

# NPN

New Product News



## CHASEMILL

### Aluminum Machining Milling Inserts with Chip Splitters



## KEY POINT

**TaeguTec has added aluminum machining milling inserts with chip splitters to the CHASE-MILL line.**

Milling inserts with chip splitters ensure high productivity by improving stability in aluminum machining with long overhangs and unstable fixtures that generate vibration.

The new insert is available in the CHASE-MILL's APCT 17 line for standard cutters.

### Feature

- Suitable for unstable machining conditions such as long overhang, unstable fixtures, and low powered machines
- High feed rates with low cutting forces for increased productivity
- Chip splitter reduces chip volume and improves chip evacuation

### Notice

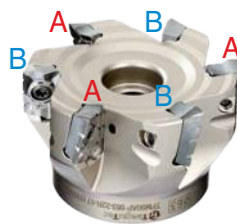
- When insert mounting, ensure they are mounted in a staggered formation i.e. 1st tooth-2 groove side; 2nd tooth-3 groove side and repeat action for the remaining teeth
- For optimum machining efficiency, use even numbered flute type cutters



Side A



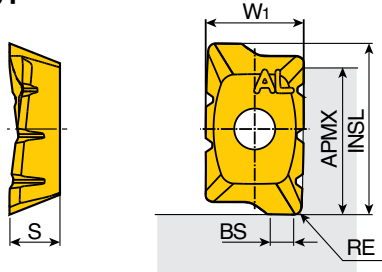
Side B



## APCT 17

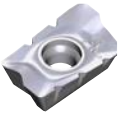


Chip splitter type insert



Size	Dimension (mm)					
	INSL	W <sub>1</sub>	S	APMX	BS	RE
<b>17-SAL</b>	18.5	10.8	5.62	16.1	2.56	0.8



Insert	Designation	Recommended machining conditions		Coated							Uncoated			
		ap (mm)	Feed (mm/tooth)	TT9080	TT9030	TT8080	TT8020	TT8525B	TT7080	TT7515	TT6080	TT2510		K10
	<b>APCT 1705 PER-SAL</b>	4.5-13.0	0.50-0.10											●

● : Standard items

## Recommended Cutting Conditions

### Machining data

Cutting Speed: Vc(m/min)

ISO	Material	Condition	Tensile strength (N/mm <sup>2</sup> )	Hardness HB	Material No.	Uncoated	
						K10	
N	Aluminum - wrought alloy	Not cureable		60	21	550-700	
		Cured		100	22	600-750	
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23	800-900
			Cured		90	24	650-800
		>12% Si	High temp.		130	25	250-320
	Copper alloys	>1% Pb	Free cutting		110	26	300-400
			Brass		90	27	300-400
			Electrolytic copper		100	28	210-280
	Non-metallic		Duroplastics, fiber plastics			29	150-250
			Hard rubber			30	150-250

■ Nonferrous materials