

NPA

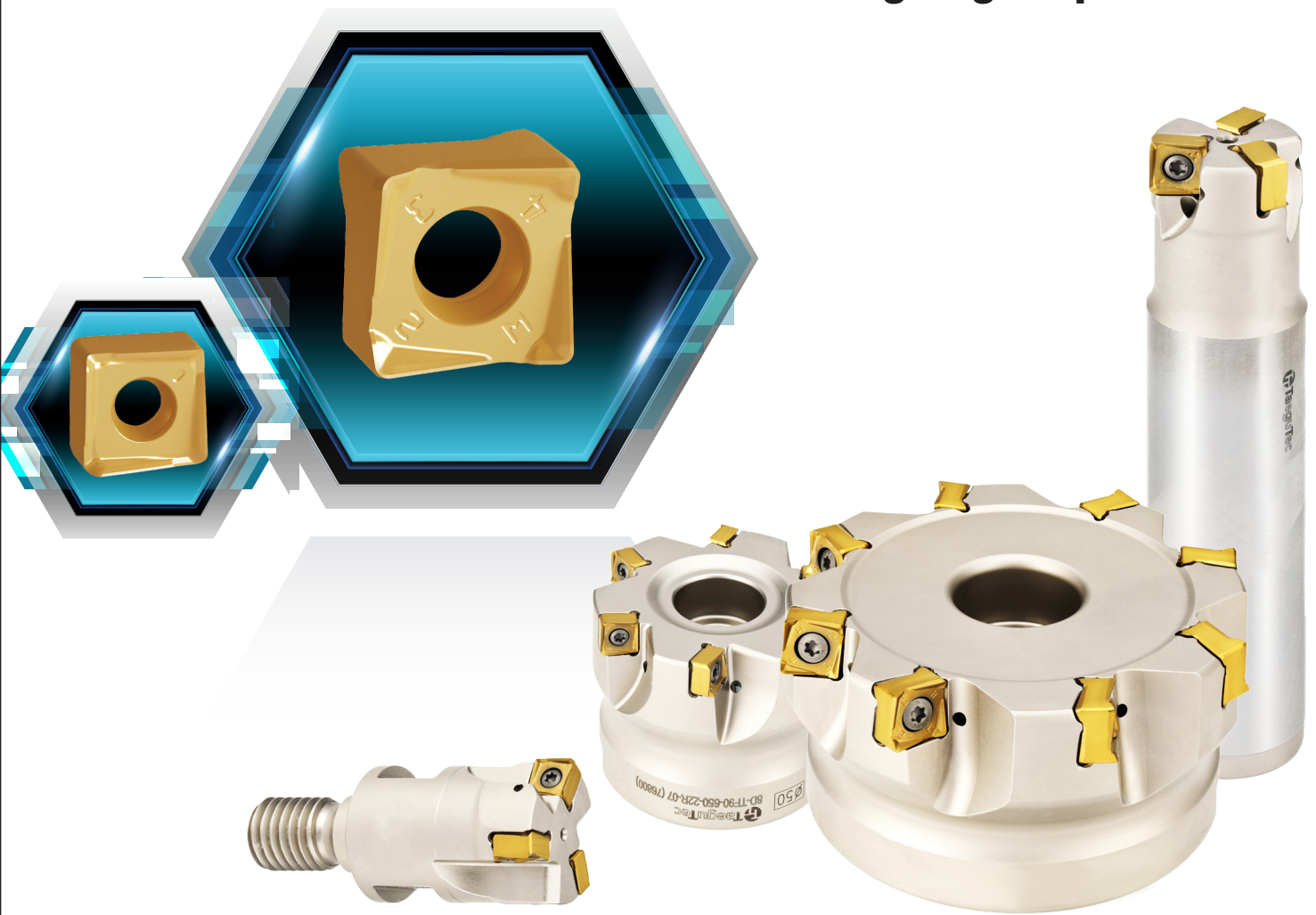
New Product Announcement No. 2019-40



CHASE 8 MILL

90° FACING & SHOULDERING

90° Shoulder Mill with Economical 8 Cutting Edge Square Insert



KEY POINT

TaeguTec now offers an economical double-sided 8 corner insert for true 90° machining.

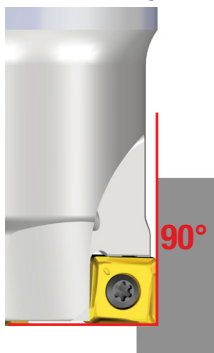
TaeguTec's **CHASE-8-MILL** line is capable of true 90° machining despite being a double-sided insert; the high axial geometry reduces cutting loads and vibration during machining yet achieves high productivity. Further advantages include the optimized design that enables minimal mismatch during 90° step machining, and improved surface roughness of the workpiece due to the inclusion of a flat bottom wiper on the insert.

With a wide variety of inserts and cutter sizes available for end mills, modular types and face mills, the line enables excellent performance in applications where small and medium workpieces are involved.

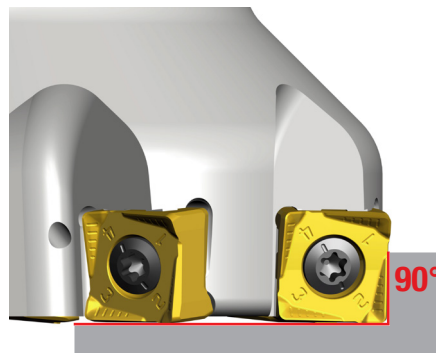
For further technical questions, please contact TaeguTec's product manager.

Features Insert

- True 90° machining

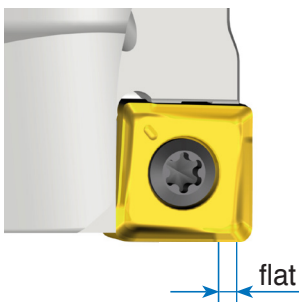


07 size



12 size

- 8 corner double-sided insert
- Insert's optimized design minimizes mismatch in step machining (SQKU 07)
- Insert's bottom wiper means improved surface roughness



- Reduced machining load due to a high positive axial rake angle

Cutter

- Internal coolant supply
- Stable clamping due to a wide supporting pocket
- Inclined screw clamping for rigid tightening



Availability

In stock

Price

Available in the GAL system

Sincerely,
TaeguTec

Cho Yeo-myeong

Rotating General PM

Sincerely,
TaeguTec

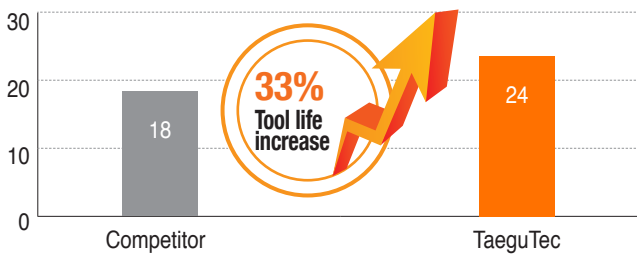
Choi Chul-won

Milling Product Manager

Case study 1

| | | Competitor | TaeguTec |
|------------------------|--------------|--------------------|--------------------------------|
| Material | | AISI 4140, 42CrMo4 | |
| Cutter | | Ø100, 8z | 8D-TF90-8100-32R-12 (Ø100, 8z) |
| Insert | | SNGX 12 type | SQKU 1206 PNR-M TT9080 |
| Cutting Speed | V (m/min) | 200 | 200 |
| Feed | f (mm/tooth) | 0.2 | 0.2 |
| | F (mm/min) | 1019 | 1019 |
| Depth of cut | ap (mm) | 3 | 3 |
| Width of cut | ae (mm) | 90 | 90 |
| Tool life (pcs/corner) | | 18 | 24 |

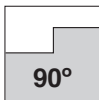
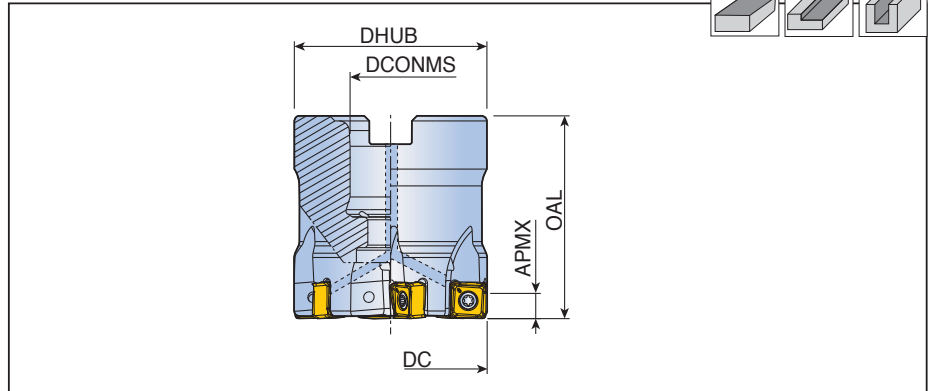
Tool life (pcs/corner)



8D-TF90-07



Face mills



| Designation | ⊙ | Dimension (mm) | | | | | Coolant | Arbor type | Kg | Mounting bolt | Insert |
|---------------------------|---|----------------|--------|------|-----|------|---------|------------|-----|---------------|-------------|
| | | DC | DCONMS | DHUB | OAL | APMX | | | | | |
| 8D-TF90-432-16R-07 | 4 | 32 | 16 | 30 | 32 | 5.0 | • | A | 0.1 | SH M8x25 | SQU 0703... |
| 640-16R-07 | 6 | 40 | 16 | 38 | 40 | 5.0 | • | A | 0.3 | SH M8x25 | |
| 650-22R-07 | 6 | 50 | 22 | 45 | 40 | 5.0 | • | A | 0.4 | SH M10x30 | |
| 850-22R-07 | 8 | 50 | 22 | 45 | 40 | 5.0 | • | A | 0.4 | SH M10x30 | |
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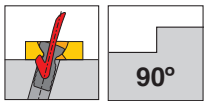
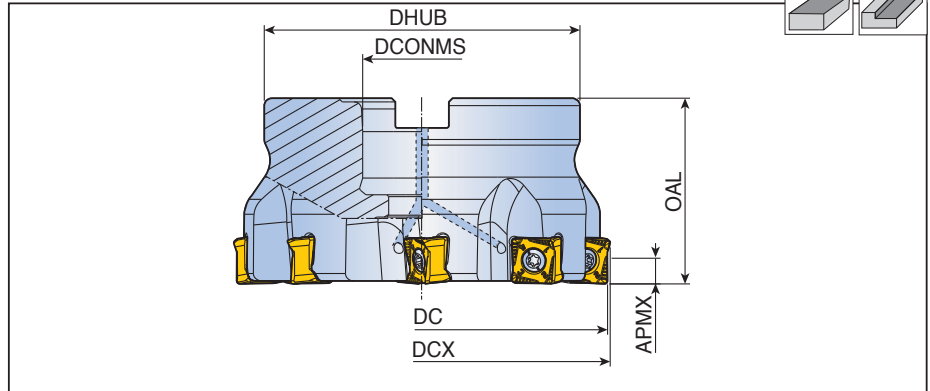
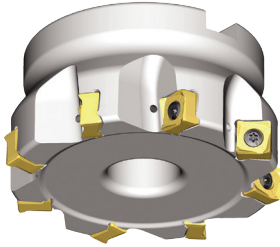
Spare parts

| Designation | Screw | Wrench | | | |
|-------------------|----------------|--------|--|--|--|
| | | | | | |
| 8D-TF90-07 | TS 25D060/HG-P | TD 7P | | | |
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8D-TF90-12



Face mills



| Designation | | Dimension (mm) | | | | | | Coolant | Arbor type | Kg | Mounting bolt | Insert |
|---------------------------|----|----------------|-------|--------|------|-----|------|---------|------------|-----|---------------|--------------------|
| | | DC | DCX | DCONMS | DHUB | OAL | APMX | | | | | |
| 8D-TF90-450-22R-12 | 4 | 50 | 51.3 | 22 | 45 | 40 | 8.5 | ● | A | 0.3 | SH M10x30 | SQK(H)U 1206... |
| 650-22R-12 | 6 | 50 | 51.3 | 22 | 45 | 40 | 8.5 | ● | A | 0.4 | SH M10x30 | |
| 563-22R-12 | 5 | 63 | 64.3 | 22 | 47 | 40 | 8.5 | ● | A | 0.5 | SH M10x30 | |
| 863-22R-12 | 8 | 63 | 64.3 | 22 | 47 | 40 | 8.5 | ● | A | 0.6 | SH M10x30 | |
| 680-27R-12 | 6 | 80 | 81.3 | 27 | 58 | 50 | 8.5 | ● | A | 1.1 | SH M12x35 | |
| 1180-27R-12 | 11 | 80 | 81.3 | 27 | 58 | 50 | 8.5 | ● | A | 1.2 | SH M12x35 | |
| 8100-32R-12 | 8 | 100 | 101.3 | 32 | 66 | 50 | 8.5 | ● | A | 1.6 | SH M16x35 | |
| 14100-32R-12 | 14 | 100 | 101.3 | 32 | 66 | 50 | 8.5 | ● | A | 1.7 | SH M16x35 | |
| 10125-40R-12 | 10 | 125 | 126.3 | 40 | 85 | 63 | 8.5 | ● | A | 3.4 | SH M20x40 | |
| 18125-40R-12 | 18 | 125 | 126.3 | 40 | 85 | 63 | 8.5 | ● | A | 3.5 | SH M20x40 | |
| 12160-40R-12 | 12 | 160 | 161.3 | 40 | 110 | 63 | 8.5 | x | C | 4.7 | - | |
| 22160-40R-12 | 22 | 160 | 161.3 | 40 | 110 | 63 | 8.5 | x | C | 4.9 | - | |
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- DC: Cutting diameter
- DCX: Cutting diameter maximum

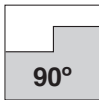
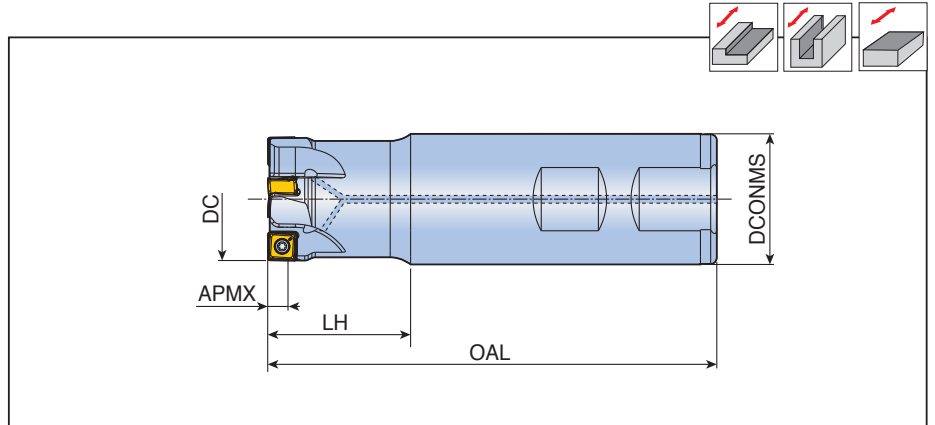
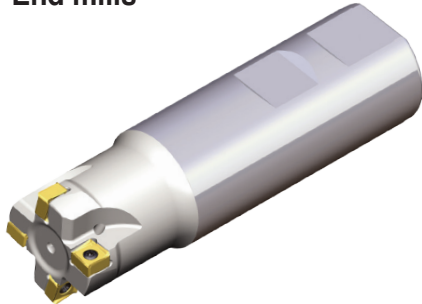
Spare parts

| Designation | Screw | Wrench | Wrench handle | | |
|-------------------|--------------|-------------|---------------|--|--|
| 8D-TF90-12 | TS 40M100/HG | TBLD T15-W6 | SW6-T | | |
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8D-TE90-07



End mills

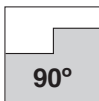
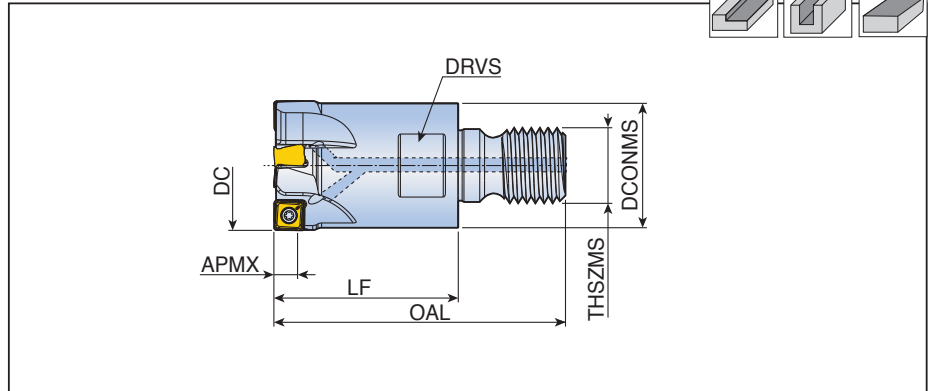
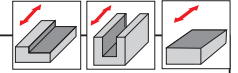
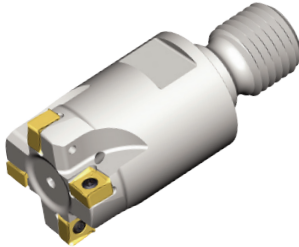


| Designation | ✂ | Dimension (mm) | | | | | Coolant | Insert |
|---------------------------|---|----------------|--------|-----|----|------|---------|--------------|
| | | DC | DCONMS | OAL | LH | APMX | | |
| 8D-TE90-216-W16-07 | 2 | 16 | 16 | 90 | 20 | 5.0 | ● | SQKU 0703... |
| 220-W20-07 | 2 | 20 | 20 | 90 | 25 | 5.0 | ● | |
| 320-W20-07 | 3 | 20 | 20 | 90 | 25 | 5.0 | ● | |
| 325-W25-07 | 3 | 25 | 25 | 100 | 30 | 5.0 | ● | |
| 425-W25-07 | 4 | 25 | 25 | 100 | 30 | 5.0 | ● | |
| 432-W32-07 | 4 | 32 | 32 | 110 | 35 | 5.0 | ● | |
| 632-W32-07 | 6 | 32 | 32 | 110 | 35 | 5.0 | ● | |
| 540-W32-07 | 5 | 40 | 32 | 110 | 40 | 5.0 | ● | |
| 840-W32-07 | 8 | 40 | 32 | 110 | 40 | 5.0 | ● | |
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8D-TE90-M-07



Modular heads for T-FLEXTEC



| Designation | Z | Dimension (mm) | | | | | | | Coolant | Insert |
|---------------------------|---|----------------|--------|----|------|--------|------|------|---------|--------------|
| | | DC | DCONMS | LF | OAL | THSZMS | APMX | DRVS | | |
| 8D-TE90-216-M08-07 | 2 | 16 | 14 | 23 | 40.5 | M08 | 5.0 | 10 | ● | SQKU 0703... |
| 320-M10-07 | 3 | 20 | 18 | 30 | 50 | M10 | 5.0 | 15 | ● | |
| 325-M12-07 | 3 | 25 | 22 | 35 | 57 | M12 | 5.0 | 17 | ● | |
| 432-M16-07 | 4 | 32 | 29 | 43 | 68 | M16 | 5.0 | 25 | ● | |
| 540-M16-07 | 5 | 40 | 29 | 43 | 68 | M16 | 5.0 | 25 | ● | |
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• Matched with T-FLEXTEC holder

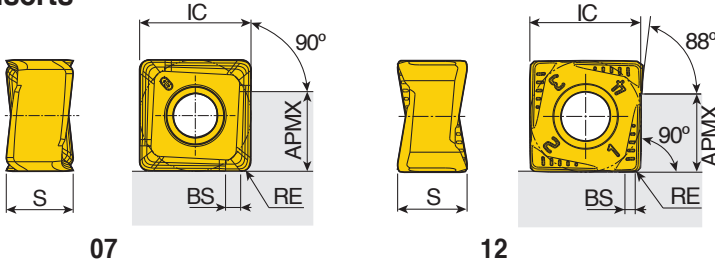
Spare parts

| Designation | Screw | Wrench | | | |
|-------------------|----------------|--------|--|--|--|
| | | | | | |
| 8D-TE90-07 | TS 25D060/HG-P | TD 7P | | | |
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SQK(H)U



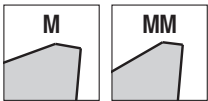
Inserts



07

12

| Size | Dimension (mm) | | | | |
|------|----------------|------|------|-----|-----|
| | IC | S | APMX | BS | RE |
| 07 | 7.0 | 4.16 | 5.0 | 0.9 | 0.8 |
| 12 | 12.2 | 8.06 | 8.5 | 1.1 | 0.8 |
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| Insert | Designation | Recommended machining conditions | | Coated | | | | | | Uncoated | | | | |
|--------|---------------------------|----------------------------------|-----------------|--------|--------|--------|--------|--------|--------|----------|--------|--------|-----|--|
| | | ap (mm) | Feed (mm/tooth) | TT9080 | TT9030 | TT8080 | TT8020 | TT8525 | TT7080 | TT7515 | TT6080 | TT2510 | K10 | |
| | SQKU 070308 PNR-M | 1.0-4.0 | 0.20-0.10 | ● | | ● | | | | | ● | | | |
| | SQKU 120608 PNR-M | 2.0-6.5 | 0.25-0.15 | ● | | | | ● | | ● | ● | | | |
| | SQHU 120608 PNR-MM | 2.0-6.5 | 0.25-0.15 | ● | | | | | | | ● | | | |

●: Standard items

KIT COLLECTIONS

These kit products are available in the format listed below.



| Cat. No. | Designation | Bill of materials | Qty. |
|----------|---------------------------------|--------------------------|------|
| 6334801 | KISFT-8D-TE90-216-W16-07 | 8D-TE90-216-W16-07 | 1 |
| | | SQKU 070308 PNR-M TT9080 | 4 |
| 6334802 | KISFT-8D-TE90-325-W25-07 | 8D-TE90-325-W25-07 | 1 |
| | | SQKU 070308 PNR-M TT9080 | 6 |
| 6334803 | KISFT-8D-TE90-432-W32-07 | 8D-TE90-432-W32-07 | 1 |
| | | SQKU 070308 PNR-M TT9080 | 8 |
| 6334804 | KISFT-8D-TF90-680-27R-12 | 8D-TF90-680-27R-12 | 1 |
| | | SQKU 120608 PNR-M TT9080 | 12 |



| Cat. No. | Designation | Bill of materials | Qty. |
|----------|---------------------------------|--------------------------|------|
| 6337866 | KISFS-8D-TE90-216-W16-07 | 8D-TE90-216-W16-07 | 1 |
| | | SQKU 070308 PNR-M TT9080 | 50 |
| 6337867 | KISFS-8D-TE90-325-W25-07 | 8D-TE90-325-W25-07 | 1 |
| | | SQKU 070308 PNR-M TT9080 | 50 |
| 6337868 | KISFS-8D-TE90-432-W32-07 | 8D-TE90-432-W32-07 | 1 |
| | | SQKU 070308 PNR-M TT9080 | 50 |
| 6337869 | KISFS-8D-TF90-680-27R-12 | 8D-TF90-680-27R-12 | 1 |
| | | SQKU 120608 PNR-M TT9080 | 50 |



| Cat. No. | Designation | Bill of materials | Qty. |
|----------|---------------------------------|--------------------------|------|
| 6338437 | KISFF-A-SQKU 07-M TT9080 | SQKU 070308 PNR-M TT9080 | 100 |
| 6338438 | KISFF-B-SQKU 07-M TT9080 | | 300 |
| 6338439 | KISFF-A-SQKU 12-M TT9080 | SQKU 120608 PNR-M TT9080 | 100 |
| 6338440 | KISFF-B-SQKU 12-M TT9080 | | 300 |