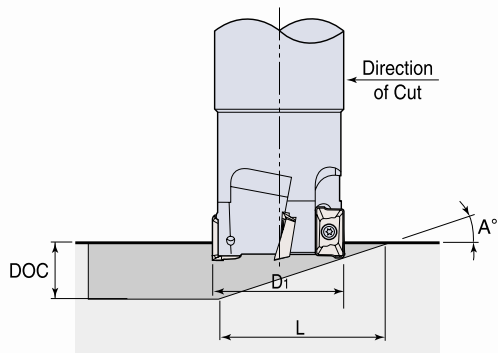


Technical Information



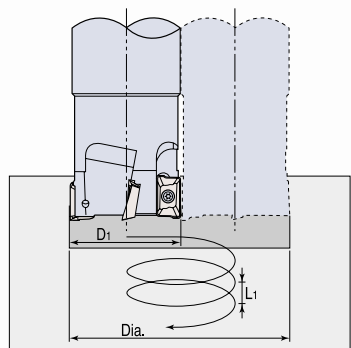
ChaseMill

Straight Ramping



Designation	Dimension (0° or inch)		
	Ramp Angle, A°	L	DOC
TE90AP-D.75	11.0	3.2	.635
TE90AP-D1.00	5.8	6.2	.635
TE90AP-D1.25	3.5	10.4	.635
TE90AP-D1.50	2.3	15.9	.635
TE90AP-D1.75	1.8	19.8	.635
TE90AP-D2.00	1.6	23.5	.635
TE90AX-D.38	7.0	2.8	.350
TE90AX-D.44	7.0	2.8	.350
TE90AX-D.50	6.8	2.9	.350
TE90AX-D.56	6.1	3.2	.350
TE90AX-D.62	5.1	3.9	.350
TE90AX-D.70	4.3	4.6	.350
TE90AX-D.75	4.1	4.8	.350
TE90AX-D.88	3.4	5.8	.350
TE90AX-D1.00	3.1	6.4	.350
TE90AX-D1.12	2.7	7.4	.350
TE90AX-D1.25	2.2	9.1	.350
TE90AX-D1.50	1.6	12.5	.350
TE90AX-D2.00	1.0	20.0	.350

Helical Ramping



Designation	Ramp Data (inch)			Helical Pitch
	Min. Dia.	Max. Dia.	L1	
TE90AP-D.75	1.00	1.5	.13	7.7
TE90AP-D1.00	1.25	2.0	.07	2.5
TE90AP-D1.25	1.65	2.5	.25	14.3
TE90AP-D1.50	2.15	3.0	.06	4.0
TE90AP-D1.75	2.65	3.5	.20	14.3
TE90AP-D2.00	3.15	4.0	.16	6.3
TE90AX-D.38	.50	.75	.08	12.5
TE90AX-D.44	.58	.88	.14	7.1
TE90AX-D.50	.62	1.00	.04	25
TE90AX-D.56	.65	1.12	.16	8.3
TE90AX-D.62	.72	1.25	.02	25.0
TE90AX-D.70	.88	1.40	.15	6.6
TE90AX-D.75	.98	1.50	.03	33.3
TE90AX-D.88	1.24	1.75	.14	7.1
TE90AX-D1.00	1.48	2.00	.05	20.0
TE90AX-D1.12	1.73	2.25	.14	7.1
TE90AX-D1.25	1.98	2.50	.07	14.2
TE90AX-D1.50	2.48	3.00	.12	8.3
TE90AX-D2.00	3.48	4.00	.07	14.2
			.11	9.0
			.06	16.1
			.09	11.1

• Calculation is based on APKT 1705 PER-EM & AXMT 0903 PER-EML insert.

Operating Guidelines for ChaseMill & ChaseQuad SEMT13 Inserts

Material	Brinell	D.O.C.	SFM	Best Grades	FPT** APKT17 & SEMT13	FPT** AXMT09 & ADKT09
1117 1020 (MS) 1018	85	.040	1300	7030, 8020, P30	.004 - .006	.002 - .005
	to 175	.150 .300	1150 1000		.004 - .006 .004 - .006	.002 - .004 .002 - .004
1045 4620 1095 8620 1060 9310 4140 52100 L1 W2 L6	175	.040	900	7030, 8020, P30	.004 - .006	.002 - .005
	to 225	.150 .300	800 600		.004 - .006 .004 - .006	.002 - .004 .002 - .004
4150 4140HT 9260 S7 4340	275	.040	800	7030, 8020, P30	.004 - .006	.002 - .005
	to 325	.150 .300	650 500	8020, 7030, P30 8020, 7030, P30	.004 - .006 .004 - .005	.002 - .004 .002 - .004
TOOL STEEL D2	200	.040	400	7030, 8020, P30	.004 - .006	.002 - .005
	to 250	.150 .300	350 300		.004 - .006 .004 - .005	.002 - .004 .002 - .004
TOOL STEEL A2 A6 P20	200	.040	915	7030, 8020, P30	.004 - .006	.002 - .005
	to 250	.150 .300	700 600		.004 - .006 .004 - .005	.002 - .004 .002 - .004
STAINLESS STEEL 303, 316 15-5PH	135	.040	800	8020, 7030, DX2	.004 - .006	.002 - .005
	to 185	.150 .300	700 500		.004 - .006 .004 - .005	.002 - .004 .002 - .004
STAINLESS STEEL 416 17-4PH	135	.040	1000	8020, 7030, DX2	.004 - .006	.002 - .005
	to 185	.150 .300	850 700		.004 - .006 .004 - .005	.002 - .004 .002 - .004
STAINLESS STEEL 13-8PH		.040	400	8020, 7030, DX2	.004 - .005	.002 - .005
		.150	300		.004 - .005	.002 - .004
		.300	200		.004 - .005	.002 - .004
INCONEL, HASTELLOY WASPALLOY		.040	150	8020, DX2, 7030	.004 - .005	.002 - .005
		.150	100		.004 - .005	.002 - .004
		.300	75		.004 - .005	.002 - .004
TITANIUM 6AL-4V		.040	180	8020, DX2, 7030	.004 - .005	.002 - .005
		.150	150		.004 - .005	.002 - .004
		.300	120		.004 - .005	.002 - .004
GRAY CAST IRON-CLASS 40-45-50	190	.040	1200	6030, 8020, K10	.004 - .006	.003 - .005
	to 220	.150 .300	1000 800		.004 - .006 .004 - .006	.003 - .005 .003 - .005
DUCTILE CAST IRON-GRADE 65-45-12	140	.040	1000	6030, 8020, K10	.004 - .006	.003 - .005
	to 190	.150 .300	850 700		.004 - .006 .004 - .006	.003 - .005 .003 - .005
DUCTILE CAST IRON-GRADE 80-55-06	190	.040	800	6030, 8020, K10	.004 - .006	.003 - .005
	to 225	.150 .300	700 500		.004 - .006 .004 - .006	.003 - .005 .003 - .005
ALUMINUM 6061 T-6 7075 T-6		.040	max	K10, 8020, DX2	.006 - .020	.005 - .020
		.150	max		.006 - .015	.005 - .015
		.300	1200 min		.006 - .015	.005 - .015
72 BRASS 360 18 AMPCO 660 BRONZE	60RB	.040	1600	K10, 6030, 8020	.006 - .020	.005 - .020
	to 100RB	.150 .300	1400 1200		.006 - .015 .006 - .015	.005 - .015 .005 - .015

- Reduce chip load by 28% for End Mills .750 dia. and under at D.O.C.>.150
- Reduce sfm by 20% for Face Mills when channel milling
- **FPT(Feed per tooth) shown at lower limit can be increased up to 2 times depending upon application



Operating Guidelines for ChaseOcto & Round Inserts

Material	Brinell	D.O.C.	Max sfm	Best Grades***	FPT** OF-- 05 OF-- 07	FPT** RFMT 14 RFMR 19
1117 1020 (MS) 1018	85	.040	1200	7030, 8020, P30	.004 - .007	.008 - .014
	to	.100	1000		.004 - .006	.005 - .008
	175	.250 +	900		.004 - .006	.004 - .006
1045 4620 1095 8620 1060 9310 4140 52100 L1 W2 L6	175	.040	850	7030, 8020, P30	.004 - .007	.008 - .014
	to	.100	750		.004 - .006	.005 - .008
	225	.250 +	600		.004 - .006	.004 - .006
4150 4140HT 9260 S7 4340	275	.040	700	7030, 8020, P30	.003 - .005	.006 - .010
	to	.100	600	8020, 7030, P30	.003 - .004	.004 - .007
	325	.250 +	450	8020, 7030, P30	.003 - .004	.003 - .004
TOOL STEEL D2	200	.040	400	7030, 8020, P30	.003 - .005	.006 - .010
	to	.100	350		.003 - .004	.004 - .007
	250	.250 +	300		.003 - .004	.003 - .004
TOOL STEEL A2 A6 P20	200	.040	800	7030, 8020, P30	.003 - .007	.006 - .014
	to	.100	650		.003 - .005	.004 - .007
	250	.250 +	550		.003 - .005	.003 - .005
STAINLESS STEEL 303, 316 15-5PH	135	.040	800	8020, 7030, DX2	.003 - .007	.006 - .014
	to	.100	700		.003 - .005	.004 - .007
	185	.250 +	500		.003 - .005	.003 - .005
STAINLESS STEEL 416 17-4PH	135	.040	1100	8020, 7030, DX2	.003 - .007	.006 - .014
	to	.100	900		.003 - .005	.004 - .007
	185	.250 +	700		.003 - .005	.003 - .005
STAINLESS STEEL 13-8PH		.040	400	8020, 7030, DX2	.003 - .007	.006 - .014
		.100	300		.003 - .005	.004 - .007
		.250 +	200		.003 - .005	.003 - .005
INCONEL, HASTELLOY WASPALLOY		.040	150	8020, DX2, 7030	.003 - .007	.006 - .014
		.100	100		.003 - .005	.004 - .007
		.250 +	80		.003 - .005	.003 - .005
TITANIUM 6AL-4V		.040	250	8020, DX2, 7030	.003 - .007	.006 - .014
		.100	175		.003 - .005	.004 - .007
		.250 +	120		.003 - .005	.003 - .005
GRAY CAST IRON-CLASS 40-45-50	190	.040	1000	6030, 8020, K10	.003 - .007	.006 - .014
	to	.100	850		.003 - .005	.004 - .007
	220	.250 +	700		.003 - .005	.003 - .005
DUCTILE CAST IRON-GRADE 65-45-12	140	.040	900	6030, 8020, K10	.003 - .007	.006 - .014
	to	.100	750		.003 - .005	.004 - .007
	190	.250 +	600		.003 - .005	.003 - .005
DUCTILE CAST IRON-GRADE 80-55-06	190	.040	800	6030, 8020, K10	.003 - .007	.006 - .014
	to	.100	700		.003 - .005	.004 - .007
	225	.250 +	500		.003 - .005	.003 - .005
ALUMINUM 6061 T-6 7075 T-6		.040	max	K10, 8020, DX2	.006 - .020	.012 - .040
		.100	max		.006 - .015	.008 - .020
		.250 +	1200 min		.006 - .015	.006 - .015
72 BRASS 360 18 AMPCO 660 BRONZE	60RB	.040	1600	K10, 6030, 8020	.006 - .020	.012 - .040
	to	.100	1400		.006 - .015	.008 - .020
	100RB	.250 +	1200		.006 - .015	.006 - .015

- Reduce sfm by 20% for Face Mills when channel milling
- **FPT(Feed per tooth) shown at lower limit can be increased up to 2 times depending upon application
- FPT reflects 40% increase to compensate for 45 degree chip thinning
- ***In order of preference, uncoated carbide reduce sfm 20%

Operating guidelines for ChaseQuad TSF and TDM End mill using Inserts: XOMT 06, SPMT 09, SPMG 09, SPMT 11, SPMG 11, SPMT 14, SPMG 14

Material	BRINELL	D.O.C.	SFM	BEST GRADES BY PREFERENCE	FPT XOMT 06	FPT SPM-09	FPT SPM-11	FPT SPM-14
1117 1020 (MS) 1018	80	.040	1300	8020, 7030, P30	.003 - .007	.004 - .008	.004 - .008	.005 - .010
	to 175	.150	1150		.003 - .006	.004 - .008	.004 - .008	.005 - .010
		.250	1000		.003 - .005	.004 - .008	.004 - .008	.005 - .010
1045 4620 1095 8620 1060 9310 4140 52100 L1 W2 L6	175	.040	900	8020, 7030, P30	.003 - .007	.004 - .007	.004 - .007	.005 - .010
	to 225	.150	800		.003 - .006	.004 - .007	.004 - .007	.005 - .010
		.250	600		.003 - .005	.004 - .007	.004 - .007	.005 - .010
4150 4140HT 9260 S7 4340	275	.040	600	8020, 7030, DX2	.003 - .007	.004 - .006	.004 - .006	.004 - .008
	to 325	.150	500		.003 - .006	.004 - .006	.004 - .006	.004 - .008
		.250	400		.003 - .005	.004 - .005	.004 - .005	.004 - .008
TOOL STEEL D2	200	.040	400	8020, 7030, P30	.002 - .005	.004 - .006	.004 - .006	.004 - .008
	to 250	.150	350		.002 - .004	.004 - .006	.004 - .006	.004 - .008
		.250	300		.002 - .004	.004 - .005	.004 - .005	.004 - .008
TOOL STEEL A2 A6 P20	200	.040	915	8020, 7030, P30	.002 - .005	.004 - .006	.004 - .006	.004 - .007
	to 250	.150	700		.002 - .004	.004 - .006	.004 - .006	.004 - .007
		.250	600		.002 - .004	.004 - .005	.004 - .005	.004 - .007
STAINLESS STEEL 303, 316 15-5PH	135	.040	800	8020, DX2, 7030	.003 - .006	.004 - .007	.004 - .007	.004 - .007
	to 185	.150	700		.003 - .005	.004 - .006	.004 - .006	.004 - .007
		.250	500		.003 - .005	.004 - .005	.004 - .005	.004 - .007
STAINLESS STEEL 416 17-4PH	135	.040	1000	8020, P30, 7030	.002 - .005	.004 - .007	.004 - .007	.004 - .008
	to 185	.150	850		.002 - .004	.004 - .006	.004 - .006	.004 - .008
		.250	700		.002 - .004	.004 - .005	.004 - .005	.004 - .008
STAINLESS STEEL 13-8PH		.040	400	8020, DX2, 7030	.002 - .005	.003 - .005	.003 - .005	.004 - .007
		.150	300		.002 - .004	.003 - .005	.003 - .005	.004 - .007
		.250	200		.002 - .004	.003 - .005	.003 - .005	.004 - .007
INCONEL, HASTELLOY WASPALLOY		.040	150	8020, DX2, 7030	.002 - .005	.003 - .005	.003 - .005	.004 - .007
		.150	100		.002 - .004	.003 - .005	.003 - .005	.004 - .007
		.250	75		.002 - .004	.003 - .005	.003 - .005	.004 - .007
TITANIUM 6AL-4V		.040	180	8020, DX2, 7300	.002 - .005	.003 - .005	.003 - .005	.004 - .007
		.150	150		.002 - .004	.003 - .005	.003 - .005	.004 - .007
		.250	120		.002 - .004	.003 - .005	.003 - .005	.004 - .007
GRAY CAST IRON-CLASS 40-45-50	190	.040	1200	6030, 8020, K10	.003 - .005	.004 - .006	.004 - .006	.004 - .008
	to 220	.150	1000		.003 - .005	.004 - .006	.004 - .006	.004 - .008
		.250	800		.003 - .005	.004 - .006	.004 - .006	.004 - .008
DUCTILE CAST IRON-GRADE 65-45-12	140	.040	1000	6030, 8020, K10	.003 - .005	.004 - .006	.004 - .006	.004 - .008
	to 190	.150	850		.003 - .005	.004 - .006	.004 - .006	.004 - .008
		.250	700		.003 - .005	.004 - .006	.004 - .006	.004 - .008
DUCTILE CAST IRON-GRADE 80-55-06	190	.040	800	6030, 8020, P30	.003 - .005	.004 - .006	.004 - .006	.004 - .008
	to 225	.150	700		.003 - .005	.004 - .006	.004 - .006	.004 - .008
		.250	500		.003 - .005	.004 - .006	.004 - .006	.004 - .008
ALUMINUM 6061 T-6 7075 T-6		.040	max	K10, 8020, DX2	.005 - .020	.006 - .020	.006 - .020	.006 - .020
		.150	max		.005 - .015	.006 - .015	.006 - .015	.006 - .015
		.250	1200 min		.005 - .015	.006 - .015	.006 - .015	.006 - .015
72 BRASS 360 18 AMPCO 660 BRONZE	60RB	.040	1600	K10, 6030, 8020	.005 - .020	.006 - .020	.006 - .020	.006 - .020
	to 100RB	.150	1400		.005 - .015	.006 - .015	.006 - .015	.006 - .015
		.250	1200		.005 - .015	.006 - .015	.006 - .015	.006 - .015

- Reduce chip load by 28% for End Mills .750 dia and under at D.O.C.>.150



Operating guidelines for Ext. Flute Mills Overcut Shell Mills Series- TEF, TES Using Inserts SPMT09, SPMT11, SPMT14 & APKT17

(Feed per Effective flute by Cutter Diameter**)

Material	BHN	RADIAL WOC	MAX SFM	BEST GRADES	1.250 DIA	1.500 DIA	2.000 DIA	2.500 DIA	3.000 DIA	4.000 DIA
1117 1020 (MS) 1018	80 to 175	0.02**	1000	7030, 8020, P30	.024	.030	.035	.048	.056	.064
		DIA/8**	900		.008	.009	.009	.011	.011	.011
		DIA/4**	800		.006	.007	.007	.008	.008	.008
		DIA/2	700		.005	.006	.006	.006	.006	.006
1045 4620 1095 8620 1060 9310 ACD 4140 W2 L6 52100 L1	175 to 225	0.02**	700	7030, 8020, P30	.024	.030	.035	.048	.056	.064
		DIA/8**	600		.008	.009	.009	.011	.011	.011
		DIA/4**	500		.006	.007	.007	.008	.008	.008
		DIA/2	400		.005	.006	.006	.006	.006	.005
4150 4140HT 4340 9260 S7	275 to 325	0.02**	600	8020, 7030, P30	.016	.022	.030	.042	.049	.056
		DIA/8**	500		.006	.008	.008	.009	.009	.009
		DIA/4**	400		.005	.006	.006	.007	.007	.007
		DIA/2	300		.004	.005	.005	.005	.005	.005
TOOL STEEL A2 A6 D2 P20	200 to 250	0.02**	450	8020, 7030, P30	.016	.022	.030	.042	.049	.056
		DIA/8**	450		.006	.008	.008	.009	.009	.009
		DIA/4**	350		.005	.006	.006	.007	.007	.007
		DIA/2	250		.004	.005	.005	.005	.005	.005
STAINLESS STEEL 303, 316 15-5PH	135 to 185	0.02**	600	8020, 7030, P30	.016	.022	.030	.042	.049	.056
		DIA/8**	600		.006	.008	.008	.009	.009	.009
		DIA/4**	500		.005	.006	.006	.007	.007	.007
		DIA/2	400		.004	.005	.005	.005	.005	.005
STAINLESS STEEL 416 17-4PH	135 to 185	0.02**	700	8020, 7030, P30	.024	.030	.035	.048	.056	.064
		DIA/8**	600		.008	.009	.009	.011	.011	.011
		DIA/4**	500		.006	.007	.007	.008	.008	.008
		DIA/2	400		.005	.006	.006	.006	.006	.006
STAINLESS STEEL 13-8PH		0.02**	400	8020, 7030, DX2	.016	.022	.030	.042	.049	.056
		DIA/8**	300		.006	.008	.008	.009	.009	.009
		DIA/4**	200		.005	.006	.006	.007	.007	.007
		DIA/2	150		.004	.005	.005	.005	.005	.005
INCONEL, HASTELLOY WASPAL- LOY		0.02**	150	8020, 7030, DX2	.016	.022	.030	.042	.049	.056
		DIA/8**	120		.006	.008	.008	.009	.009	.009
		DIA/4**	100		.005	.006	.006	.007	.007	.007
		DIA/2	75		.004	.005	.005	.005	.005	.005
TITANIUM 6AL-4V		0.02**	180	8020, 7300, DX2	.016	.022	.030	.042	.049	.056
		DIA/8**	170		.006	.008	.008	.009	.009	.009
		DIA/4**	150		.005	.006	.006	.007	.007	.007
		DIA/2	120		.004	.005	.005	.005	.005	.005
GRAY CAST IRON-CLASS 40-45-50	190 to 220	0.02**	700	6030, K10, 8020	.024	.030	.035	.048	.056	.064
		DIA/8**	500		.008	.009	.009	.011	.011	.011
		DIA/4**	400		.006	.007	.007	.008	.008	.008
		DIA/2	400		.005	.006	.006	.006	.006	.006
DUCTILE / NODULAT CAST IRON-GRADE 65-45-12	140 to 190	0.02**	700	6030, K10, P30	.024	.030	.035	.048	.056	.064
		DIA/8**	500		.008	.009	.009	.011	.011	.011
		DIA/4**	400		.006	.007	.007	.008	.008	.008
		DIA/2	400		.005	.006	.006	.006	.006	.006
DUCTILE / NODULAT CAST IRON-GRADE 80-55-06	190 to 225	0.02**	700	6030, K10, P30	.024	.030	.035	.048	.056	.064
		DIA/8**	500		.008	.009	.009	.011	.011	.011
		DIA/4**	400		.006	.007	.007	.008	.008	.008
		DIA/2	400		.005	.006	.006	.006	.006	.006
ALUMINUM BRASS BRONZE		0.02**	1500+	K10, 8020, DX2	.040	.044	.050	.060	.070	.080
		DIA/8**	1500+		.015	.015	.015	.015	.015	.015
		DIA/4**	1500+		.012	.012	.012	.012	.012	.012
		DIA/2	1500+		.010	.010	.010	.010	.010	.010

- ** FPT Adjusted to compensate for radial chip thinning FPT Above can be increased as Much as 50% depending upon application
- Decrease SFM 20% when width of cut(WOC) Exceeds DIA/1.3 (3/4 of cutter DIA) or consider using single stage end mills or face Mills-TE90AP, TFM90AP; Insert APKT1705 in Multiple passes to desired depth

Operating guidelines for Z-Mill, Face Mills series TFM55HN
using HNCF100510-MR, -ML, -EM Inserts

Material	BRINELL HARDNESS	D.O.C. (Depth Of Cut)	MAX SFM	BEST GRADES*** BY PREFERENCE	FPT** HNCF 100510
GRAY CAST IRON-CLASS 40-45-50	190 TO 220	.040	1000	6030, K10	.006 ~ .017
		.100	850		.006 ~ .014
	max .040	.310	700	KB90	.006 ~ .014
		max .040	2950		.003 ~ .006
DUCTILE/NODULAR CAST IRON-GRADE 65-45-12	140 TO 190	.040	900	6030, K10	.006 ~ .017
		.100	750		.006 ~ .014
	max .040	.310	600	KB90	.006 ~ .014
		max .040	2300		.003 ~ .006
DUCTILE/NODULAR CAST IRON-GRADE 80-55-06	190 TO 225	.040	700	6030, K10	.006 ~ .017
		.100	600		.006 ~ .014
	max .040	.310	450	KB90	.006 ~ .014
		max .040	1950		.003 ~ .006

- Reduce SFM by 20% when channel milling
- **Higher FPT reflects increase to compensate for 35 degree lead angle chip thinning.
- ***In order of preference, uncoated carbide reduce SFM 20%



Grades

Grade Chart

TaeguTec Grade	ISO Rating	Coating	HrA	Grain Size	Workpiece material	Feature
K10	K10 - K20 N10 - N20	Uncoated	92.8	Fine	Malleable & Gray Cast Iron over 220HB, Aluminum, Non-ferrous alloys, Copper, Plastics, High-temp alloys	High Wear resistance Dry Milling
P30	P25 - P35	Uncoated	91.7	Medium	Steels	High Shock Resistance, High Wear & Crater resistance
DX2	M30 - M40 K30 - K40	Uncoated	90.2	Fine	Stainless steels, Alloy steels, Cast Iron, High-temp alloys	Wet or Dry Milling, High Mechanical Shock & Wear resistance
NEW CT5000	P10 - P30 K10 - K20 M15 - M30 N10 - N25 H10 - H25	Cermet	92.5	Fine	Steels, Mold Steels, Stainless steels, Cast iron & Aluminum	High Wear & Shock Resistance for finishing to medium machining
NEW CT3000	P05 - P25 K05 - K15 M05 - M20 N05 - N20 H05 - H20	Cermet	93.0	Fine	Steels, Mold Steels, Cast iron, Stainless steels & Aluminum alloy	High Wear Resistance for finishing application
KT7300	P20 - P40	CVD TiCN-TiN	89.9	Coarse	Steels	Dry Milling at high Speeds & Lower FPT
TT6030	K05 - K20 N05 - N20 H05 - H20	PVD TiAlN	92.8	Fine	Malleable & Gray Cast Iron over 220HB, Aluminum, Non-ferrous alloys, Copper, Plastics, High-temp alloys	Dry & Wet Milling, High Wear Resistance
TT7030	P15 - P40	PVD TiAlN	91.7	Medium	Steels	Dry Milling, High wear & Crater resistance
NEW TT7070	P20 - P40	PVD TiAlN	92.0	Medium	Alloy Steels, Mold Steels, Cast Iron	Dry Milling High wear resistance
TT8020	M30 - M40 P30 - P45 K20 - K40 N15 - N30 S20 - S30	PVD TiCN	90.2	Fine	Stainless steels, Alloy steels, High-temp alloys, Cast Iron	All purpose Grade, High Mechanical & Shock resistance
NEW TT8030	M20 - M40 P25 - P45 K15 - K40 S15 - S30	PVD TiAlN	90.2	Fine	Alloy Steels, Stainless steels, High-temp alloys, Cast Iron	All purpose Grade, High Mechanical & Shock resistance
NEW TT9030	M10 - M30 P15 - P35 K10 - K30 S10 - S25	PVD TiAlN	92.8	Micro	Stainless steels, Alloy steels, High-temp alloys, Cast Iron	All purpose Grade, Dry & Wet milling
KT8600	P05 - P20 K05 - K20 H05 - H25	PVD TiAlN	92.8	Micro	Mold Steels, Cast Iron, Stainless steels	Wet or Dry Milling, High Mechanical Wear and Thermal Shock resistance

Grades

Carbide Selection Guide

Direction of Use		Wear Resistance →				Wear Resistance →				Wear Resistance →				Wear Resistance →				Wear Resistance →																													
		← Toughness				← Toughness				← Toughness				← Toughness				← Toughness																													
		← Increase Feed				← Increase Feed				← Increase Feed				← Increase Feed				← Increase Feed																													
		→ Increase Speed				→ Increase Speed				→ Increase Speed				→ Increase Speed				→ Increase Speed																													
Material		Chilled Iron Cast Iron								Alloy Iron Stainless Steel Steel Casting Manganese								Steel Free Cutting Steels Malleable Iron								Non-Ferrous Alloy				High-Temp Alloys				Hardened Iron Hardened Steel													
TaeguTec Grade	Coating	C1				C2				C3				C4				C5				C6				C7				C8																	
		K 50	K 45	K 40	K 35	K 30	K 25	K 20	K 15	K 10	K 05	K 01	M 50	M 40	M 30	M 20	M 10	P 50	P 45	P 40	P 35	P 30	P 25	P 20	P 15	P 10	P 05	P 01	N 30	N 25	N 20	N 15	N 10	N 05	N 01	S 30	S 25	S 20	S 15	S 10	S 05	S 01	H 30	H 25	H 20	H 15	H 10
K10	Uncoated	█								█								█				█																									
P30		█								█								█				█																									
DX2		█								█								█				█																									
NEW CT5000	Cemet	█								█								█				█				█																					
NEW CT3000		█								█								█				█				█																					
KT7300	CVD	█								█								█				█				█																					
TT6030	PVD	█								█								█				█				█																					
TT7030		█								█								█				█				█																					
NEW TT7070		█								█								█				█				█																					
TT8020		█								█								█				█				█																					
NEW TT8030		█								█								█				█				█																					
NEW TT9030		█								█								█				█				█																					
KT8600		█								█								█				█				█																					

TaeguTmill - Grades

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