

# NPA

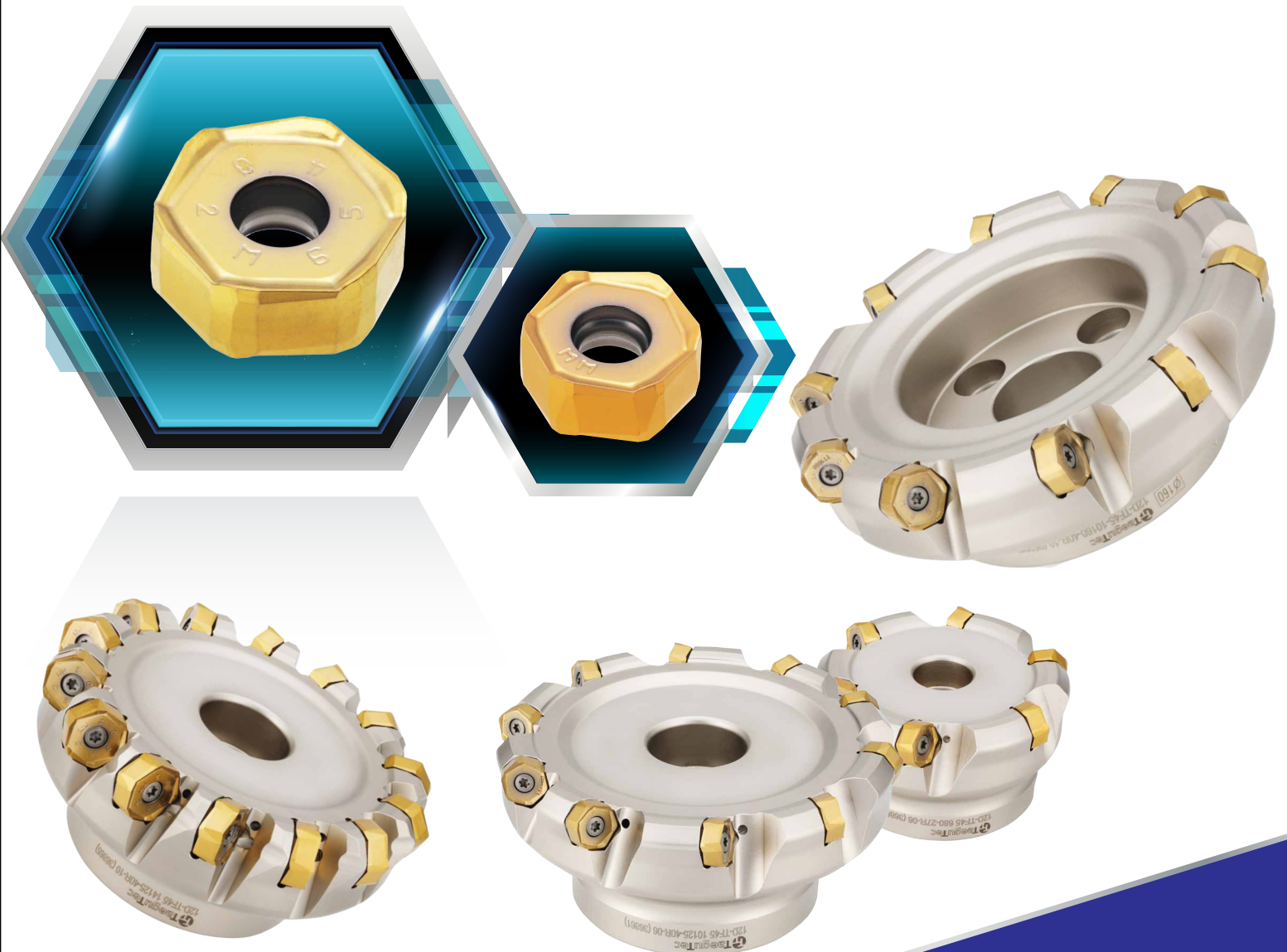
New Product Announcement No. 2019-45



## CHASE 12 MILL

FACE MILLING

A High Productivity 45° Cutter Line  
with Economical 12 Corner Insert



## KEY POINT

**TaeguTec has released a 45° entering angle cutter with economical 12 corner inserts for high productivity.**

TaeguTec has launched the **CHASE-12-MILL** line; a double-sided 12 corner insert to improve productivity in heavy machining and roughing applications.

The **CHASE-12-MILL** delivers high reliability and productivity in high feed machining with a reinforced cutting edge insert and optimized cutter design (semi-tangential positioning). The high radially inclined angle provides excellent chip evacuation and minimizes vibration due to the increased cutter body's stiffness. This results in significant productivity gains in facing applications of general steels and cast iron.

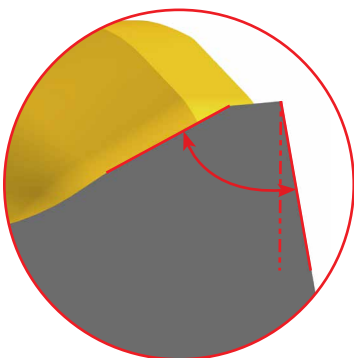
For further technical questions, please contact TaeguTec's product manager.



## Features

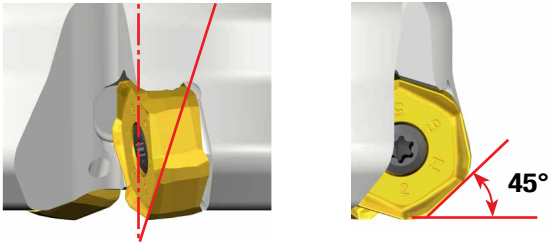
### Insert

- Enhanced cutting edge for cutting stability and high feed machining
- Acute cutter pocket design and inclined screw clamping enables robust clamping
- High helical cutting edges for smooth machining
- Double-sided 12 corner insert

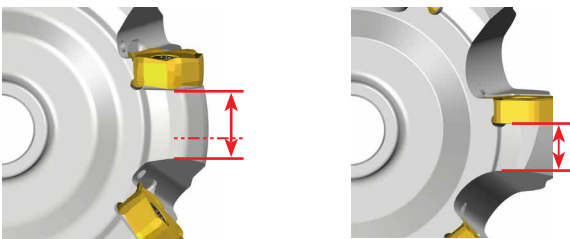


## Cutters

- High radially inclined insert arrangement enables smooth machining and excellent chip evacuation



- Maximized cutter body stiffness

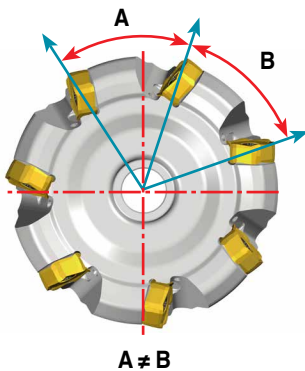


**CHASE-12-MILL**

**Current**

Higher thickness cutter design when fitted with the same size inserts

- Unequal placement of inserts minimizes vibration



- High inclination angle and inclined screw means a finer pitch cutter



## Availability

In stock

## Price

Available in the GAL system

Sincerely,  
TaeguTec

**Cho Yeo-myeong**  
Rotating General PM

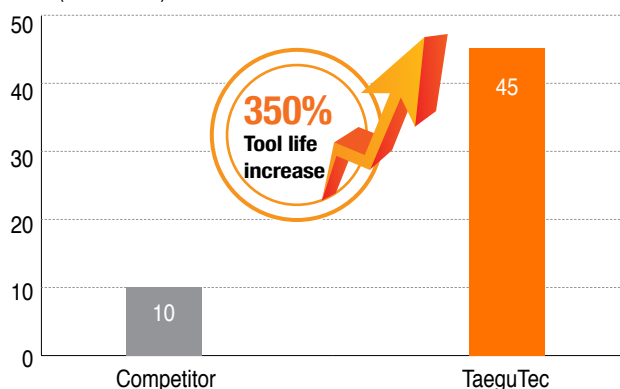
Sincerely,  
TaeguTec

**Choi Chul won**  
Milling Product Manager

## Case study 1

		Competitor	TaeguTec
Material		DIN GGG 50	
Cutter		Ø200, 12z	12D-TF45-12200-60R-10 (Ø200, 12z)
Insert		14 corner insert	HXKU 1007 ANR-HR TT7515
Cutting Speed	V (m/min)	225	225
Feed	f (mm/tooth)	0.8-1.1	0.8-1.1
	F (mm/min)	3500-4600	3500-4600
Depth of cut	ap (mm)	3-5	3-5
Width of cut	ae (mm)	180	180
Tool life (min/corner)		10	45

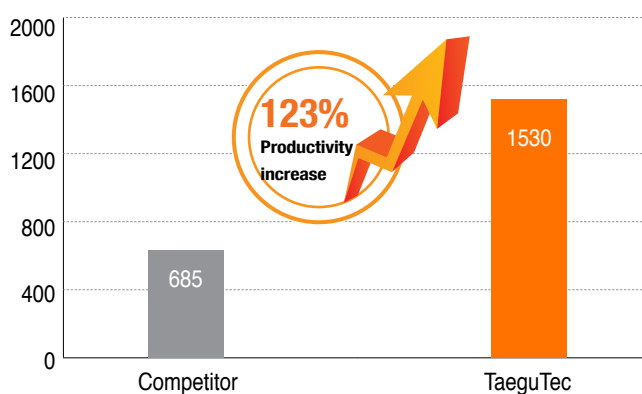
Tool life (min/corner)



## Case study 2

		Competitor	TaeguTec
Material		AISI 4140, 42CrMo4	
Cutter		Ø125, 8z	12D-TF45-10125-40R-06 (Ø125, 10z)
Insert		SNMX 12 type	HXKU 1007 ANR-M TT9080
Cutting Speed	V (m/min)	200	200
Feed	f (mm/tooth)	0.168	0.3
	F (mm/min)	685	1530
Depth of cut	ap (mm)	1.5	1.5
Coolant		Wet	Dry
Tool life (pcs/corner)		8-12	8-12

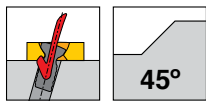
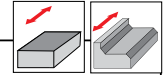
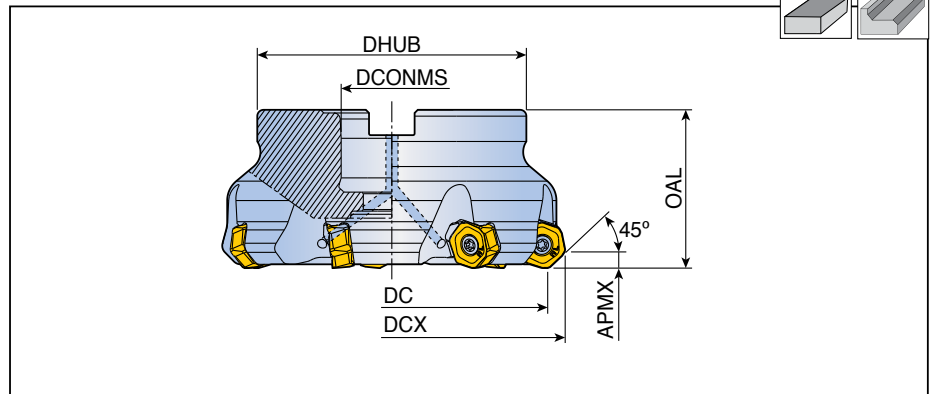
F (mm/min)



## 12D-TF45-06



### Face mills



Designation		Dimension (mm)						Coolant	Arbor type	Kg	Mounting bolt	Insert
		DC	DCX	DCONMS	DHUB	OAL	APMX					
<b>12D-TF45-440-16R-06</b>	4	40	50.8	16	38	40	3.0	•	A	0.3	SH M8x25	HXK(H)U 0605...
<b>450-22R-06</b>	4	50	60.8	22	45	40	3.0	•	A	0.5	LH M10x25	
<b>650-22R-06</b>	6	50	60.8	22	45	40	3.0	•	A	0.5	LH M10x25	
<b>563-22R-06</b>	5	63	73.8	22	47	40	3.0	•	A	0.7	LH M10x25	
<b>763-22R-06</b>	7	63	73.8	22	47	40	3.0	•	A	0.7	LH M10x25	
<b>680-27R-06</b>	6	80	90.8	27	70	50	3.0	•	A	1.5	SH M12x35	
<b>1080-27R-06</b>	10	80	90.8	27	70	50	3.0	•	A	1.5	SH M12x35	
<b>7100-32R-06</b>	7	100	110.8	32	85	50	3.0	•	A	2.2	LH M16x35	
<b>12100-32R-06</b>	12	100	110.8	32	85	50	3.0	•	A	2.2	LH M16x35	
<b>10125-40R-06</b>	10	125	135.8	40	85	63	3.0	•	A	3.6	SH M20x40	
<b>16125-40R-06</b>	16	125	135.8	40	85	63	3.0	•	A	3.6	SH M20x40	
<b>12160-40R-06</b>	12	160	170.8	40	110	63	3.0	x	C	4.9	-	
<b>20160-40R-06</b>	20	160	170.8	40	110	63	3.0	x	C	4.9	-	

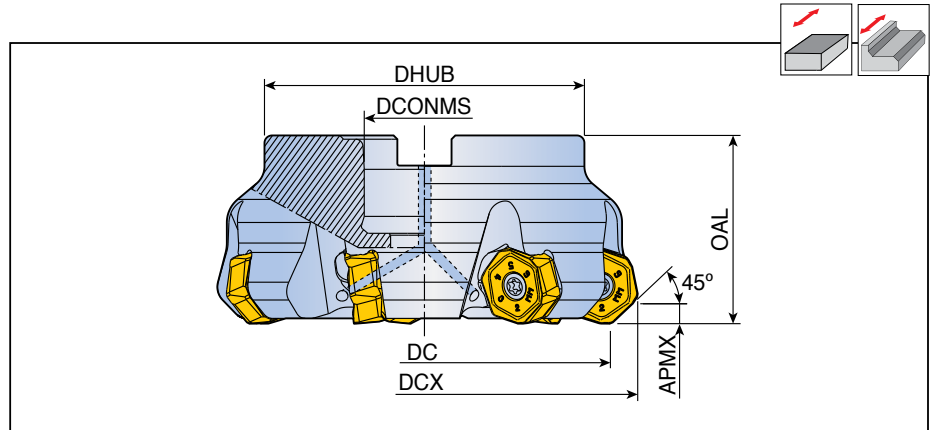
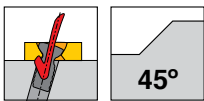
### Spare parts

Designation	Screw 	Wrench 	Wrench handle 		
<b>12D-TF45-06</b>	TS 40B100I	TBLD T15-W6	SW6-T		

## 12D-TF45-10



Face mills



Designation		Dimension (mm)						Coolant	Arbor style	Kg	Mounting bolt	Insert
		DC	DCX	DCONMS	DHUB	OAL	APMX					
<b>12D-TF45-563-22R-10</b>	5	63	77.5	22	47	50	5.0	●	A	0.9	SH M10x30	HXK(H)U 1007...
<b>763-22R-10</b>	7	63	77.5	22	47	50	5.0	●	A	0.9	SH M10x30	
<b>680-27R-10</b>	6	80	94.5	27	70	50	5.0	●	A	1.6	SH M12x35	
<b>980-27R-10</b>	9	80	94.5	27	70	50	5.0	●	A	1.6	SH M12x35	
<b>7100-32R-10</b>	7	100	114.5	32	85	50	5.0	●	A	2.4	LH M16x35	
<b>11100-32R-10</b>	11	100	114.5	32	85	50	5.0	●	A	2.4	LH M16x35	
<b>8125-40R-10</b>	8	125	139.5	40	85	63	5.0	●	A	4.1	SH M20x40	
<b>14125-40R-10</b>	14	125	139.5	40	85	63	5.0	●	A	4.0	SH M20x40	
<b>10160-40R-10</b>	10	160	174.5	40	110	63	5.0	x	C	5.6	-	
<b>16160-40R-10</b>	16	160	174.5	40	110	63	5.0	x	C	5.6	-	
<b>14200-60R-10</b>	14	200	214.5	60	130	63	5.0	x	C	7.9	-	
<b>21200-60R-10</b>	21	200	214.5	60	130	63	5.0	x	C	7.9	-	
<b>16250-60R-10</b>	16	250	264.5	60	160	63	5.0	x	C	12.4	-	
<b>26250-60R-10</b>	26	250	264.5	60	160	63	5.0	x	C	12.4	-	

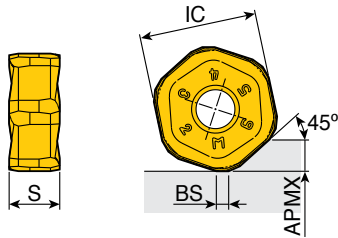
### Spare parts

Designation	Screw	Wrench	Wrench handle		
<b>12D-TF45-10</b>	TS 50C130I/HG	TBLD T20-W6	SW6-T		

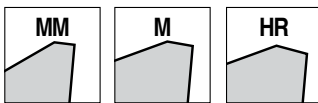
## HXK(H)U



### Inserts



Size	Dimension (mm)				
	IC	S	APMX	BS	
<b>06-MM</b>	14	6.8	3	1.3	
<b>06-M</b>	14	6.8	3	1.0	
<b>10-MM</b>	19.05	8.3	5	1.6	
<b>10-M/HR</b>	19.05	8.3	5	1.0	



Insert	Designation	Recommended machining conditions		Coated							Uncoated		
		ap (mm)	Feed (mm/tooth)	TT9080	TT9030	TT8080	TT8020	TT8525	TT7080	TT7515	TT6080	K10	
	<b>HXHU 0605 ANR-MM</b>	1.0-3.0	0.35-0.10	●							●		
	<b>1007 ANR-MM</b>	2.0-5.0	0.45-0.10								●		
	<b>HXKU 0605 ANR-M</b>	1.0-3.0	0.25-0.10	●				●					
	<b>1007 ANR-M</b>	2.0-5.0	0.30-0.10	●				●					
	<b>HXKU 1007 ANR-HR</b>	2.0-5.0	0.60-0.10					●					
		2.0-5.0	0.70-0.10						●				

●: Standard items

## KIT COLLECTIONS

These kit products are available in the format listed below.



Cat. No.	Designation	Bill of materials	Qty.
6334805	<b>KISFT-12D-TF45-680-06</b>	12D-TF45-680-27R-06	1
		HXKU 0605 ANR-M TT8525	12
6334806	<b>KISFT-12D-TF45-7100-06</b>	12D-TF45-7100-32R-06	1
		HXKU 0605 ANR-M TT8525	14
6334807	<b>KISFT-12D-TF45-10125-06</b>	12D-TF45-10125-40R-06	1
		HXKU 0605 ANR-M TT8525	20
6334808	<b>KISFT-12D-TF45-680-10</b>	12D-TF45-680-27R-10	1
		HXKU 1007 ANR-M TT8525	12
6334809	<b>KISFT-12D-TF45-7100-10</b>	12D-TF45-7100-32R-10	1
		HXKU 1007 ANR-M TT8525	14
6334810	<b>KISFT-12D-TF45-8125-10</b>	12D-TF45-8125-40R-10	1
		HXKU 1007 ANR-M TT8525	16



Cat. No.	Designation	Bill of materials	Qty.
6337870	<b>KISFS-12D-TF45-680-06</b>	12D-TF45-680-27R-06	1
		HXKU 0605 ANR-M TT8525	50
6337871	<b>KISFS-12D-TF45-7100-06</b>	12D-TF45-7100-32R-06	1
		HXKU 0605 ANR-M TT8525	50
6337872	<b>KISFS-12D-TF45-10125-06</b>	12D-TF45-10125-40R-06	1
		HXKU 0605 ANR-M TT8525	50
6337873	<b>KISFS-12D-TF45-680-10</b>	12D-TF45-680-27R-10	1
		HXKU 1007 ANR-M TT8525	50
6337874	<b>KISFS-12D-TF45-7100-10</b>	12D-TF45-7100-32R-10	1
		HXKU 1007 ANR-M TT8525	50
6337875	<b>KISFS-12D-TF45-8125-10</b>	12D-TF45-8125-40R-10	1
		HXKU 1007 ANR-M TT8525	50



Cat. No.	Designation	Bill of materials	Qty.
6338441	<b>KISFF-A-HXKU 06-M TT8525</b>	HXKU 0605 ANR-M TT8525	100
6338442	<b>KISFF-B-HXKU 06-M TT8525</b>		300
6338443	<b>KISFF-A-HXKU 10-M TT8525</b>	HXKU 1007 ANR-M TT8525	100
6338444	<b>KISFF-B-HXKU 10-M TT8525</b>		300