

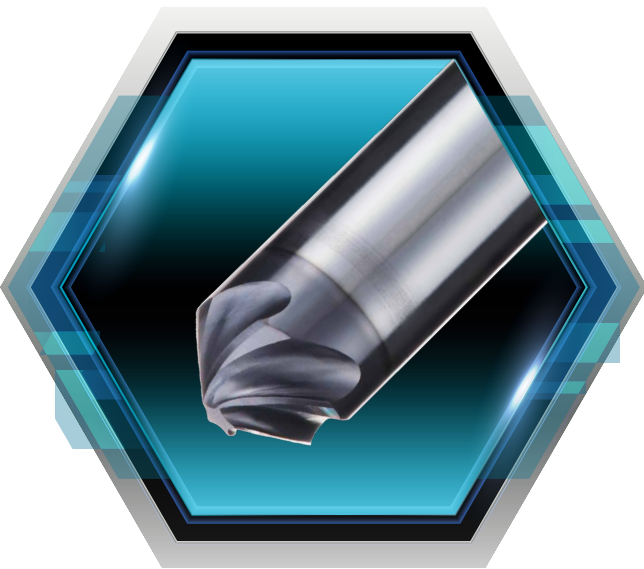
# NPN

New Product News



## APEX MILL

**45° Chamfering Solid End Mill  
with 5 Flute High Helix Angle**



## KEY POINT

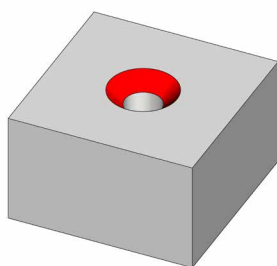
**TaeguTec's APEXMILL has launched a 45° chamfering solid end mill with 5 flutes and high helix angle.**

TaeguTec has expanded its chamfering solid end mill line by adding to the current uncoated two and four flute straight cutting edge APEXMILL family. The new end mill not only reduces the cutting force during machining due to its high helix cutting edge, but also improves productivity due to the five flutes design. It is also suitable for high-speed machining and increases tool life with the latest coated grade.

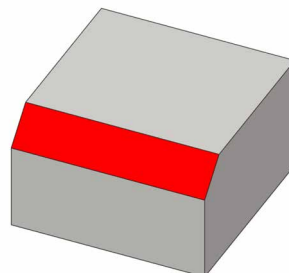
### Features

- 40-degree high helix angle
    - Low cutting force and excellent surface finish
  - Optimal flute design
    - Excellent chip evacuation
  - TT5525 PVD coated grade
    - Increased tool life and high-speed machining
  - 5 flutes
    - Increased productivity
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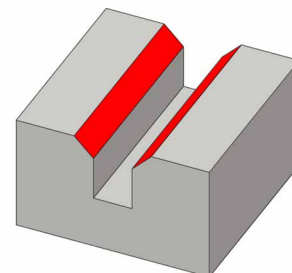
### Applications



Countersinking



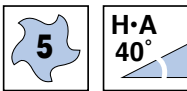
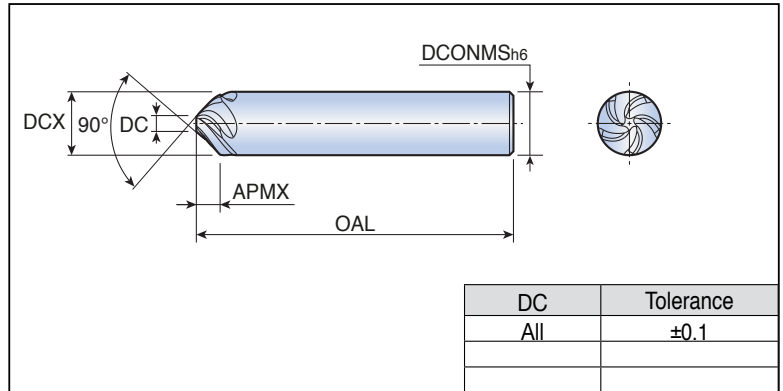
Chamfering



## HCEM 5



5 flute, for chamfering



| Designation      | Feed (mm/tooth) | Dimension (mm) |     |     |      |        | Grade |
|------------------|-----------------|----------------|-----|-----|------|--------|-------|
|                  |                 | DCX            | DC  | OAL | APMX | DCONMS |       |
| <b>HCEM 5080</b> | 0.02-0.06       | 8              | 2   | 63  | 3.0  | 8      | ●     |
| <b>5100</b>      | 0.03-0.07       | 10             | 2.5 | 72  | 3.8  | 10     | ●     |
| <b>5120</b>      | 0.03-0.08       | 12             | 3   | 83  | 4.5  | 12     | ●     |
| <b>5160</b>      | 0.04-0.10       | 16             | 4   | 92  | 6.0  | 16     | ●     |
|                  |                 |                |     |     |      |        |       |
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|                  |                 |                |     |     |      |        |       |
|                  |                 |                |     |     |      |        |       |

●: Standard items

## Recommended Cutting Conditions



| Workpiece material         | Vc (m/min) | fz (mm/tooth) |             |             |             |
|----------------------------|------------|---------------|-------------|-------------|-------------|
|                            |            | Ø8            | Ø10         | Ø12         | Ø16         |
| Cast iron                  | 80-130     | 0.020-0.060   | 0.025-0.070 | 0.030-0.080 | 0.040-0.100 |
| Aluminum                   | 130-170    | 0.020-0.140   | 0.025-0.160 | 0.030-0.180 | 0.040-0.200 |
| Carbon steel & Alloy steel | 70-120     | 0.015-0.060   | 0.020-0.070 | 0.025-0.080 | 0.030-0.100 |
| Hardened steel             | 20-30      | 0.010-0.050   | 0.015-0.060 | 0.020-0.070 | 0.025-0.080 |
| Stainless                  | 20-40      | 0.015-0.060   | 0.020-0.070 | 0.025-0.080 | 0.030-0.100 |