

NEW PRODUCT NEWS

CHASE² HEPTA



**Tough Carbide Shim Type Cutters and Inserts XNM(H)U 06
for Roughing and Finishing of Difficult-to-Cut Materials**



KEY POINT

TaeguTec's CHASE2HEPTA line has released new carbide shim type cutters and inserts XNM(H)U 06 for reliable roughing and finishing of difficult-to-cut materials.

TaeguTec's **CHASE2HEPTA** double-sided 14-corner insert line has introduced new carbide shim type cutters and inserts for roughing and finishing to the family.

With the added carbide shims, the new **CHASE2HEPTA** line can be applied under high feed conditions due to its increased rigidity and strength. Furthermore, damage to the cutter body is minimized due to the shim's rigid seating design. As such, the **CHASE2HEPTA** shim type cutters are characterized by its reliable performance when manufacturing turbochargers as well as the machining of difficult-to-cut materials while performing roughing applications.

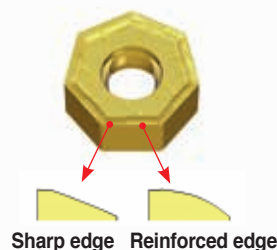
The shim type cutters come with two new insert types specifically designed for difficult-to-cut materials: the **MT** chip former for roughing and the **MLW** chip former for finishing. Designed with a variable edge geometry, the **MT** chip former can reach a maximum depth of cut up to 4.2 mm while the **MLW** type includes a big R shape wiper, which allows for excellent surface roughness making it suitable for finishing applications.

Cutter Features

- An optimally designed carbide shim meant for high feed cutting applications
- Carbide shims prevent damage to the cutter which enables consistent machining performance

Insert Features

- **MT chip former (Roughing)**
 - Corner R type
 - Variable and reinforced cutting edge geometry
 - Maximum depth of cut: 4.2 mm

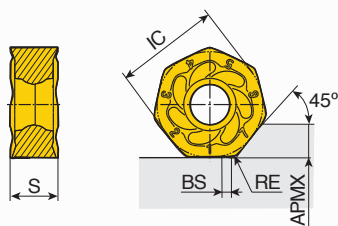


- **MLW chip former (Finishing)**
 - Applied big R shape wiper
 - Optimized geometry for finishing applications



XNM(H)U 06

Insert



| Size | Dimension (mm) | | | | |
|----------------------|----------------|-----|-----|-----|------|
| | IC | S | BS | RE | APMX |
| 06(M, MM, ML) | 13.7 | 6.2 | 1.0 | 1.0 | 3.5 |
| 06-MT | 13.7 | 6.0 | - | 0.8 | 4.2 |
| 06-MLW | 13.7 | 6.2 | 1.5 | 0.2 | 3.5 |
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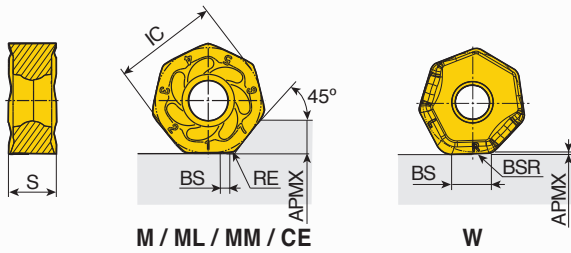
| Insert | Designation | Recommended machining conditions | | Ceramic | | Coated | | | | | Uncoated | | |
|--------|-------------------------------------------------------------|----------------------------------|-----------------|---------|--------|--------|--------|--------|--------|--------|----------|--------|-----|
| | | ap (mm) | Feed (mm/tooth) | AS10 | TT9080 | TT9030 | TT8080 | TT7800 | TT7080 | TT7515 | TT6080 | TT2510 | K10 |
| | XNMU 0605 ANR-M | 1.0-3.0 | 0.20-0.10 | | ● | | | | ● | | ● | | |
| | XNHU 0605 ANN-MM | 1.0-3.5 | 0.20-0.10 | | ● | | | | | | | | |
| | XNHU 0605 ANN-ML | 1.0-3.5 | 0.20-0.10 | | ● | | ● | | | | ● | | |
| | XNMU 060508-MT new | 1.0-4.2 | 0.30-0.10 | | | | ○ | | | | | | |
| | XNHU 0605 ANR-MLW new | 0.3-1.0 | 0.15-0.08 | | | | ○ | | | | | | |

• The MT and MLW chip formers will be available as a special grade for turbocharger machining operations.

●: Standard items
○: Semi standard items

XNM(H)U 09

Insert



| Size | Dimension (mm) | | | | | |
|-------------|----------------|----------|-----|-----|------|-----|
| | IC | S | BS | RE | APMX | BSR |
| 09 | 18.5 | 6.35-7.4 | 1.0 | 1.0 | 5.0 | - |
| 09-W | 18.5 | 6.35 | 7.0 | 1.0 | 1.0 | 250 |
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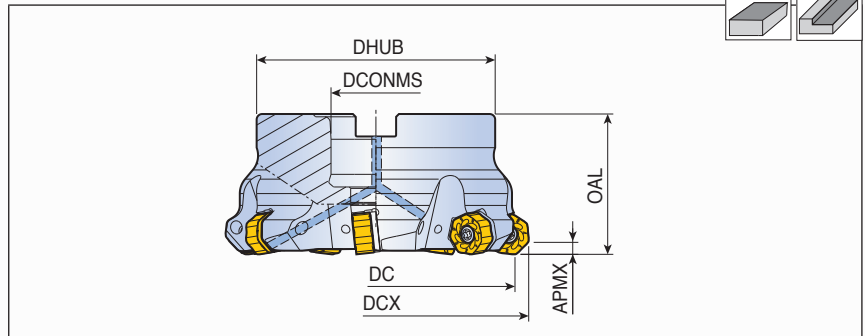


| Insert | Designation | Recommended machining conditions | | Ceramic | | | | | | | | Uncoated | |
|--------|--------------------------|----------------------------------|-----------------|---------|--------|--------|--------|--------|--------|--------|--------|----------|--|
| | | ap (mm) | Feed (mm/tooth) | AS10 | TT9080 | TT8080 | TT7800 | TT7080 | TT7515 | TT6080 | TT2510 | K10 | |
| | XNMU 0906 ANTR-M | 1.5-4.0 | 0.20-0.10 | | ● | ● | ● | ● | ● | ● | | | |
| | XNMU 0906 ANTN-ML | 1.5-4.0 | 0.25-0.13 | | ● | ● | | | | | | | |
| | XNHU 0906 ANTN-ML | 1.5-4.0 | 0.25-0.13 | | | | | | | ● | | | |
| | XNHU 0906 ANTN-MM | 1.5-4.0 | 0.25-0.13 | | ● | | ● | | ● | ● | | | |
| | XNHU 0906 ANTN-CE | 1.5-4.0 | 0.25-0.13 | ● | | | | | | | | | |
| | XNHU 0906 ANTN-W | 0.1-1.0 | 0.20-0.10 | | | | | | | ● | | | |

●: Standard items

14D-F45XNH-06 new

Shim type face mill



| Designation | | Dimension (mm) | | | | | | | Coolant | Arbor style | | Mounting bolt | Insert |
|------------------------------|----|----------------|-------|--------|------|-----|------|---|---------|-------------|-----------|-----------------|--------|
| | | DC | DCX | DCONMS | DHUB | OAL | APMX | | | | | | |
| 14D-F45XNH 763-22R-06 | 7 | 63 | 72.2 | 22 | 47 | 40 | 3.5 | ● | A | 0.7 | SH M10x25 | XNM(H)U 0605... | |
| 780-27R-06 | 7 | 80 | 89.2 | 27 | 70 | 50 | 3.5 | ● | A | 1.5 | SH M12x35 | | |
| 880-27R-06 | 8 | 80 | 89.2 | 27 | 70 | 50 | 3.5 | ● | A | 1.5 | SH M12x35 | | |
| 7100-32R-06 | 7 | 100 | 109.2 | 32 | 85 | 50 | 3.5 | ● | A | 2.2 | SH M16x35 | | |
| 8100-32R-06 | 8 | 100 | 109.2 | 32 | 85 | 50 | 3.5 | ● | A | 2.2 | SH M16x35 | | |
| 11125-40R-06 | 11 | 125 | 134.2 | 40 | 85 | 63 | 3.5 | ● | A | 3.5 | SH M20x40 | | |
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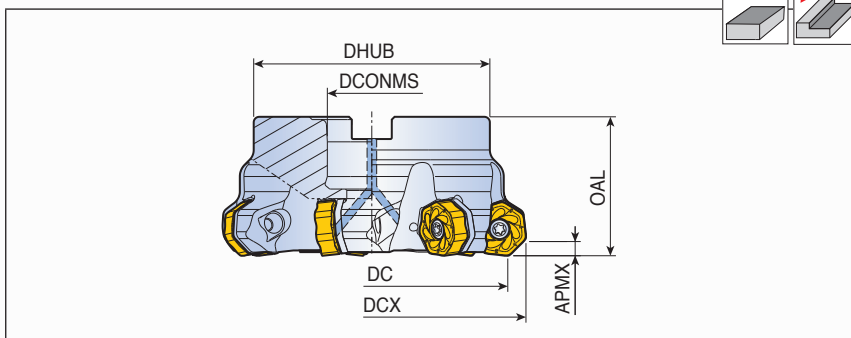
• Mounting bolt with coolant through hole is available on request (ordering example: SH M10x1.5x30-C)

Spare parts

| Designation | Screw | Wrench | Wrench handle | Shim | Shim screw |
|----------------------|------------|-------------|---------------|----------|---------------|
| 14D-F45XNH-06 | TS 35C110I | TBLD T15-W6 | SW6-T | TSXN 06N | TS 5035062S-B |
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14D-F45XNH-09 new

Shim type face mill



| Designation | | Dimension (mm) | | | | | | Coolant | Arbor style | | Mounting bolt | Insert |
|------------------------------|---|----------------|-------|--------|------|-----|------|---------|-------------|-----|---------------|-----------------|
| | | DC | DCX | DCONMS | DHUB | OAL | APMX | | | | | |
| 14D-F45XNH 563-22R-09 | 5 | 63 | 75.1 | 22 | 47 | 40 | 5 | ● | A | 0.6 | SH M10x25 | XNM(H)U 0906... |
| 680-27R-09 | 6 | 80 | 92.1 | 27 | 70 | 50 | 5 | ● | A | 1.5 | SH M12x35 | |
| 7100-32R-09 | 7 | 100 | 112.1 | 32 | 85 | 50 | 5 | ● | A | 2.2 | SH M16x35 | |
| 9125-40R-09 | 9 | 125 | 137.0 | 40 | 85 | 63 | 5 | ● | A | 3.6 | SH M20x40 | |
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• Mounting bolt with coolant through hole is available on request (ordering example: SH M10x1.5x30-C)

Spare parts

| Designation | Screw | Wrench | Wrench handle | Shim | Shim screw |
|----------------------|--------------|-------------|-------------------|----------|----------------|
| 14D-F45XNH-09 | TS 50C130/HG | TBLD T20-W6 | SW6-T | TSXN 09N | TS 8050088S |
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