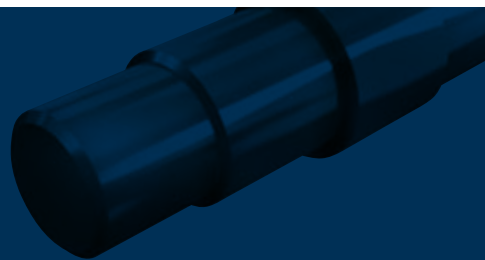
< SNMM type >



Railway Industry

2

Axle



02 Holders

<PRDCN(RCMX)>

[External / Profile]

Turning for heavy duty machining

➡ Application Example: P.20~22

➡ Product Details: P.28~34



< RCMX type >





Axle

03 Rich Mill

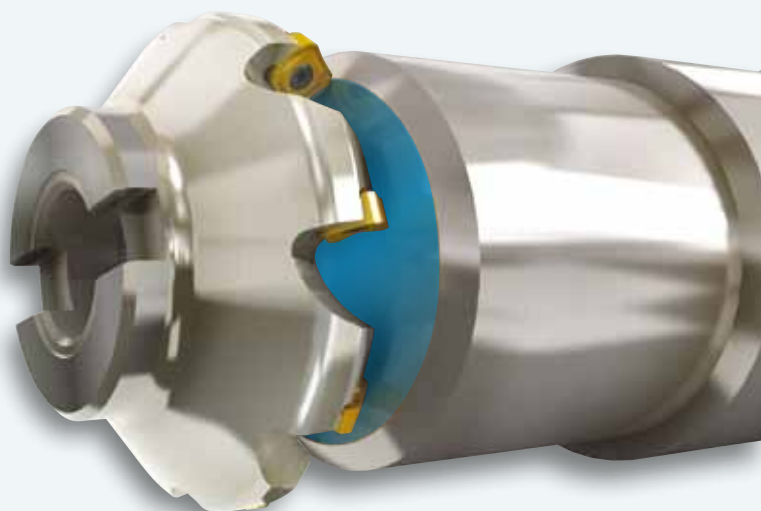
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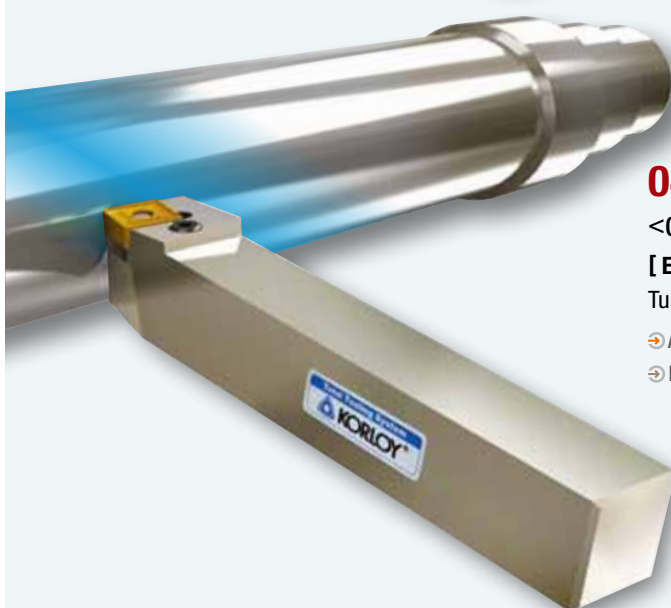
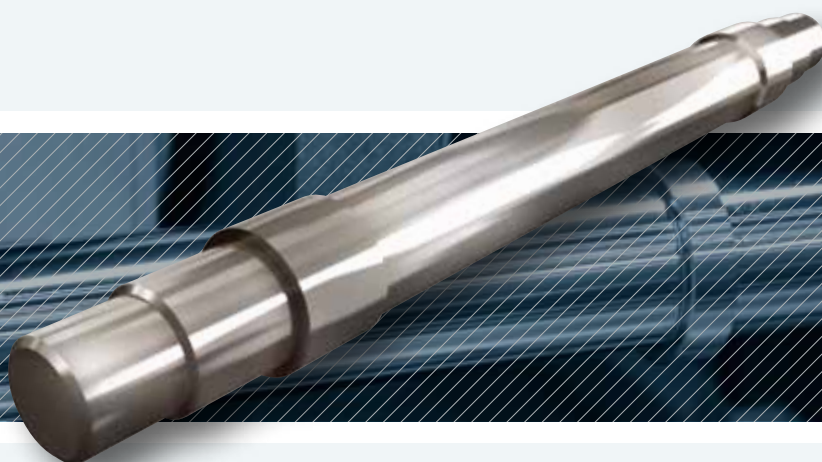
Roughing and finishing for top surface facing

➡ Application Example: P.20~22

➡ Product Details: P.28~34



RAILWAY
INDUSTRY



04 Inserts for Heavy Duty Machining

<CNMM>

[External / Profile]

Turning for heavy duty machining

➡ Application Example: P.20~22

➡ Product Details: P.28~34



< CNMM type >

01 Inserts for Heavy Duty Machining

<SNMM/CNMM>

[External / Profile]

Turning for heavy duty machining

➔ Application Example: P.22~23

➔ Product Details: P.28~34



Railway Industry

3

Wheel



02 Holders

<PRDCN(RCMX)>

[Wheel External / Profile]

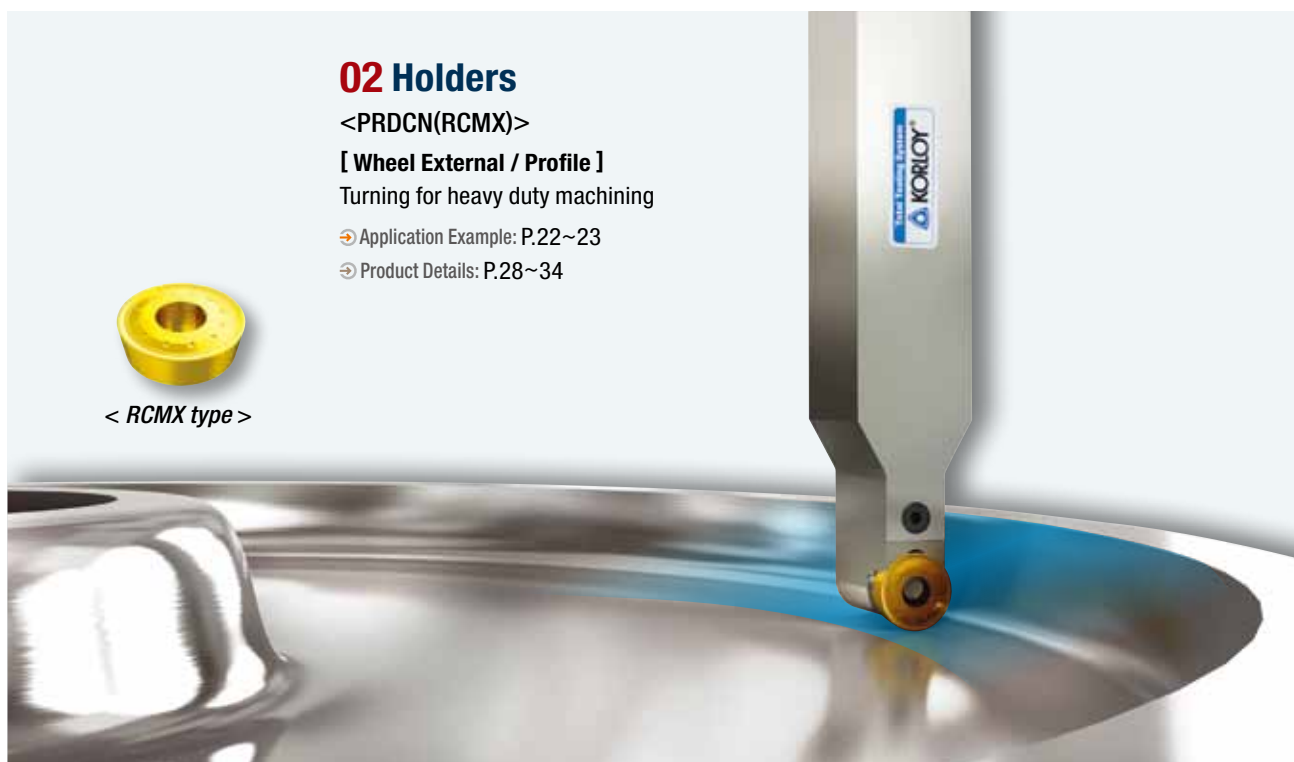
Turning for heavy duty machining

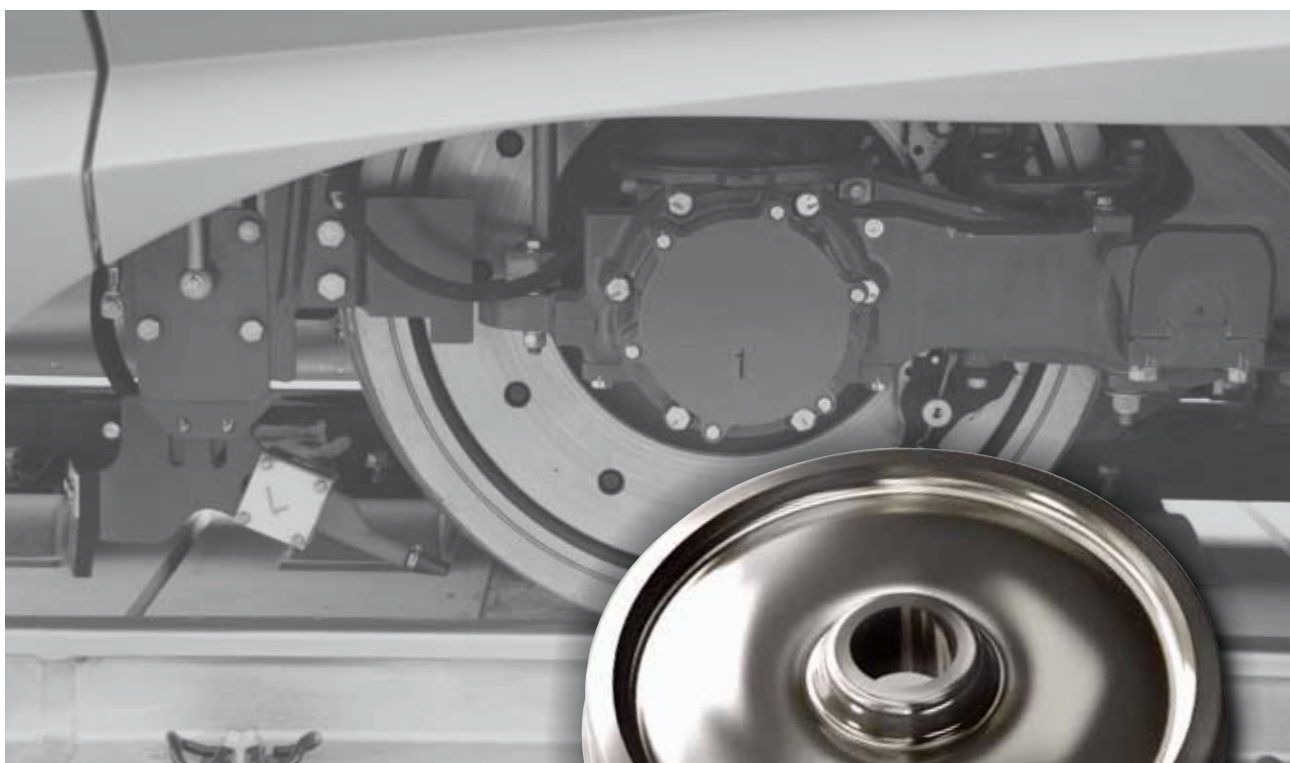
➔ Application Example: P.22~23

➔ Product Details: P.28~34



< RCMX type >





RAILWAY
INDUSTRY

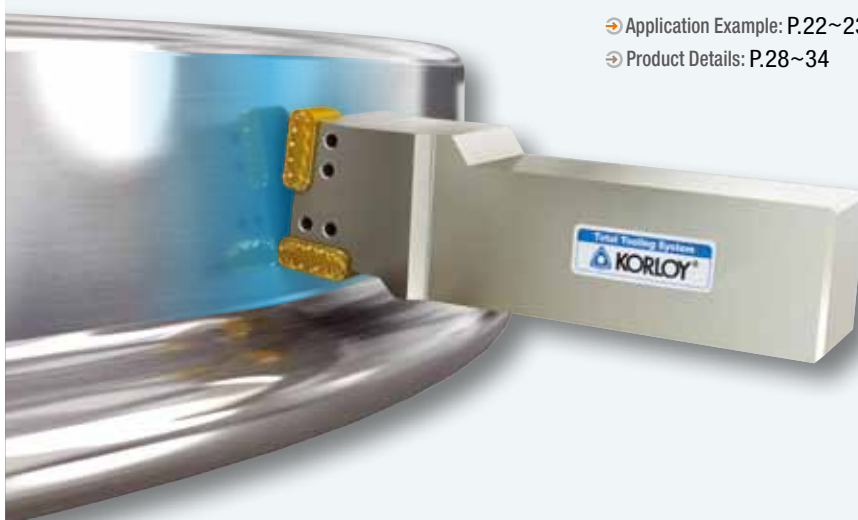
03 LNUX Insert for Rail Way Wheel

<LNUX>

[External / Profile-Finishing]

➡ Application Example: P.22~23

➡ Product Details: P.28~34



< LNUX type >

01 Forming Cutter for the Top Side of Rail Way

- Cutter diameter: $\varnothing 300(\text{mm})$
- Number of tooth: 33
- One body design of cutter and arbor provides high rigidity

⇒ Product Details: P.28~34



Railway Industry

4

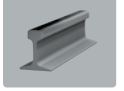
Rail & Crossing



02 Periphery Face Milling for the Top Side of Rail Way

- Cutter diameter: $\varnothing 240(\text{mm})$
- Number of tooth: 25

⇒ Product Details: P.28~34



03 Forming Cutter for the Top Side of Rail Way

- Cutter diameter: Ø160(mm)
- Number of tooth: 16
- Precise forming of rail way is possible

➡ Product Details: P.28~34



RAILWAY
INDUSTRY

04 Rail Separator Joint Face Milling Cutter

- Cutter diameter: Ø160(mm)
- Number of tooth: 54
- Special customizing is available upon customer's requests

➡ Product Details: P.28~34



01 Inserts for Heavy Duty Machining

<SNMM/CNMM>

[External / Profile]

Turning for heavy duty machining

⇒ Product Details: P.28~34



< SNMM/CNMM type >



Railway Industry

5

Wheel Repair



02 LNUX Insert for Wheel Repair

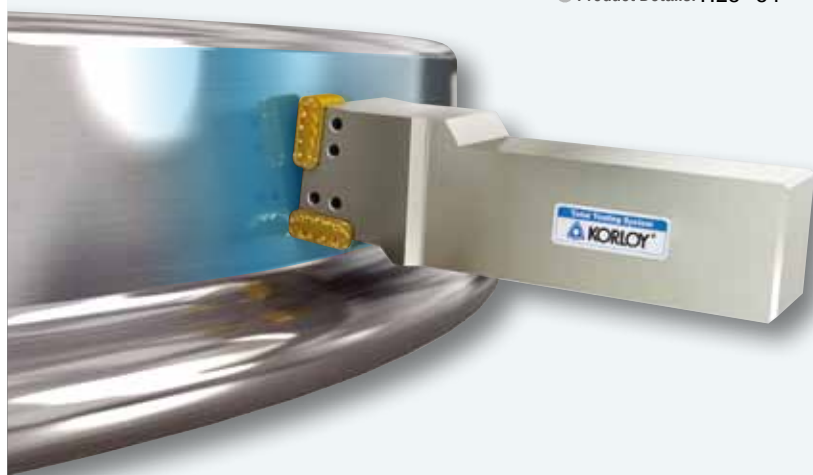
<LNUX>

[External / Profile-Finishing]

⇒ Product Details: P.28~34



< LNUX type >





RAILWAY
INDUSTRY



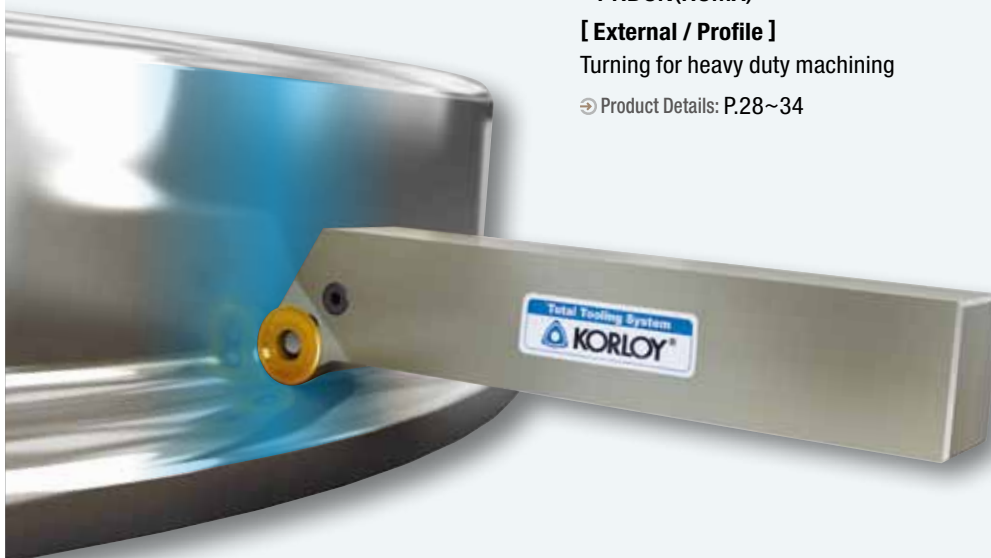
03 Holders

<PRDCN(RCMX)>

[External / Profile]

Turning for heavy duty machining

⇒ Product Details: P.28~34



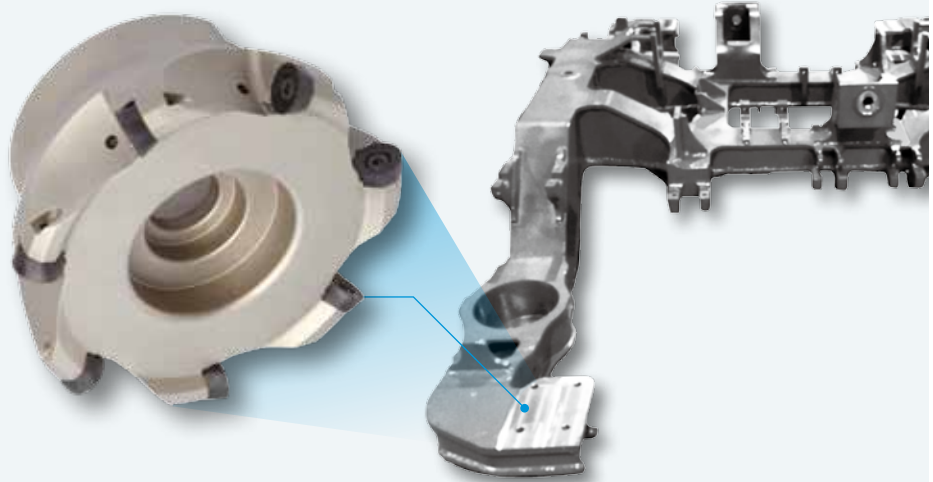
< RCMX type >

01 FMR-P Positive

[Facing]

➡ Application Example: P.24~25

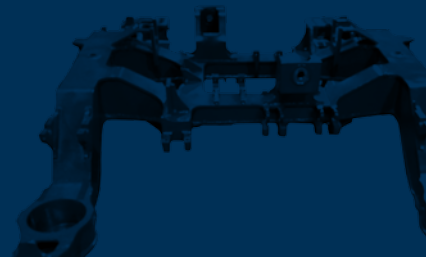
➡ Product Details: P.28~34



Railway Industry

6

Bogie

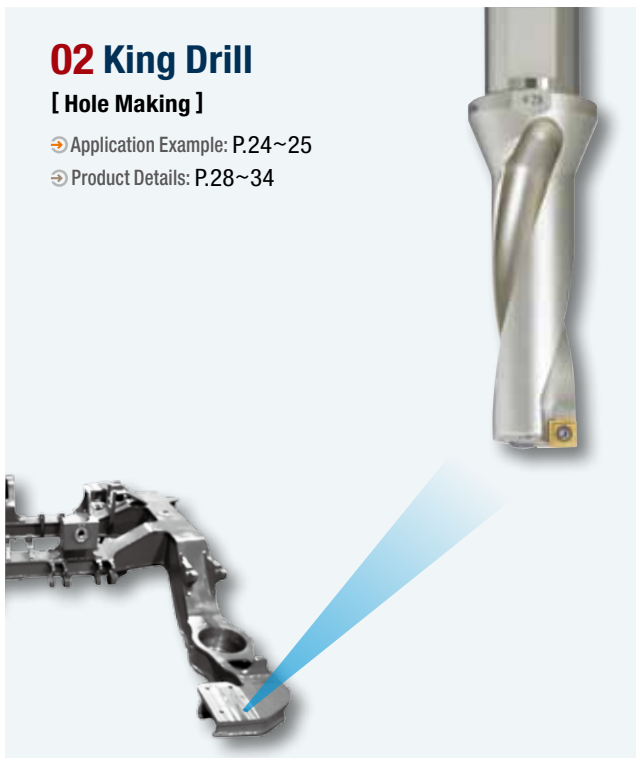


02 King Drill

[Hole Making]

➡ Application Example: P.24~25

➡ Product Details: P.28~34

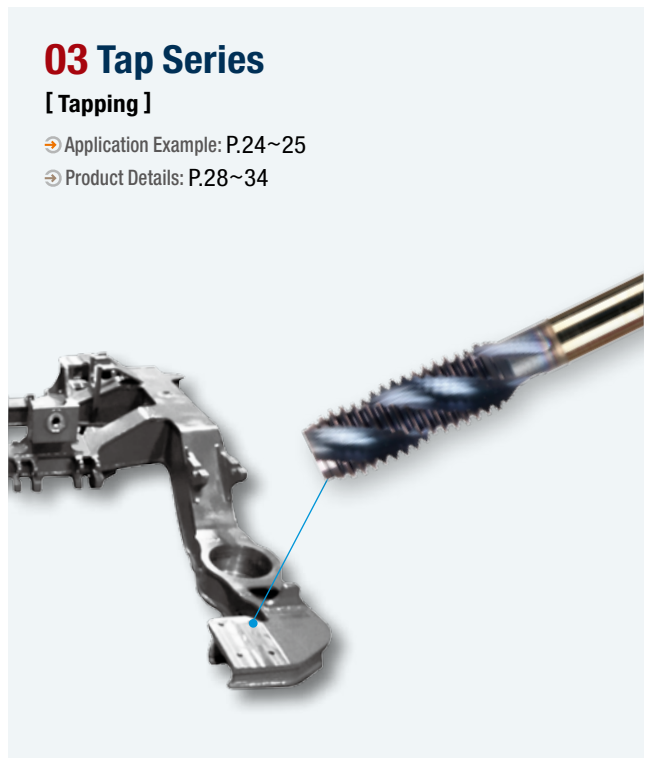


03 Tap Series

[Tapping]

➡ Application Example: P.24~25

➡ Product Details: P.28~34

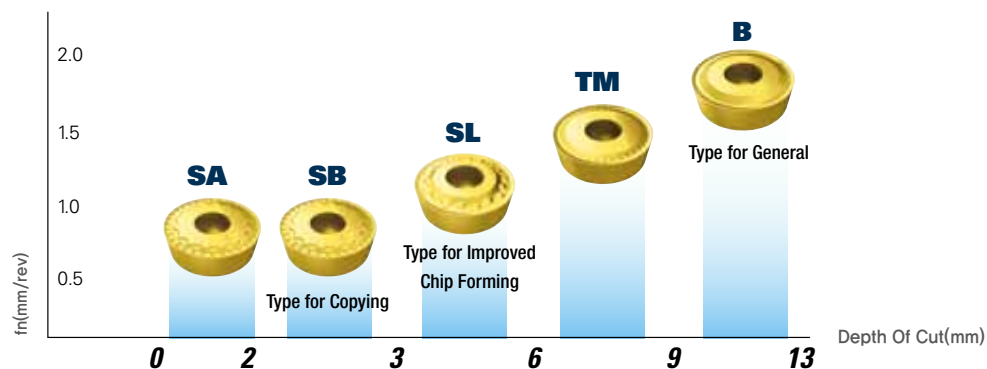




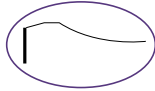
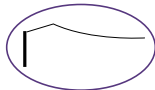
Chip Breaker

RCMX for The Working of Wheel

[RCMX32 type Line-up]



The Insert for Rail Way Wheel

Designation	C/B	Insert Shape	Edge Shape	Chip Breaker Use And Feature
LNUX type	TF			For Light Cutting, It Generates a Low Cutting Load And Has Good Chip Forming (d = under 3mm)
	TM			Comprehensive Design For General Use, Strong Cutting Edge With Good Chip Forming (d = 2~5mm)(First Recommendation)

Cutting performance 1

- Example 1**
- **Tool (insert)** : RCMX3209M0-SL
 - **Grades** : NC3225
 - **Work Piece** : Forged Steel (SSW-2) Diameter 840mm
 - **Cutting Condition** : $vc=55\sim100$ m/min $fn=1.0\sim1.5$ mm/rev $ap=1\sim6$ mm
 - **Result** : Superior in chip-control, stability, tool-life

- Example 2**
- **Tool (insert)** : LNUX301940-TM
 - **Grades** : NC3225
 - **Work Piece** : Forged Steel (SSW-2) Diameter 915~990mm
 - **Cutting Condition** : $vc=78$ m/min $fn=1.0$ mm/rev $ap=3\sim6$ mm
 - **Result** : Superior in chip-control, stability, tool-life

RAILWAY INDUSTRY

Part 2

RAILWAY INDUSTRY

Part 2

Application Example

01	Application Example for Axle	020
02	Application Example for Wheel	022
03	Application Example for Bogie	024



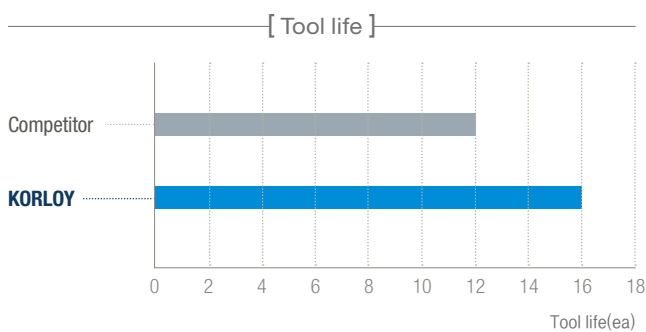
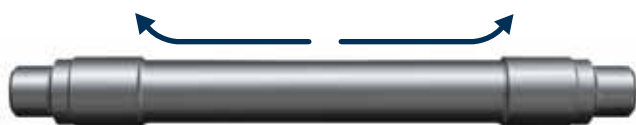
Axle

Application Example 1

Cutting conditions

Insert	SNMM250724-X279
Grade	NC3225
Workpiece	SM45C
Cutting speed	$vc = 160 \sim 180$ (m/min)
Feed	$fn = 0.7 \sim 1.1$ (mm/rev)
Depth of cut	$ap = 5 \sim 20$ (mm)
Coolant	Wet

Maker	KORLOY	Competitor
SNMM250724	16ea	12ea

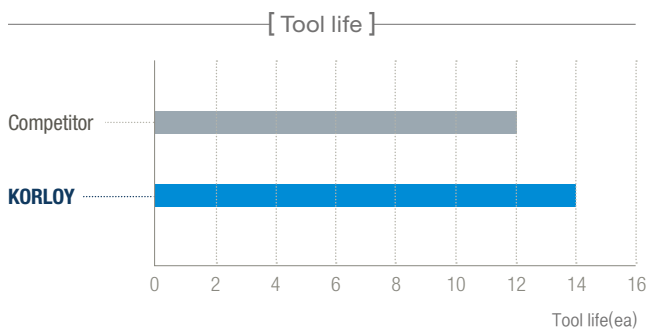


Application Example 2

Cutting conditions

Insert	CNMG120408-VC
Grade	NC3215
Workpiece	SM45C
Cutting speed	$vc = 230$ (m/min)
Feed	$fn = 0.27$ (mm/rev)
Depth of cut	$ap = 1.5$ (mm)
Coolant	Wet

Maker	KORLOY	Competitor
CNMG120408	14ea	12ea

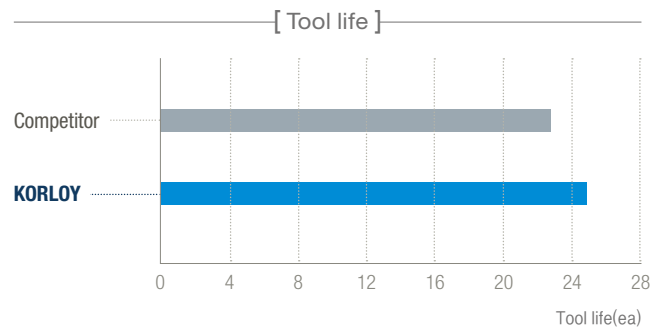




Axle

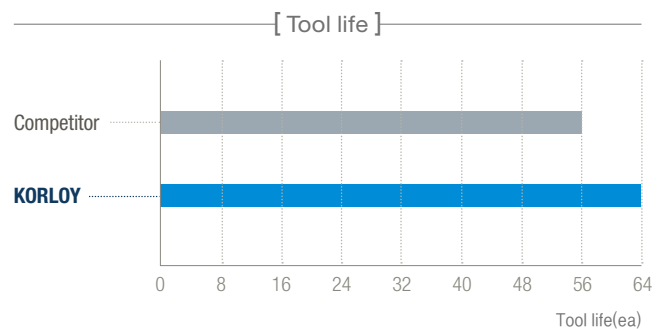
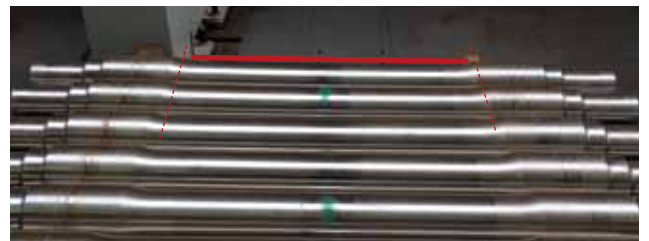
Application Example 3

Cutting conditions		
Insert	CNMG120408-VC	
Grade	NC3215	
Workpiece	SM45C	
Cutting speed	vc = 84 (m/min)	
Feed	fn = 0.6 (mm/rev)	
Depth of cut	ap = 4.4 (mm)	
Coolant	Wet	
Maker	KORLOY	Competitor
CNMG120408	25ea	23ea



Application Example 4

Cutting conditions		
Insert	SNMM250924-VT	
Grade	NC3215	
Workpiece	SM45C	
Cutting speed	vc = 176 (m/min)	
Feed	fn = 0.2 (mm/rev)	
Depth of cut	ap = 8 ~ 12 (mm)	
Coolant	Wet	
Maker	KORLOY	Competitor
SNMM250924-VT	64ea	56ea





Axle

Application Example 5

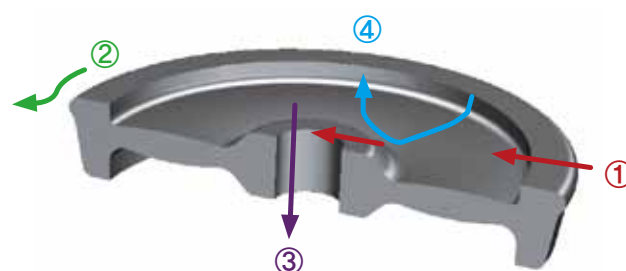
Cutting conditions		
Holder	TPDC3D-21025-63	
Insert	TPD2100CP	
Grade	PC5335	
Workpiece	SM45C	
Cutting speed	$vc = 62$ (m/min)	
Feed	$fn = 0.3$ (mm/rev)	
Depth of cut	$ap = 12$ (mm), Closed hole	
Coolant	Wet	
Maker	KORLOY	Competitor
Drill(Corn type)	Noise / Vibration decrease → get order	Not good Noise / Vibration



Wheel

Application Example 1

Cutting conditions					
Insert		SNMM250724-X279 ①/②/④ SNMM250724-X304 ③			
Grade		NC3215, NC3215			
Workpiece		High carbon steel rolling wheel			
Cutting speed		$vc = 100$ (m/min)			
Feed		$fn = 1.0 \sim 1.5$ (mm/rev)			
Depth of cut		$ap = 2$ (mm)			
Coolant		Wet			
Maker		KORLOY	A Co.	B Co.	C Co.
RCMH3209M0	A Part	19ea	19ea	15ea	19ea
	B Part	19ea	19ea	15ea	19ea
	Normal	19(100%)	19(100%)	15(79%)	19(100%)
SNMM250724		A Part	20(200%)	16(80%)	8(80%)



< Outside wheel - A part >



< Inside wheel - B part >



Wheel

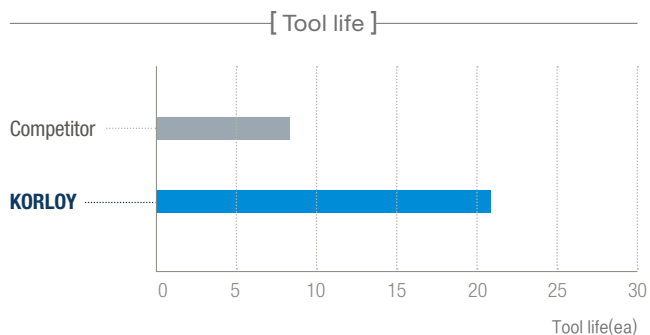
Application Example 2

Cutting conditions		
Insert	SNMM250724-X279	
Grade	NC3215	
Workpiece	High carbon steel rolling wheel	
Cutting speed	vc = 150 (m/min)	
Feed	fn = 1.1 (mm/rev)	
Depth of cut	ap = 6 ~ 7 (mm)	
Coolant	Air	
Maker	KORLOY	Competitor
SNMM250724	Excellent chip evacuation	Not good chip evacuation



Application Example 3

Cutting conditions		
Insert	RCMX2507M0	
Grade	NC3120	
Workpiece	Carbon Steel	
Cutting speed	vc = 90 (m/min)	
Feed	fn = 1.2 ~ 1.4 (mm/rev)	
Depth of cut	ap = 3 ~ 8 (mm)	
Coolant	Wet	
Maker	KORLOY	Competitor
RCMX2507M0	21ea	8ea





Bogie

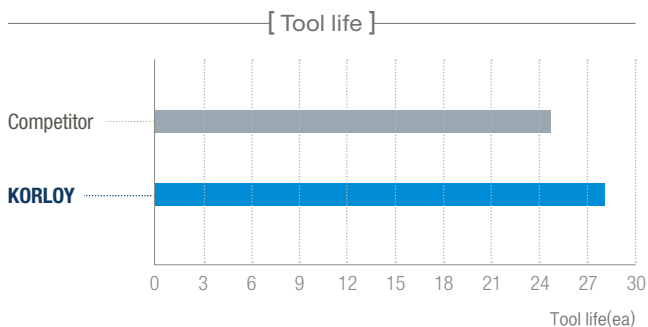
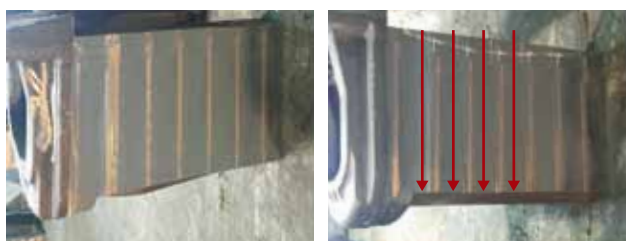
Application Example 1

Cutting conditions		
Holder	AMCM4085HM-5Z76-CH	
Insert	Internal	APMT180650R-MM
	External	APMT1806PDSR-MM
Grade	PC3545, PC3545	
Workpiece	Beam Bolster(SCMn1 - Cast Steel)	
Cutting speed	vc = 158 (m/min)	
Feed	fz = 0.37 (mm/t)	
No. of tooth	25(5F*5T)	
Depth of cut	ap = 40 (mm), ae = 3 (mm)	
Coolant	Wet	
Maker	KORLOY	Competitor
Milling Multi type (Good machinability)	Noise / Vibration decrease → get order	Not good Noise / Vibration



Application Example 2

Cutting conditions		
Holder	AMCM4080HM-5Z61-CH	
Insert	APMT1806PDSR-MM	
Grade	PC3545	
Workpiece	Front Support(SCMn1 - Cast Steel)	
Cutting speed	vc = 158 (m/min)	
Feed	fz = 0.37 (mm/t)	
No. of tooth	20(5F*4T)	
Depth of cut	ap = 40 (mm), ae = 3 (mm)	
Coolant	Wet	
Maker	KORLOY	Competitor
Milling Multi type (Chip removal amount)	56,264cm ³ 28ea	50,200cm ³ 25ea

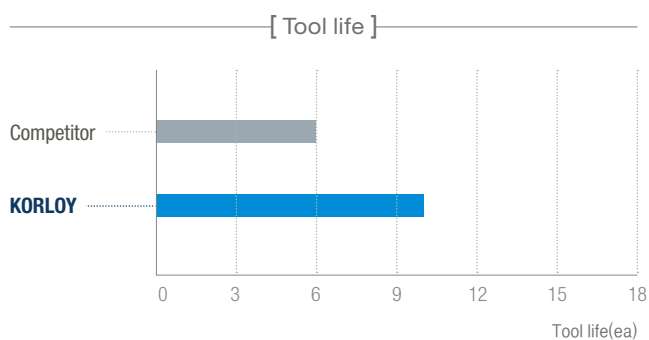
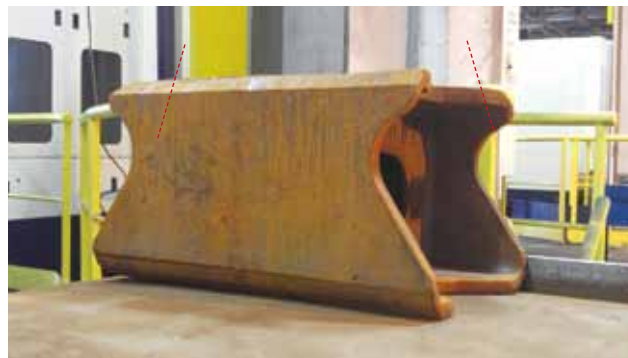




Bogie

Application Example 3

Cutting conditions		
Holder	FMRCM6080HRX-5-CH	
Insert	RPMX2007M0S-MM	
Grade	NC5340, NCM535	
Workpiece	Front Support(SCMn1 - Cast Steel)	
Cutting speed	vc = 160.8 (m/min)	
Feed	fn = 0.63 (mm/t)	
No. of tooth	5	
Depth of cut	ap = 3 (mm), ae = 0.8D	
Coolant	Wet	
Maker	KORLOY	Competitor
Round (Chip removal amount)	13,650cm ³ 10ea	8,370cm ³ 6ea





RAILWAY INDUSTRY

Part 3

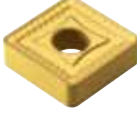
RAILWAY INDUSTRY

Part 3

Product Details

01	Turning	028
02	Milling	030
03	Drilling	033

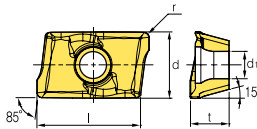
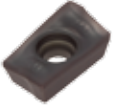
Turning

Application	Inserts	Designation	Grades		
			NC3215	NC3030	NC5330
Heavy (General)	VH 	CNMM	190612-VH	●	
			190616-VH	●	
			190624-VH	●	
			250724-VH	●	
			250924-VH	●	
Heavy (High feed cutting)	VT 	CNMM	190612-VH	●	●
			190616-VH	●	
			190624-VH	●	
			250724-VH	●	
			250924-VH	●	
Heavy (General)	VH 	SNMM	190612-VH	●	
			190616-VH	●	
			190624-VH	●	
			250716-VH		
			250724-VH	●	●
			250920-VH		
			250924-VH	●	
Heavy (High feed cutting)	VT 	SNMM	190612-VH	●	●
			190616-VH	●	●
			190624-VH	●	
			250716-VH		
			250724-VH	●	●
			250920-VH		
			250924-VH	●	●
Machining for wheel (Medium to finishing)	TF 	LNUX	301940-TF		

Turning

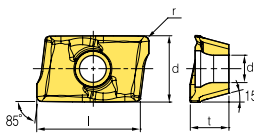
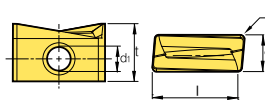
Application	Inserts	Designation	Grades		
			NC3215	NC3030	NC5330
Machining for wheel (General)	TM 	LNUX 301940-TM			
Machining for wheel (Medium to finishing)	SB 	RCMX 3209M0-SB			
Machining for wheel (General)	SL 	RCMX 3209M0-SL			
Machining for wheel (Medium)	TM 	RCMX 1606M0-TM 3209M0-TM			
Machining for wheel (Roughing)	B 	RCMX 3209M0-B			

Milling

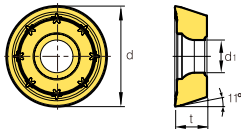
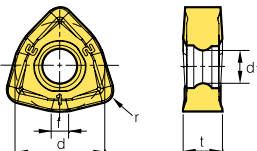
Inserts	Designation	Coated		Dimensions (mm)					Configuration
		PC3545	PC5300	l	d	t	r	d ₁	
APMT-MF 	APMT	11T3PDSR-MF	●	11.2	6.467	3.6	0.5	2.8	
		1604PDSR-MF	●	16.4	9.41	5.76	0.8	4.5	
		1806PDSR-MF	●	17.4	10.95	6.35	0.8	4.5	
		180612PDSR-MF	●	17.4	10.95	6.35	1.2	4.5	
APMT-ML 		0903PDER-ML	●	9.4	6.21	3.6	0.4	2.8	
		090308PDER-ML	●	9.4	6.21	3.6	0.8	2.8	
		11T3PDER-ML	●	11.2	6.467	3.6	0.5	2.85	
		11T308PDER-ML	●	11.2	6.467	3.6	0.8	2.85	
		160404PDER-ML	●	16.4	9.41	5.76	0.4	4.5	
		1604PDER-ML	●	16.4	9.41	5.76	0.8	4.5	
		180604PDER-ML	●	17.4	10.98	6.35	0.4	4.5	
		1806PDER-ML	●	17.4	10.98	6.35	0.8	4.5	
		180612PDER-ML	●	17.4	10.98	6.35	1.2	4.5	
		180616PDER-ML	●	17.4	10.98	6.35	1.6	4.5	
		180620PDER-ML	●	17.4	10.98	6.35	2.0	4.5	
		180624PDER-ML	●	17.4	10.98	6.35	2.4	4.5	
		180630R-ML	●	17.4	10.98	6.35	3.0	4.5	
APMT-MM 		060202PDSR-MM	●	6.0	4.24	2.60	0.2	2.0	
		0602PDSR-MM	●	6.0	4.24	2.60	0.4	2.0	
		060208PDSR-MM	●	6.0	4.24	2.60	0.8	2.0	
		060212R-MM	●	6.0	4.24	2.60	1.2	2.0	
		060216R-MM	●	6.0	4.24	2.60	1.6	2.0	
		0903PDSR-MM	●	9.4	6.21	3.60	0.4	2.8	
		090306PDSR-MM	●	9.4	6.21	3.60	0.6	2.8	
		090308PDSR-MM	●	9.4	6.21	3.60	0.8	2.8	
		090312R-MM	●	9.4	6.21	3.60	1.2	2.8	
		090316R-MM	●	9.4	6.21	3.60	1.6	2.8	
		090320R-MM	●	9.4	6.21	3.60	2.0	2.8	
		090331R-MM		9.4	6.21	3.60	3.1	2.8	
		090332R-MM	●	9.4	6.21	3.60	3.2	2.8	
		11T3PDSR-MM	●	11.2	6.467	3.60	0.5	2.85	
		11T308PDSR-MM	●	11.2	6.467	3.60	0.8	2.85	
		11T312PDSR-MM	●	11.2	6.467	3.60	1.2	2.85	
		11T316R-MM	●	11.2	6.467	3.60	1.6	2.85	
		11T318R-MM		11.2	6.467	3.60	1.8	2.85	
		11T324R-MM	●	11.2	6.467	3.60	2.4	2.85	



Milling

Inserts	Designation	Coated		Dimensions (mm)					Configuration
		PC3545	PC5300	l	d	t	r	d ₁	
APMT-MM 	APMT	1604PDSR-MM	●	16.4	9.41	5.76	0.8	4.5	
		160410PDSR-MM	●	16.4	9.41	5.76	1.0	4.5	
		160416PDSR-MM	●	16.4	9.41	5.76	1.6	4.5	
		160424R-MM	●	16.4	9.41	5.76	2.4	4.5	
		160430R-MM	●	16.4	9.41	5.76	3.0	4.5	
		160432R-MM	●	16.4	9.41	5.76	3.2	4.5	
		160450R-MM	●	16.4	9.41	5.76	5.0	4.5	
		160464R-MM	●	16.4	9.41	5.76	6.4	4.5	
		1806PDSR-MM	●	17.4	10.98	6.35	0.8	4.5	
		180612PDSR-MM	●	17.4	10.98	6.35	1.2	4.5	
		180616PDSR-MM	●	17.4	10.98	6.35	1.6	4.5	
		180620PDSR-MM		17.4	10.98	6.35	2.0	4.5	
		180624PDSR-MM	●	17.4	10.98	6.35	2.4	4.5	
		180630R-MM	●	17.4	10.98	6.35	3.0	4.5	
		180632R-MM	●	17.4	10.98	6.35	3.2	4.5	
		180640R-MM	●	17.4	10.98	6.35	4.0	4.5	
		180648R-MM	●	17.4	10.98	6.35	4.8	4.5	
		180650R-MM	●	17.4	10.98	6.35	5.0	4.5	
		180660R-MM		17.4	10.98	6.35	6.0	4.5	
		180664R-MM	●	17.4	10.98	6.35	6.4	4.5	
LNKT-ML 	LNKT	080404PNR-ML	●	8.0	4.2	6.6	0.4	2.8	
		080408PNR-ML	●	8.0	4.2	6.6	0.8	2.8	
		140608PNR-ML		12.7	6.65	10.0	0.8	4.0	
		170704PNR-ML	●	16.5	7.0	11.0	0.4	4.5	
		170708PNR-ML	●	16.5	7.0	11.0	0.8	4.5	
		170712PNR-ML		16.5	7.0	11.0	1.2	4.5	
		170716PNR-ML		16.5	7.0	11.0	1.6	4.5	
		170720PNR-ML		16.5	7.0	11.0	2.0	4.5	
		LNKT-MM 		080404PNR-MM	●	0.8	4.2	6.6	
080408PNR-MM	●			0.8	4.2	6.6	0.8	2.8	
140608PNR-MM				12.7	6.65	10.0	0.8	4.0	
170704PNR-MM	●			16.5	7.0	11.0	0.4	4.5	
170708PNR-MM	●			16.5	7.0	11.0	0.8	4.5	
170712PNR-MM				16.5	7.0	11.0	1.2	4.5	
170716PNR-MM				16.5	7.0	11.0	1.6	4.5	
170720PNR-MM				16.5	7.0	11.0	2.0	4.5	

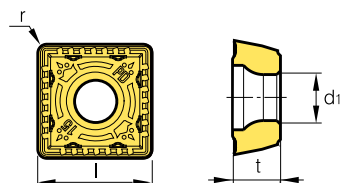
Milling

Inserts	Designation		Coated		Dimensions (mm)					Configuration	
			NC3545	NC5300	l	d	t	r	d ₁		
RPMX-MM 	RPMX	1605M0S-MM			-	16.0	5.6	-	5.5		
		2006M0S-MM			-	20.0	6.4	-	7.0		
WNMX-MF 	APMT	060312ZNN-MF		●	6.35	3.18	1.2	2.86	1.2		
		09T316ZNN-MF		●	9.525	3.97	1.6	3.6	1.7		
		130520ZNN-MF		●	12.7	5.56	2.0	4.7	2.5		
		160720ZNN-MF		●	16	7.00	2.0	5.8	3.0		
WNMX-ML 			060312ZNN-ML		●	6.35	3.18	1.2	2.86		1.2
			09T316ZNN-ML		●	9.525	3.97	1.6	3.6		1.7
			130520ZNN-ML		●	12.7	5.56	2.0	4.7		2.5
			160720ZNN-ML		●	16	7.00	2.0	5.8		3.0
WNMX-MM 			060312ZNN-MM		●	6.35	3.18	1.2	2.86		1.2
			09T316ZNN-MM		●	9.525	3.97	1.6	3.6		1.7
			130520ZNN-MM		●	12.7	5.56	2.0	4.7		2.5
			160720ZNN-MM		●	16	7.00	2.0	5.8		3.0



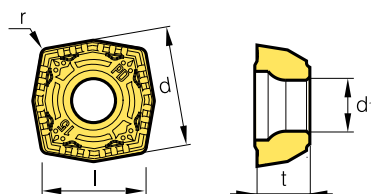
Drilling

King Drill Insert



Peripheral insert

Inserts		Designation	l	t	r	d ₁
Drill Dia.(Ø)	Ø12.0~Ø13.5	SPM(E)T040204-PD, ND	4.7	2.4	0.4	2.3
	Ø14.0~Ø16.0	SPM(E)T050204-PD, ND	5.1	2.4	0.4	2.3
	Ø16.5~Ø19.5	SPM(E)T060205-PD, LD, ND	6.2	2.5	0.5	2.5
	Ø20.0~Ø23.5	SPM(E)T070208-PD, LD, ND	7.5	2.8	0.7	2.8
	Ø24.0~Ø29.5	SPM(E)T090308-PD, LD, ND	9.2	3.3	0.8	3.4
	Ø30.0~Ø35.5	SPM(E)T11T308-PD, LD, ND	11	4.0	0.8	4.0
	Ø36.0~Ø42.5	SPM(E)T130410-PD, LD, ND	13	4.5	1.0	4.5
	Ø43.0~Ø50.5	SPM(E)T15M510-PD, LD, ND	15.2	5.0	1.0	5.5
	Ø51.0~Ø60.5	SPM(E)T180510-PD, LD, ND	18.2	5.5	1.0	6.0

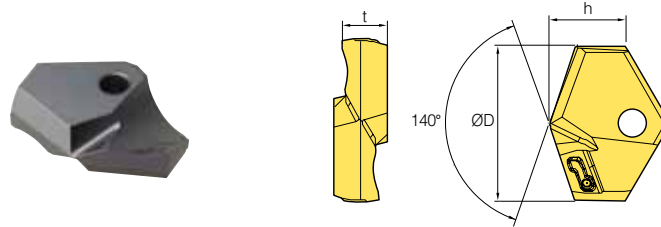


Central insert

Inserts		Designation	l	t	r	d ₁
Drill Dia.(Ø)	Ø12.0~Ø13.5	XOM(E)T040204-PD, ND	4.9	2.4	0.4	2.3
	Ø14.0~Ø16.0	XOM(E)T050204-PD, ND	5.4	2.4	0.4	2.3
	Ø16.5~Ø19.5	XOM(E)T060205-PD, LD, ND	6.6	2.5	0.4	2.5
	Ø20.0~Ø23.5	XOM(E)T070208-PD, LD, ND	7.8	2.8	0.5	2.8
	Ø24.0~Ø29.5	XOM(E)T090308-PD, LD, ND	9.6	3.3	0.5	3.4
	Ø30.0~Ø35.5	XOM(E)T11T308-PD, LD, ND	11.4	4.0	0.6	4.5
	Ø36.0~Ø42.5	XOM(E)T130410-PD, LD, ND	13.6	4.5	0.6	4.5
	Ø43.0~Ø50.5	XOM(E)T15M510-PD, LD, ND	15.9	5.0	0.8	5.5
	Ø51.0~Ø60.5	XOM(E)T180510-PD, LD, ND	18.9	5.5	0.8	0.8

Drilling

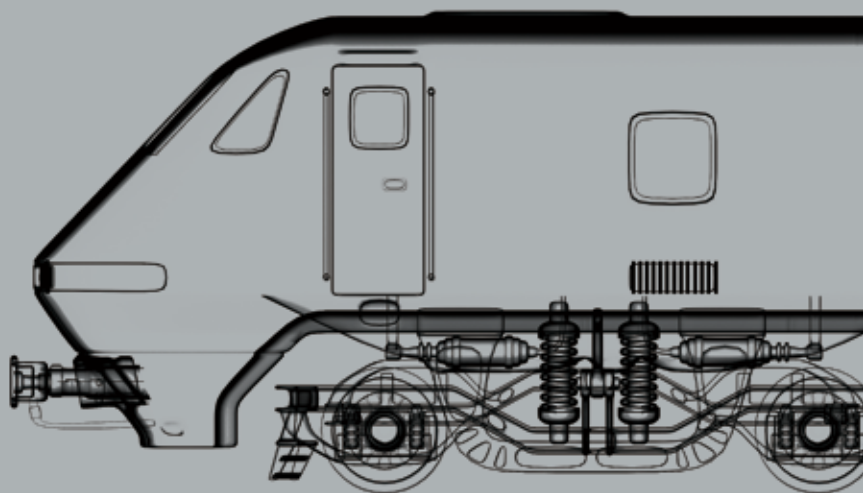
TPDB Insert



(mm)

Designation		Grade	ØD	h	t
TPD	100B~109B	PC5300, PC5335	10.0~10.9	5.5	3.5
	110B~119B	PC5300, PC5335	11.0~11.9	5.8	3.5
	120B~129B	PC5300, PC5335	12.0~12.9	6.3	3.5
	130B~139B	PC5300, PC5335	13.0~13.9	6.5	4.0
	140B~149B	PC5300, PC5335	14.0~14.9	6.8	4.0
	150B~159B	PC5300, PC5335	15.0~15.9	7.0	4.0
	160B~169B	PC5300, PC5335	16.0~16.9	7.7	5.5
	170B~179B	PC5300, PC5335	17.0~17.9	7.9	5.5
	180B~189B	PC5300, PC5335	18.0~18.9	8.1	6.0
	190B~199B	PC5300, PC5335	19.0~19.9	8.3	6.0
	200B~209B	PC5300, PC5335	20.0~20.9	9.7	6.5
	210B~219B	PC5300, PC5335	21.0~21.9	9.4	6.5
	220B~229B	PC5300, PC5335	22.0~22.9	9.6	7.0
	230B~239B	PC5300, PC5335	23.0~23.9	9.8	7.0
	240B~249B	PC5300, PC5335	24.0~24.9	10.7	7.5
	250B~259B	PC5300, PC5335	25.0~25.9	10.9	7.5
	260B~269B	PC5300, PC5335	26.0~26.9	11.0	8.5
	270B~279B	PC5300, PC5335	27.0~27.9	11.8	8.5
	280B~289B	PC5300, PC5335	28.0~28.9	12.6	9.5
	290B~299B	PC5300, PC5335	29.0~29.9	12.9	9.5
	300B~309B	PC5300, PC5335	30.0~30.9	13	10
	310B~319B	PC5300, PC5335	31.0~31.9	13.3	10
	320B~329B	PC5300, PC5335	32.0~32.9	13.5	10

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