

# NEW PRODUCT CHASEMILLPOWER NEWS



## New 2PKT 05 and 07 High Feed Inserts Released



## KEY POINT

TaeguTec has introduced the 2PKT 05 and 07 high feed inserts to the CHASEMILL POWER line.

TaeguTec's new **CHASEMILL POWER 2PKT 05 and 07-HF** (high feed) inserts are designed for high feed rate machining, making it an excellent productivity improvement cutting tool line.

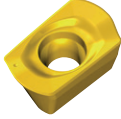
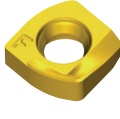
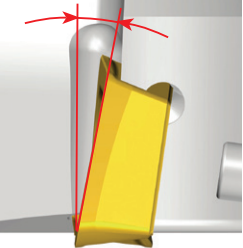
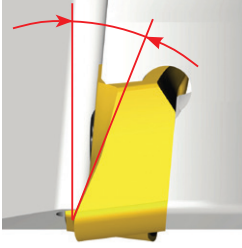
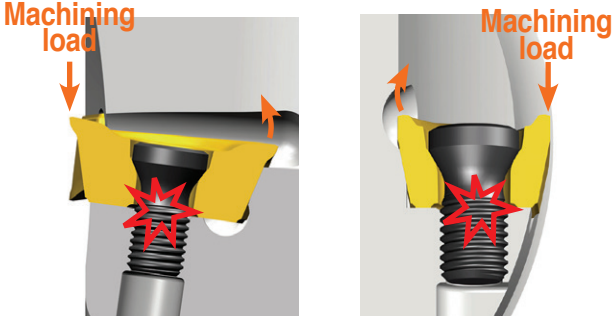
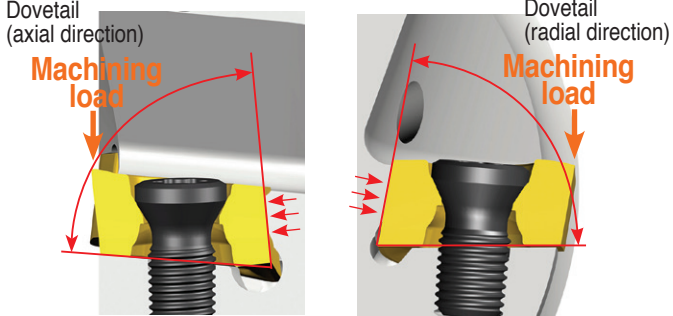
The **CHASEMILL POWER line** inserts already come with a highly efficient double-sided dovetail structure. TaeguTec has added the **HF** inserts to the line in order to perform high feed machining. An additional advantage to the double-sided structure is that it solves frequent tool failure and screw issues therefore enabling stable machining at high feed rates.

One further feature of the double dovetail structure is the excellent clamping force it provides when an **HF** insert is seated in the holder, allowing the **2PKT-HF** insert to further withstand related high feed rates as well.

The **2PKT 05-HF** insert is fastened to existing **CHASEMILL POWER** holders making it convenient as it can be purchased and used immediately. However, for the **2PKT 07-HF** insert, the existing holder must be modified.(See page 5 for modification information.)

### Features

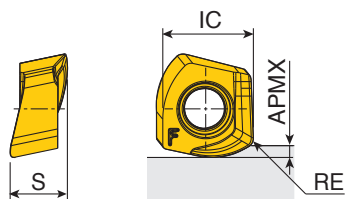
- New optimized HF insert added for high feed machining
- High positive double-sided insert ensures stability and excellent machinability
- Double-sided dovetail design ensures stable and strong fastening
- New line's 05 size insert is compatible with the existing 90 degree holders (the 07 size holder requires modification)

Competitor's mini 90 degree high feed insert	2PKT 0503R-HF
	
Single sided, 2 corners	Double-sided, 2 corners (Double-dovetail)
M1.8 screw	M2.0 screw
<p style="text-align: center;"><b>Positive</b></p> 	<p style="text-align: center;"><b>High positive</b></p> 
	

• In 2 corner inserts, the insert screws bear most of the machining load, which frequently causes breakage. The 2PKT-HF insert's double dovetail structure means the cutter body supports the machining load for more stable machining.



## 2PKT-HF new

### Insert



Size	Dimension (mm)			
	IC	S	APMX	RE
<b>05</b>	5.12	3.2	0.5	0.5
<b>07</b>	6.78	4.06	0.8	0.85

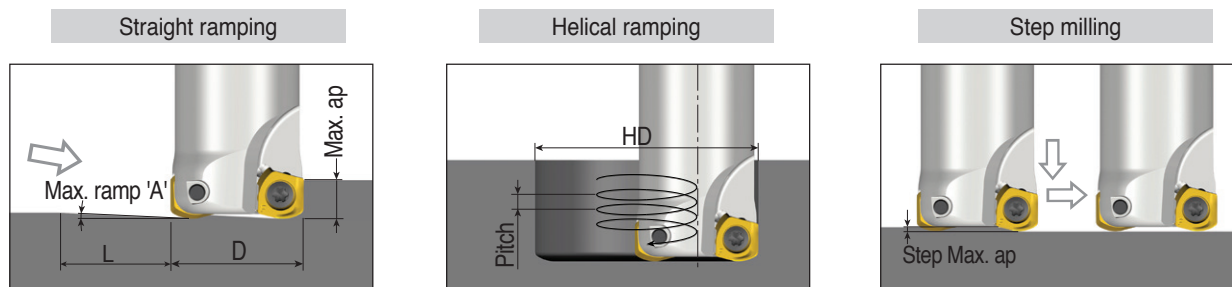


Insert	Designation	Recommended machining conditions		Coated			
		ap (mm)	Feed (mm/tooth)	TT9080	TT8080	TT3540	TT2510
	<b>2PKT 0503R-HF</b>	0.2-0.5	1.0-0.5	●	●		
	<b>2PKT 0704R-HF</b>	0.3-0.8	1.2-0.6	●			

• 2PKT 0704R-HF will be available from June 2019.

●: Standard items

## Ramping Data



### 2PKT 0503R-HF

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia. (HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø12	5.1	0.5	6	18.2	24	0.5	0.4
Ø16	2.7		11	26.2	32	0.5	
Ø18	2.2		13	30.2	36	0.5	
Ø20	1.8		16	34.2	40	0.5	
Ø25	1.2		23	44.2	50	0.5	
Ø32	0.9		32	58.2	64	0.5	
Ø40	0.6		44	74.2	80	0.5	
				80	0.5		

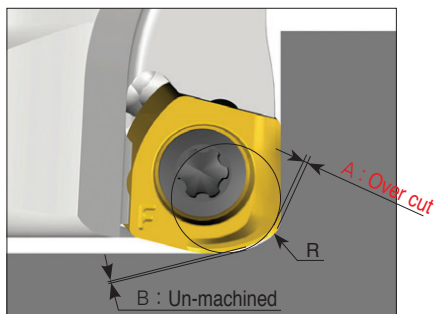
### 2PKT 0704R-HF

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia. (HD)	Max. dia.(HD)	Max. pitch/rev.	Max. ap
Ø16	4.6	0.8	10	26.2	32	0.8	0.5
Ø25	2.4		19	44.2	50	0.8	0.6
				58.2	64	0.8	
Ø32	1.6		28	94.2	100	0.8	0.6
Ø50	0.9		51	100	0.8		

## Programming technical data

(unit: mm)



	R Program	A Over cut	B Un-machined
2PKT 0503R-HF	0.9	0	0.26
	1.0	0.008	0.231
	1.5	0.157	0.104
	2.0	0.35	0.018
2PKT 0704R-HF	1.5	0	0.358
	2.0	0.103	0.21
	2.5	0.278	0.089
	3.0	0.47	0.019

**Yellow background** : Recommended program 'R'

## Holder modification information

Insert	Modification
2PKT 0503R-HF	No modification required
2PKT 0704R-HF	<div style="display: flex; justify-content: space-around; align-items: center;"> <div style="text-align: center;"> <p>Before</p> <p>R 0.8</p> </div> <div style="text-align: center;"> <p>After</p> <p>R 3</p> <p>0.6mm</p> </div> </div>