NEW PRODUCT NEWS

CHASEMILL

new

Now Available for the CHASEMILL line, a Higher Positive Helix Angle, Thicker Insert

TaeguTec
Member IMC Group

CHASEMILL

Now available for the CHASEMILL line, a higher positive helix angle, thicker insert

FEATURES

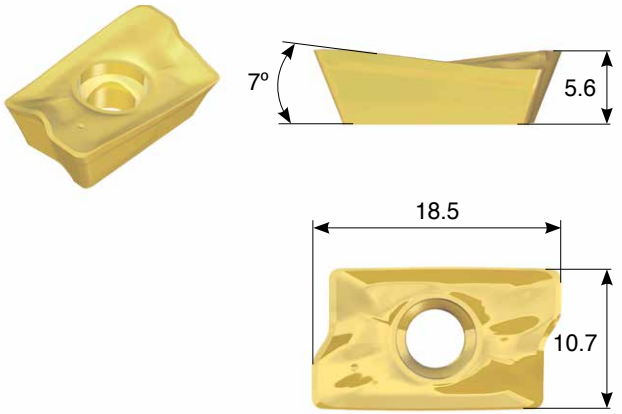
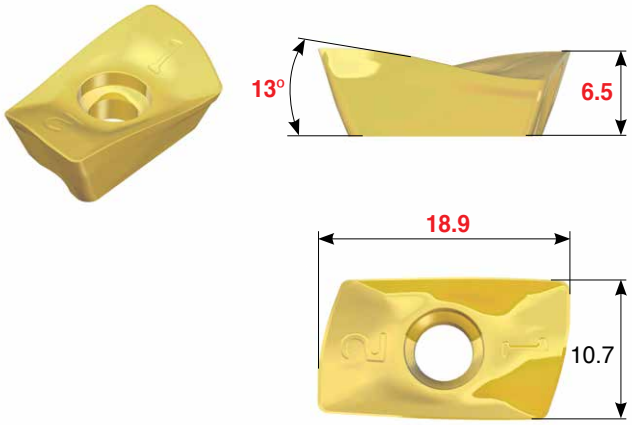
- **Higher positive helix angle for smoother machining**
  -7°(APKT 1705) → 13° (APKT 1706)
- **Thicker and stronger insert design**
  -5.6 mm (APKT 1705) → 6.5 mm (APKT 1706)
- **Compatible with the current line of CHASEMILL cutters & holders**

TaeguTec is pleased to introduce an addition to the CHASEMILL line, a new insert featuring a higher positive helix angle cutting edge available in a variety of grades – the APKT 1706.

Focused on productivity, the APKT 1706 insert's higher positive helix angle enables smooth machining on all materials in heavy industry, automotive industry as well as general applications.

The insert's higher positive helix angle (13°) achieves smoother machining over the APKT 1705 and is characterized by a 7° positive helix angle. It is a thicker, stronger insert – 6.5 mm relative to APKT 1705's 5.6 mm – that enhances the already robust machining capability on all materials.

In keeping with the line's focus on economy the APKT 1706 is compatible with the CHASEMILL's current line of APKT 1705 cutters and holders.

APKT 1705	APKT 1706 new
	

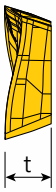
*** Notice: Please note there is a difference in diameters between the APKT 1705 line and the APKT 1706 line of inserts when using the current line of CHASEMILL cutters and holders (refer to the chart below).**

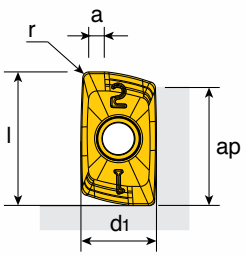
Diameter / APKT 1706 Insert	Diameter comparison to APKT 1705
~ Ø25	+0.1 ~ +0.3mm
Ø32 ~ Ø63	0
Ø80 ~	-0.1 ~ -0.2mm

APKT 17

Insert

EM





Size	Dimension (mm)					
	l	d1	t	ap	a	r
17	18.9	10.7	6.5	16	2.2	0.8

Insert	Designation	Recommended machining conditions		Coated										Uncoated		
		Fz (mm/tooth)	ap (mm)	TT9080	TT9030	TT8080	TT8020	TT7800	TT7080	TT6800	TT6080	TT2510	TT3540	TT9540		K10		
	**APKT 1706 PER-EM**	0.09-0.18	4.5-13.0	●	●	●	●	●	●	●	●	●	○	○		●		

●: Standard item ○: Semi standard item

Recommended cutting conditions

CHASEMILL – TE90AP, TFM90AP using APKT 1706 insert

Material	Hardness (HB)	D.O.C (mm)	Cutting speed (m/min)	Best grades	Feed (mm/tooth)
Low Carbon Steel	85 - 175	- 12.0	180 - 300	TT7080	0.12 - 0.29
High Carbon Steel	175 - 225	- 12.0	130 - 280	TT9080	0.12 - 0.29
Alloy Steel	275 - 325	- 12.0	120 - 250	TT9080	0.12 - 0.25
Tool Steel	-	- 12.0	80 - 200	TT2510	0.12 - 0.25
Stainless 300 Series	-	- 8.0	80 - 170	TT8080	0.10 - 0.21
Stainless 400 Series	-	- 8.0	100 - 210	TT8080	0.10 - 0.23
High Temp. Super Alloy	-	- 8.0	30 - 100	TT8080	0.10 - 0.21
Titanium Alloy	-	- 8.0	30 - 80	TT8080	0.10 - 0.21
Gray Cast Iron	190 - 220	- 11.0	150 - 400	TT6800	0.12 - 0.35
Nodular Cast Iron	140 - 200	- 11.0	100 - 250	TT6080	0.12 - 0.29
Aluminum	-	- 11.0	400 - 600	K10	0.17 - 0.58

• Reduce Speed by 20% for Face Mills when slotting

Ramping data

CHASEMILL – TE90AP, TFM90AP using APKT 1706 insert

Cutter Dia.(D_1)	Straight Ramp Down			Helical Ramp Down		
	Max. Ramp (A°)	Max. ap (mm)	Min. Length (L)	Min. Dia.	Max. Dia.	Max. Pitch/Rev.
20	8.0	16.1	115	22		0.7
					40	7.5
25	5.0	16.1	184	30.6		1.3
					50	5.8
26	4.0	16.1	230	32.6		1.2
					52	4.9
32	9.0	16.1	102	44.6		5.3
					64	13.5
33	9.0	16.1	102	46.6		5.7
					66	13.9
40	5.0	16.1	184	60.6		4.8
					80	9.3
50	4.4	16.1	209	80.6		6.3
					100	10.3
63	3.2	16.1	288	106.6		6.5
					126	9.4
80	2.3	16.1	401	140.6		6.5
					160	8.6
100	1.8	16.1	513	180.6		6.8
					200	8.4
125	1.4	16.1	659	230.6		6.9
					250	8.1
160	1.0	16.1	923	300.6		6.5
					320	7.5
200	0.7	16.1	1318	380.6		5.9
					400	6.5