

NEW PRODUCT NEWS

CHASEMILL &
CHASE²MILL



Splitter Insert Expansion



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Splitter insert expansion

FEATURES

- Reduced machining load
- Lighter, smoother cutting
- Reduced vibration in unstable fixture
- Stable machining in long overhang conditions
- For general industry machining

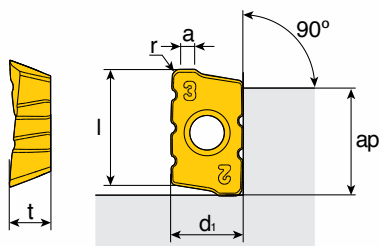
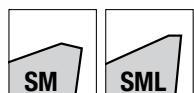
TaeguTec has expanded its line of splitter inserts suitable for high productivity, reduced cutting force and vibration for unstable fixture or long overhang of general industry applications.

The new SML chip former insert is designed with a sharper edge over the current SM chip former type for reduced machining load, noise and vibration.

SML chip formers are available for both the CHASEMILL (APKT 12 & 17 sizes) and the CHASE2MILL lines (ANHX 11 & 16 sizes). Moreover, the new inserts are compatible with the current CHASEMILL and CHASE2MILL line of cutters.

APKT 12/17

Insert



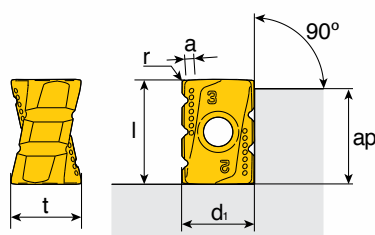
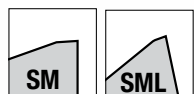
Size	Dimension (mm)					
	l	d1	t	ap	a	r
12	14.6	8.3	4.76	12.5	1.6	0.8
17	18.5	10.7	5.56	16.4	2.26	0.8

Insert	Designation	Recommended machining conditions		Coated					
		Fz (mm/tooth)	ap (mm)	TT6080	TT7800	TT8080	TT9080	TT3540	TT9540
	APKT 1204 PER-SM	0.07-0.14	3.5-10.0	●	●	●	●	○	○
	1204 PER-SML (new)	0.06-0.14	3.5-10.5			●	●	○	○
	APKT 1705 PER-SM	0.09-0.17	4.5-13.0	●	●	●	●	○	○
	1705 PER-SML (new)	0.06-0.17	4.5-14.5			●	●		

● : Standard item ○ : Semi standard item

ANHX 11/16

Insert



Size	Dimension (mm)					
	l	d1	t	ap	a	r
11	12	9.2	8.5	11	1.1	0.8
16	16	11	10.6	15	1.4	0.8

Insert	Designation	Recommended machining conditions		Coated					
		Fz (mm/tooth)	ap (mm)	TT6080	TT7800	TT8080	TT9080	TT3540	TT9540
	ANHX 110608R-SML (new)	0.06-0.15	3.0-9.5			●	●	○	○
	ANHX 160708R-SM	0.10-0.20	4.5-12.0	●	●	●	●		
	160708R-SML (new)	0.06-0.20	4.5-13.5			●	●		

● : Standard item ○ : Semi standard item

The following cutters are recommended for optimum performance with the new chip splitter inserts

Item No	Designation
6134840	TEF D40-40-W32-AN11-2F
6134836	TEF D50-56-W40-AN16-2F
6131286	TES D63-56-27R-AN16-2F
6134838	TES D100-69-40R-AN16-4F
6134831	TES D100-88-40-AP17-4F
6134841	TES D50-40-22R-AN11-4F
6134837	TES D63-42-27R-AN16-4F
6134830	TES D63-44-27-AP17-4F
6131615	TES D63-56-27R-AN16-4F
6134834	TES D63-56-27R-AP12-4F
6134842	TES D80-60-32R-AN11-4F
6134839	TES D100-69-40R-AN16-6F
6134832	TES D100-88-40-AP17-6F
6134835	TES D63-56-27R-AP12-6F
6134843	TES D80-60-32R-AN11-6F

Recommended cutting conditions

CHASEMILL - TE90AP, TFM90AP using APKT 12/17-SML inserts

Material	Hardness (HB)	Speed (m/min)	Best grades
Low carbon steel	85 - 175	180 - 300	TT9080
Stainless 300 series	-	80 - 170	TT8080
Stainless 400 series	-	100 - 210	TT8080
High temp. super alloy	-	30 - 100	TT3540
Titanium alloy	-	30 - 80	TT3540

- Reduce speed by 20% for face mills when slotting

CHASE²MILL - TE90AN and TFM90AN using ANHX 11-SML inserts

Material	Hardness (HB)	Speed (m/min)	Best grades
Low carbon steel	85 - 175	180 - 300	TT9080
Stainless 300 series	-	80 - 170	TT8080
Stainless 400 series	-	100 - 210	TT8080
High temp. super alloy	-	30 - 100	TT3540
Titanium alloy	-	30 - 80	TT3540

- Reduce speed by 20% for face mills when slotting

CHASE²MILL - TE90AN and TFM90AN using ANHX 16-SML inserts

Material	Hardness (HB)	Speed (m/min)	Best grades
Low carbon steel	85 - 175	180 - 300	TT9080
Stainless 300 series	-	80 - 170	TT8080
Stainless 400 series	-	100 - 210	TT8080
High temp. super alloy	-	30 - 100	TT3540
Titanium alloy	-	30 - 80	TT3540

- Reduce speed by 20% for face mills when slotting