Insert	Size	Chipbreaker Geometry	Process type	Chipbreaker Type	Ground Wiper	Ground Edge	Ground Clamping Base
HM390 TDKT 1505PDR-MP	15	PDR-MP	SEMI AND FINISH	Negative	Yes	No	No
HM390 TDKT 1505PDR-HS		PDR-HS	ROUGH	Negative	No	No	No
HM390 TDKT 1505..PDR		PDR	SEMI FINISH	Negative	No	No	No
HM390 TDKT 1505PDR-GW		PDR-GW	SEMI AND FINISH	Negative	Yes	No	No
HM390 TDKT 1505PDR-FW		PDR-FW	ROUGH	Negative	No	No	No
HM390 TDKR 150508PDRHM		PDRHM	SEMI AND FINISH	Positive	Yes	No	No

HM390 TDKT 1505PDR-FW

The serrated wavy cutting edges of the insert provide the following advantages:

- Crushes chips into small segments
- Reduces cutting forces and thus power consumption
- Increases cutter stability
- Improves chip evacuation

Due to the above-mentioned features, cutters carrying the new **HM390 TDKT 1505PDR-FW** insert provide extra efficiency in rough milling, especially in the following cases:

- Low operational stiffness (high overhang, poor workholding, thin-walled workpiece, etc.)
- Limited machine power
- Difficult chip evacuation in narrow slots or deep cavities

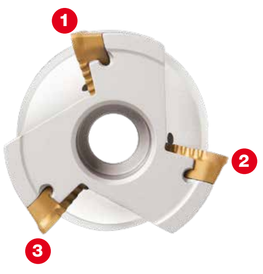
HM390 TDKT 1505PDR-FW Insert for **HM390-15** Milling Cutters

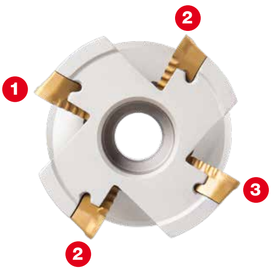
This single-sided triangular insert has three positive and serrated cutting edges intended for up to 12 mm milling depth of cut.
5 serration grooves on each flank of the insert generate a wavy cutting edge.
The insert also features a **wiper corner edge for high surface finish.**

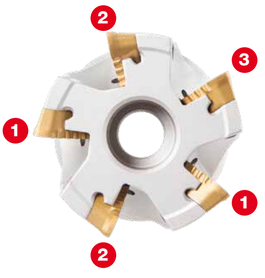
Main Application
Machining square shoulders using 90° face and endmills.

In order to provide an overlapping effect and to achieve optimal chip crushing, it is recommended to mount the **HM390 TDKT 1505PDR-FW** insert in an alternating edge configuration on adjacent cutter flutes.

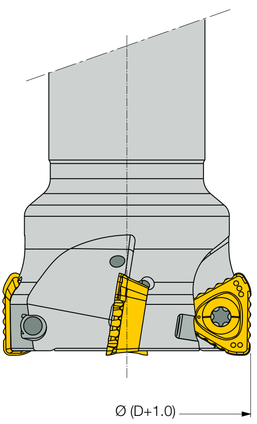
Mounting Instructions



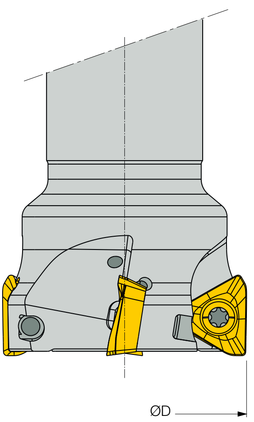




Notes for technologists and CNC programmers
When the **HM390 TDKT 1505PDR-FW** inserts are mounted on standard tools, their actual diameter will be **1.0 mm larger** than their nominal diameter.



A tool with HM390 TDKT 1505PDR-FW inserts



A tool with regular inserts