

NPN

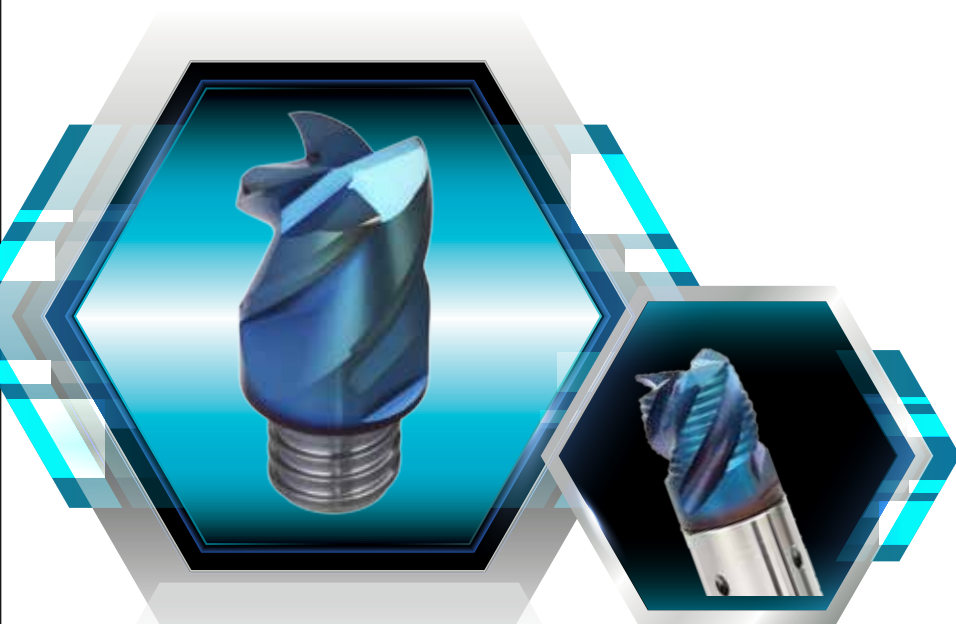
New Product News



MAXIRUSH

INDEXABLE SOLID HEADS

Head Changeable Type Solid End Mill



KEY POINT

TaeguTec has released a convenient head changeable type solid carbide end mill.

The innovative head changeable type solid carbide end mill, launched under the brand name **MAXI-RUSH**, replaces most of the existing conventional solid end mills machining range. The line is a new high productivity tooling solution offering outstanding advantages.

Superior performance is the result along with quick and easy indexable heads which reduce set up time and improve customer productivity. The **MAXI-RUSH** line is offered in many head types covering all applications; they also come in steel, carbide and tungsten shank holders in various lengths that can be combined to provide the widest flexibility in tooling solutions.

For further technical questions, please contact TaeguTec's product manager.

Features

- Rigid and precise double contact fastening system



Flat contact surface for precise axial runout accuracy

Conical taper contact for self-centering and precise radial runout accuracy

Quick and rigid unique threading

- Tooling downtime minimized by replacing the heads quickly

Collet chuck + MAXI-RUSH



Easy head replacement
with spindle engaged

**Replacement
time is
dramatically
reduced**

Collet chuck + end mill



Separate the arbor
from the spindle



Secure the arbor to the tool post and
remove the nut and the end mill

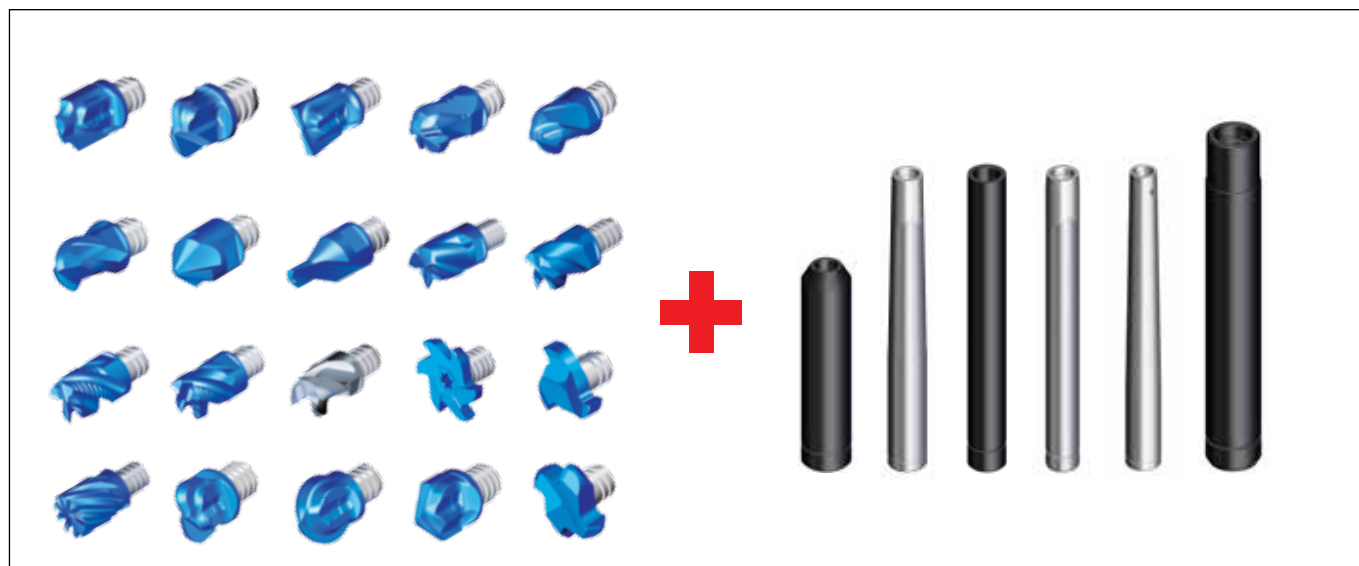


Set the height, if necessary,
after tightening the end mill



Re-mount the arbor
to the spindle

■ Available in a wide variety of indexable head types and shank types



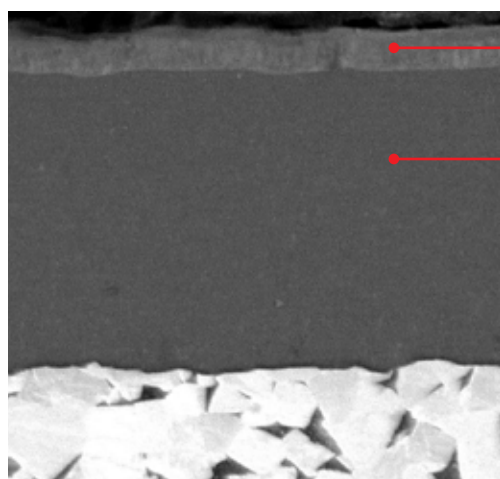
- Flat, ball, corner radius, chamfer, slot, etc
Available in various head types for all applications
- Available diameter range:
General: Ø6-Ø25, Slot: Ø13.5-Ø27.7

- With various shapes and lengths such as straight shanks with neck and taper neck in various materials, the optimal choice considering stiffness and interference
- Available in both steel, carbide and tungsten materials
- Internal through coolant capability

■ Applied with the latest coating grade for dedicated MAXI-RUSH (TT5523, TT5543)

- Optimal combination of wear resistance and chipping resistance makes it suitable for various materials and applications
- Distinctive shiny blue color appearance

TT5523

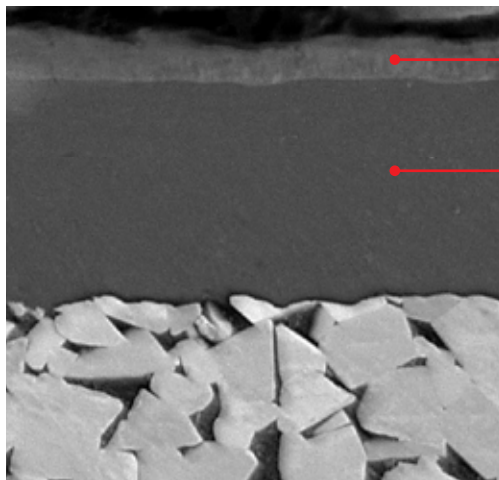


Unique blue color layer

Nano-crystalline structured AlTiN layer

- Excellent abrasion resistant sub-micron substrate
- Anti-abrasion and oxidation resistant PVD AlTiN coating layer
- High-speed milling of steel and cast iron, stainless steel and heat resistant super alloys
- Applied to all MAXI-RUSH items except the T-slot type

TT5543



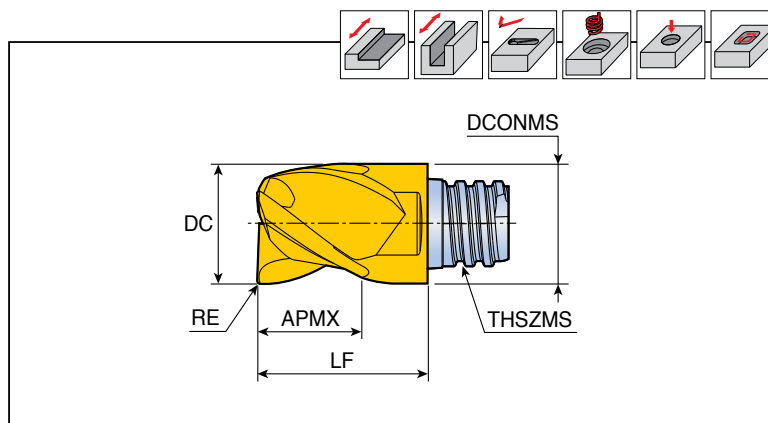
Unique blue color layer

Nano-crystalline
structured AlTiN layer

- Tough carbide grade with an advanced PVD AlTiN coating layer
- Suitable for T-Slot interrupted and rough machining of various materials
- Applied to T-slot items only



3 flute, for general purpose



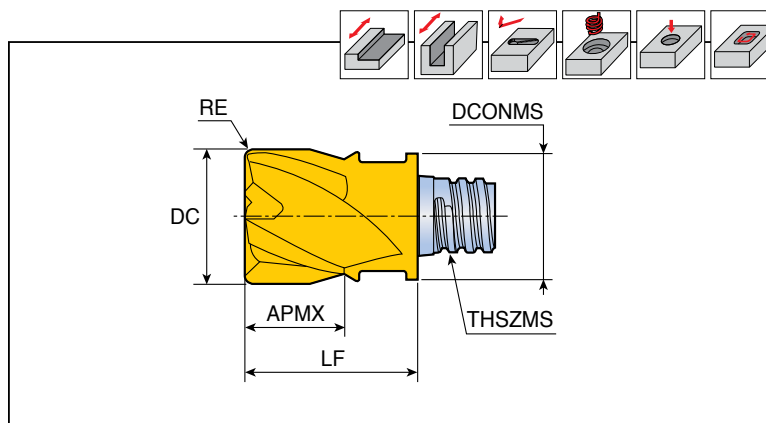
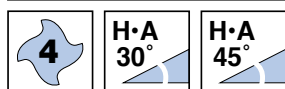
●: Standard items

MXEE(D)-04

4 flute, for general purpose



MAXIRUSH
UNBREAKABLE SOLID END MILLS



Designation	Feed (mm/tooth)	Dimension (mm)							Grade TT5523
		DC	RE	FHA	APMX	THSZMS	DCONMS	LF	
MXEE 060L05R00-04S05	0.025-0.060	6	-	45	5	S05	8	10	●
MXEE 080L05R00-04S05	0.030-0.080	8	-	45	5	S05	7.7	10	●
MXED 080L05R05-04S05	0.030-0.080	8	0.5	30	5	S05	7.7	10	●
MXED 080L05R10-04S05	0.030-0.080	8	1.0	30	5	S05	7.7	10	●
MXED 080L05R15-04S05	0.030-0.080	8	1.5	30	5	S05	7.7	10	●
MXEE 100L07R00-04S06	0.035-0.090	10	-	45	7	S06	9.7	13	●
MXED 100L07R05-04S06	0.035-0.090	10	0.5	30	7	S06	9.7	13	●
MXEE 100L07R05-04S06	0.035-0.090	10	0.5	45	7	S06	9.7	13	●
MXED 100L07R10-04S06	0.035-0.090	10	1.0	30	7	S06	9.7	13	●
MXEE 100L07R10-04S06	0.035-0.090	10	1.0	45	7	S06	9.7	13	●
MXEE 120L09R00-04S08	0.035-0.110	12	-	45	9	S08	11.7	16.5	●
MXED 120L09R05-04S08	0.035-0.110	12	0.5	30	9	S08	11.7	16.5	●
MXEE 120L09R05-04S08	0.035-0.110	12	0.5	45	9	S08	11.7	16.5	●
MXED 120L09R10-04S08	0.035-0.110	12	1.0	30	9	S08	11.7	16.5	●
MXEE 120L09R10-04S08	0.035-0.110	12	1.0	45	9	S08	11.7	16.5	●
MXEE 160L12R00-04S10	0.040-0.130	16	-	45	12	S10	15.3	20.5	●
MXED 160L12R05-04S10	0.040-0.130	16	0.5	30	12	S10	15.3	20.5	●
MXEE 160L12R05-04S10	0.040-0.130	16	0.5	45	12	S10	15.3	20.5	●
MXED 160L12R10-04S10	0.040-0.130	16	1.0	30	12	S10	15.3	20.5	●
MXEE 160L12R40-04S10	0.040-0.130	16	4.0	45	12	S10	15.3	20.5	●
MXEE 200L15R00-04S12	0.050-0.150	20	-	45	15	S12	18.3	25.5	●
MXED 200L15R05-04S12	0.050-0.150	20	0.5	30	15	S12	18.3	25.5	●
MXED 200L15R10-04S12	0.050-0.150	20	1.0	30	15	S12	18.3	25.5	●
MXED 200L15R20-04S12	0.050-0.150	20	2.0	30	15	S12	18.3	25.5	●
MXED 200L15R30-04S12	0.050-0.150	20	3.0	30	15	S12	18.3	25.5	●

● FHA: Flute helix angle

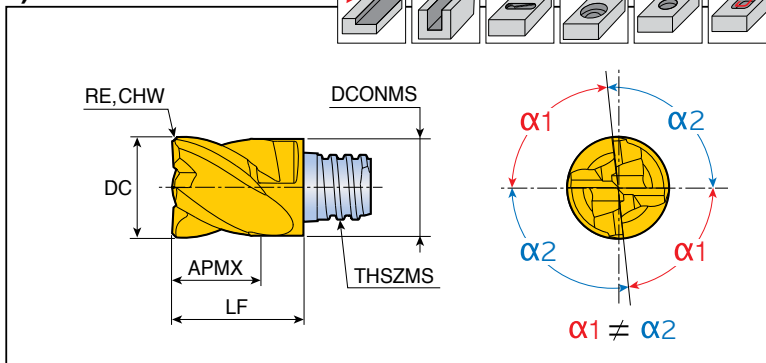
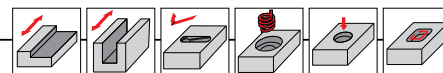
●: Standard items

MXEE-I04

4 flute, irregular-pitch flutes (vibration free)



MAXIRUSH
UNBREAKABLE & VIBRATION FREE



H-A
38°

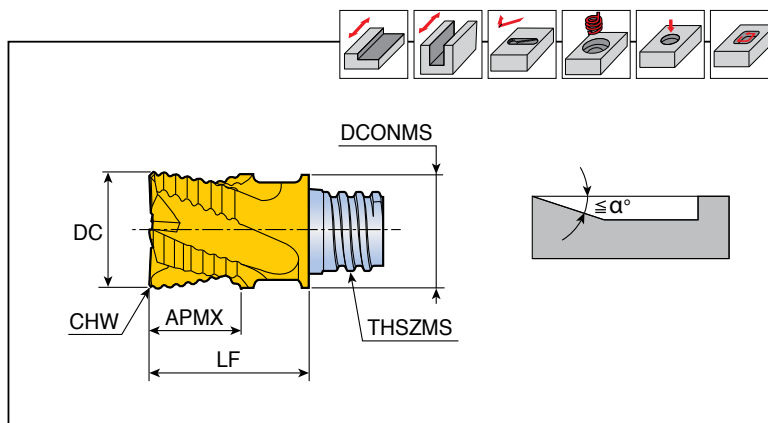
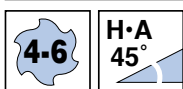
Designation	Feed (mm/tooth)	Dimension (mm)							Grade
		DC	RE	CHW	APMX	THSZMS	DCONMS	LF	
MXEE 080L05C30I04S05	0.030-0.080	8	-	0.3	5	S05	7.7	10	●
100L07C40I04S06	0.035-0.090	10	-	0.4	7	S06	9.7	13	●
120L09C50I04S08	0.035-0.110	12	-	0.5	9	S08	11.7	16.5	●
160L12C60I04S10	0.040-0.130	16	-	0.6	12	S10	15.3	20.5	●
200L15C60I04S12	0.050-0.150	20	-	0.6	15	S12	18.3	25.5	●
250L22R30I04S15	0.060-0.170	25	3.0	-	22	S15	23.9	37	●

●: Standard items

MXEE-R

4-6 flute, for roughing

MAXIRUSH
INDEXABLE SOLID END MILLS



Designation	Feed (mm/tooth)	Dimension (mm)								Grade
		DC	NOF	APMX	CHW	THSZMS	DCONMS	LF	α°	
MXEE 080L05C25R04S05	0.030-0.080	8	4	5	0.25	S05	7.7	10	90	●
100L07C30R04S06	0.035-0.090	10	4	7	0.30	S06	9.7	13	90	●
120L09C35R04S08	0.035-0.110	12	4	9	0.35	S08	11.7	16.5	90	●
160L12C40R05S10	0.040-0.130	16	5	12	0.40	S10	15.3	20.5	7	●
200L15C40R06S12	0.050-0.150	20	6	15	0.40	S12	18.3	25.5	3	●
250L22C50R06S15	0.060-0.170	25	6	22	0.50	S15	23.9	37	3	●

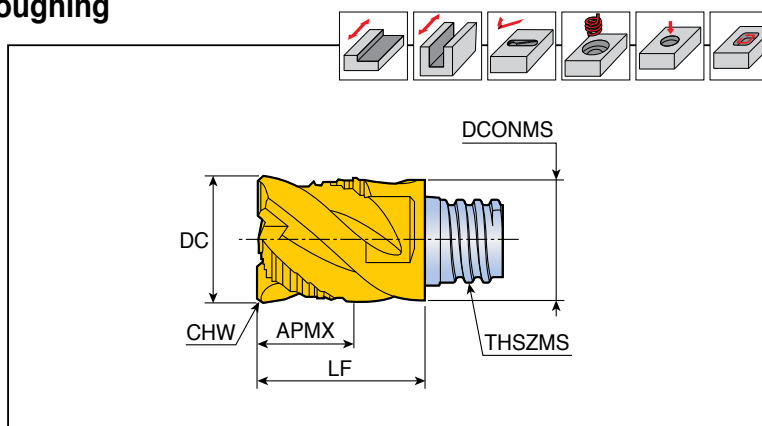
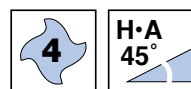
● NOF: Number of flutes

●: Standard items

MXEE-C04

4 flute, combined edges for finishing & roughing

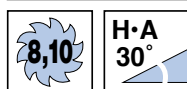
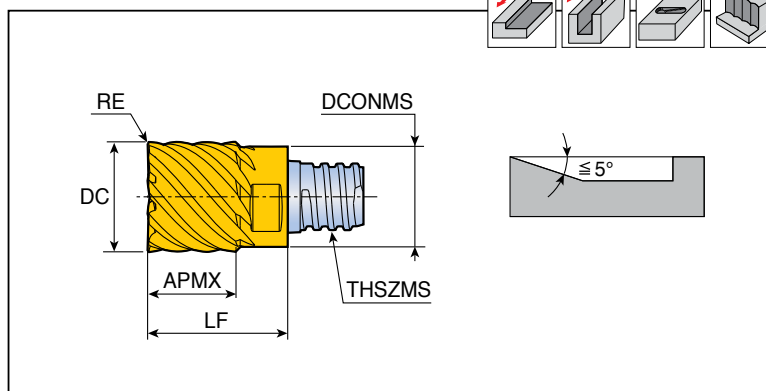
MAXIRUSH
INDEXABLE SOLID END MILLS



Designation	Feed (mm/tooth)	Dimension (mm)						Grade
		DC	APMX	CHW	THSZMS	DCONMS	LF	
MXEE 080L05C30C04S05	0.030-0.080	8	5	0.3	S05	7.7	10	●
100L07C30C04S06	0.035-0.090	10	7	0.3	S06	9.7	13	●
120L09C40C04S08	0.035-0.110	12	9	0.4	S08	11.7	16.5	●
160L12C60C04S10	0.040-0.130	16	12	0.6	S10	15.3	20.5	●
200L15C60C04S12	0.050-0.150	20	15	0.6	S12	18.3	25.5	●
250L22C60C04S15	0.060-0.170	25	22	0.6	S15	23.9	37	●

●: Standard items

MAXIRUSH



- NOF: Number of flutes

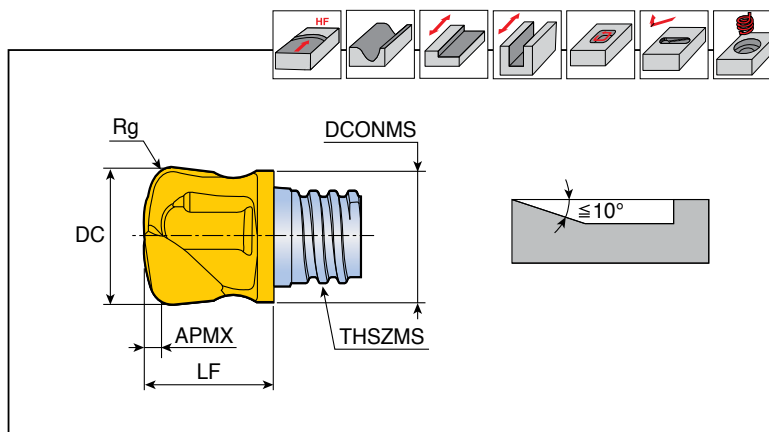
●: Standard items

MXFX-02

2 flute, for high feed milling



MAXIRUSH
INDEXABLE SOLID FEEDERS



Designation	Feed (mm/tooth)	Dimension (mm)						Grade
		DC	Rg	APMX	THSZMS	DCONMS	LF	
MXFX 100L0.6R20-02S06	0.035-0.090	10	2.0	0.6	S06	9.6	12.5	●
120L01R25-02S08	0.035-0.110	12	2.5	1.0	S08	11.5	11.1	●
160L1.1R30-02S10	0.040-0.130	16	3.0	1.1	S10	15.2	20	●

• Rg: Radius for programmers

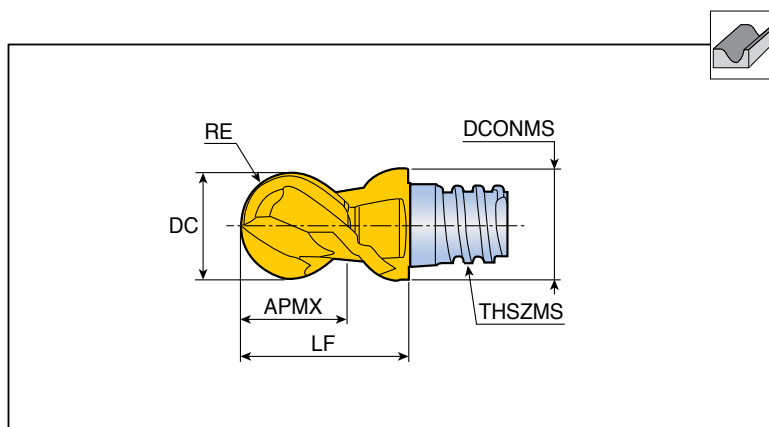
●: Standard items

MXBD-BG-02

2 flute, for high precision machining



MAXIRUSH
INDEXABLE SOLID FEEDERS



Designation	Feed (mm/tooth)	Dimension (mm)						Grade
		DC	RE	APMX	THSZMS	DCONMS	LF	
MXBD 080L05-BG-02S05	0.030-0.080	8	3.982 ⁽¹⁾	5	S05	7.7	10	●
100L07-BG-02S06	0.035-0.090	10	4.982 ⁽¹⁾	7	S06	9.7	13	●
120L09-BG-02S08	0.035-0.110	12	5.978 ⁽²⁾	9	S08	11.7	16.5	●
160L09-BG-02S10	0.040-0.130	16	7.978 ⁽²⁾	9	S10	15.3	20.5	●

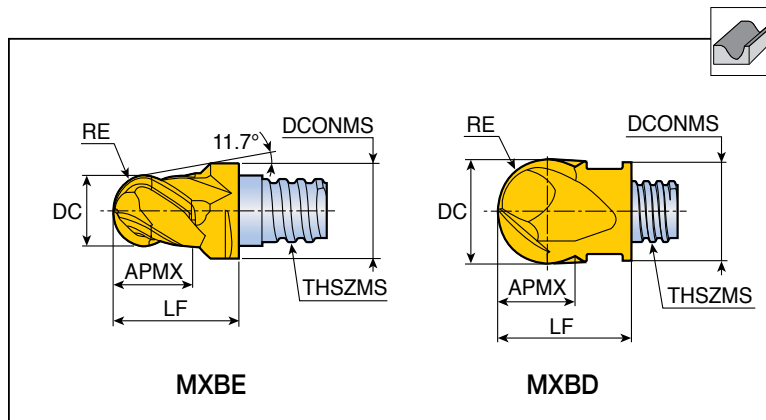
• RE Tolerance: ⁽¹⁾± 0.01, ⁽²⁾± 0.012

●: Standard items

MXBD(E)-BG-04

MAXIRUSH
INDENKABLE SOLID HEADS

4 flute, for high precision machining



Designation	Feed (mm/tooth)	Dimension (mm)								Grade
		DC	RE	FHA	APMX	THSZMS	DCONMS	LF		TT5523
MXBE 060L05-BG-04S05	0.025-0.060	6	2.987 ⁽¹⁾	38	5.5	S05	8.0	10		●
MXBD 080L05-BG-04S05	0.030-0.080	8	3.982 ⁽¹⁾	30	5	S05	7.7	10		●
100L07-BG-04S06	0.035-0.090	10	4.982 ⁽¹⁾	30	7	S06	9.7	13		●
120L09-BG-04S08	0.035-0.110	12	5.978 ⁽²⁾	30	9	S08	11.7	16.5		●
160L12-BG-04S10	0.040-0.130	16	7.978 ⁽²⁾	30	12	S10	15.3	20.5		●
200L15-BG-04S12	0.050-0.150	20	9.972 ⁽²⁾	30	15	S12	18.3	25.5		●
250L22-BG-04S15	0.060-0.170	25	12.470 ⁽³⁾	30	22	S15	23.9	37		●

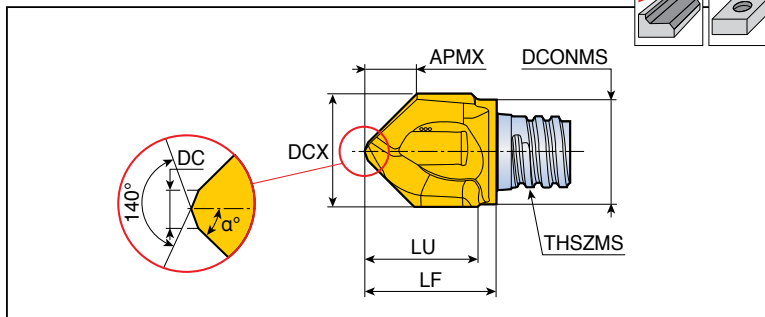
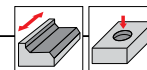
- RE Tolerance: ⁽¹⁾± 0.01, ⁽²⁾± 0.012, ⁽³⁾± 0.02
- FHA: Flute helix angle

●: Standard items

MXCP-02



2 flute, for spot drilling, chamfering and countersinking



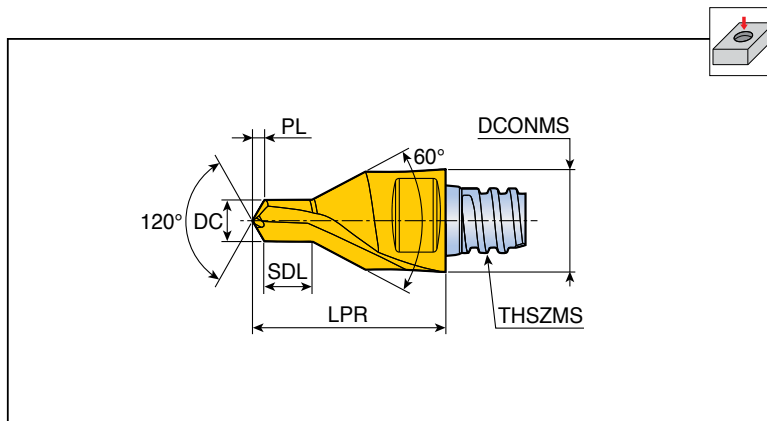
Designation	Feed (mm/tooth)	Dimension (mm)								Grade
		DCX	DC	APMX	THSZMS	DCONMS	LU	LF	α°	
MXCP 100L09A30-02S06	0.035-0.090	10	1.5	7.5	S06	9.5	8.5	11.75	30	●
120L12A30-02S08	0.035-0.110	12	1.5	9.2	S08	11.5	11	15.4	30	●
160L15A30-02S10	0.040-0.130	16	2.5	12	S10	15.2	16	20.2	30	●
080L07A45-02S05	0.030-0.080	8	1.0	3.7	S05	7.6	7.5	9.75	45	●
083L07A45-02S05	0.030-0.080	8.3	1.0	3.8	S05	7.6	7.5	10	45	●
100L09A45-02S06	0.035-0.090	10	1.5	4.4	S06	9.5	9.5	11.75	45	●
104L09A45-02S06	0.035-0.090	10.4	1.5	4.6	S06	9.5	9.5	11.75	45	●
120L12A45-02S08	0.035-0.110	12	1.5	5.4	S08	11.5	11.5	15.4	45	●
124L12A45-02S08	0.035-0.110	12.4	1.5	5.6	S08	11.5	11.5	15.4	45	●
160L15A45-02S10	0.040-0.130	16	1.5	7.1	S10	15.2	15	18.8	45	●
165L15A45-02S10	0.040-0.130	16.5	1.5	7.1	S10	15.2	15	18.8	45	●
100L09A60-02S06	0.035-0.090	10	1.5	2.7	S06	9.5	9.5	12.7	60	●
120L12A60-02S08	0.035-0.110	12	1.5	3.3	S08	11.5	11.5	15.2	60	●
160L15A60-02S10	0.040-0.130	16	1.5	4.4	S10	15.2	16	19.9	60	●

●: Standard items

MXDP-02

MAXIRUSH
INDEXABLE SOLID HEADS

2 flute, for center drilling



Designation	Feed (mm/tooth)	Dimension (mm)						Grade
		DC	PL	SDL	THSZMS	DCONMS	LPR	
MXDP 328L04A30-02S05	0.04-0.08	3.28	0.85	3.75	S05	8	15	●
412L05A30-02S06	0.05-0.10	4.12	1.07	4.83	S06	10	19	●
513L07A30-02S08	0.05-0.12	5.13	1.32	5.88	S08	12	23	●
646L08A30-02S10	0.06-0.15	6.46	1.65	7.25	S10	16	28	●

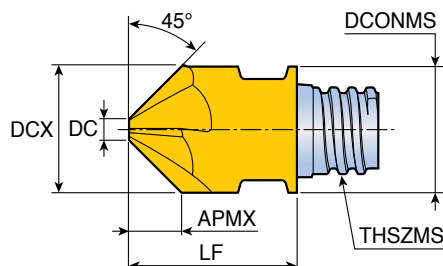
• SDL : Step diameter length

●: Standard items

MXCA-04/06



4, 6 flute, chamfering and countersinking (without center edge)



Designation	Feed (mm/tooth)	Dimension (mm)							Grade	
		DCX	DC	NOF	APMX	THSZMS	DCONMS	LF	TT5523	
MXCA 100L04A45-04S06	0.035-0.090	10	1.95	4	4.0	S06	10	13	●	
120L05A45-04S08	0.035-0.110	12	1.95	4	5.0	S08	12	16.5	●	
127L05A45-04S08	0.035-0.110	12.7	1.98	4	5.3	S08	12.7	16.5	●	
160L06A45-06S10	0.040-0.130	16	3.0	6	6.5	S10	16	20.3	●	
200L07A45-06S12	0.050-0.150	20	5.0	6	7.5	S12	20	25.5	●	

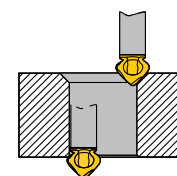
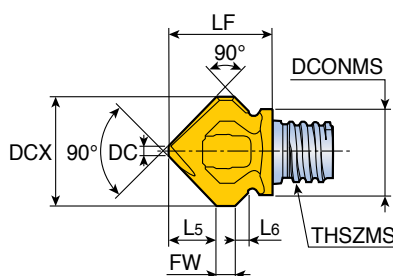
• NOF: Number of flutes

●: Standard items

MXCW-02



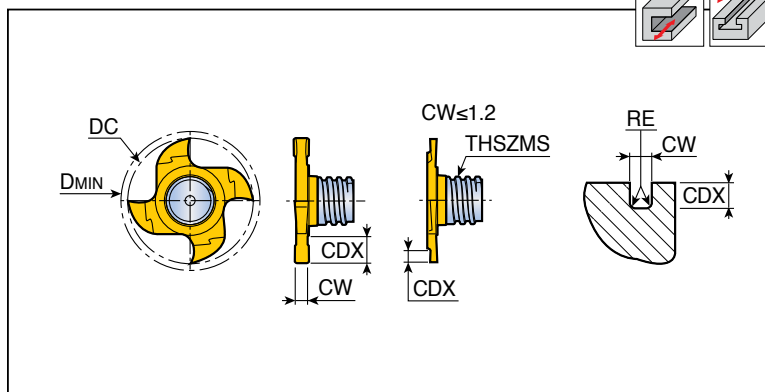
2 flute, for double chamfering



Designation	Feed (mm/tooth)	Dimension (mm)							Grade	
		DCX	DC	L5	L6	FW	THSZMS	DCONMS	LF	TT5523
MXCW 118L05A45-02S06	0.035-0.110	11.8	1.2	5	1.2	2	S06	9.3	11.2	●

●: Standard items

MAXIRUSH
INDENKABLE SON-LO HEADS



4,6

[illegible]

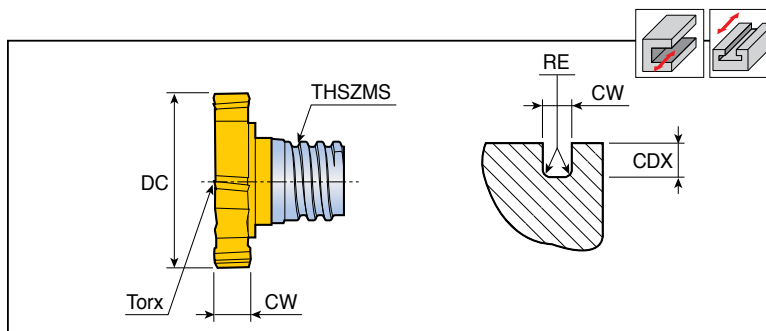
- : Standard items

TTB-06

6 flute, for slotting



MAXIRUSH
UNBREAKABLE SOLID END MILLS



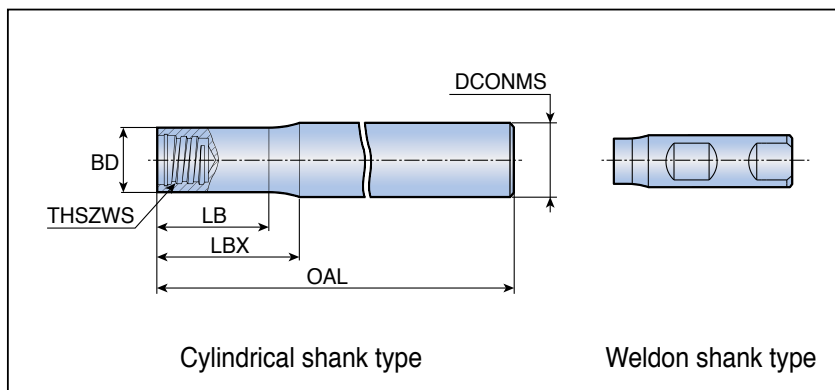
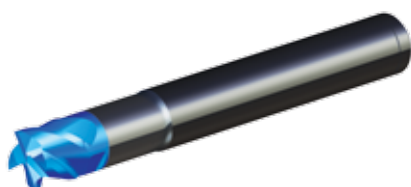
Designation	Feed (mm/tooth)	Dimension (mm)					Torx	Grade TT5543
		DC	CW	CDX	RE	THSZMS		
TTB 135W3.0R04-06S05	0.025-0.130	13.5	3	2.65	0.4	S05	T20	●
135W4.0R04-06S05	0.025-0.150	13.5	4	2.65	0.4	S05	T20	●
160W2.0R04-06S06	0.025-0.120	16	2	2.9	0.4	S06	T20	●
160W3.0R04-06S06	0.025-0.130	16	3	2.9	0.4	S06	T25	●
160W4.0R04-06S06	0.025-0.150	16	4	2.9	0.4	S06	T25	●
165W2.0R04-06S06	0.025-0.120	16.5	2	3.15	0.4	S06	T20	●
165W3.0R04-06S06	0.025-0.130	16.5	3	3.15	0.4	S06	T25	●
165W4.0R04-06S06	0.025-0.150	16.5	4	3.15	0.4	S06	T25	●
195W4.0R04-06S08	0.025-0.150	19.5	4	3.45	0.4	S08	T30	●
195W5.0R04-06S08	0.025-0.150	19.5	5	3.45	0.4	S08	T30	●
195W6.0R04-06S08	0.025-0.170	19.5	6	3.45	0.4	S08	T30	●
225W5.0R04-06S08	0.025-0.150	22.5	5	4.95	0.4	S08	T40	●
225W6.0R04-06S08	0.025-0.170	22.5	6	4.95	0.4	S08	T40	●
225W8.0R04-06S08	0.025-0.170	22.5	8	4.95	0.4	S08	T40	●
250W6.0R04-06S08	0.025-0.170	25	6	5.9	0.4	S08	T50	●
250W8.0R04-06S08	0.025-0.170	25	8	5.9	0.4	S08	T50	●
250W5.0R04-06S10	0.025-0.150	25	5	4.3	0.4	S10	T50	●
250W6.0R04-06S10	0.025-0.170	25	6	4.3	0.4	S10	T50	●
250W8.0R04-06S10	0.025-0.170	25	8	4.3	0.4	S10	T50	●

●: Standard items

MXSSD

Straight shank and neck

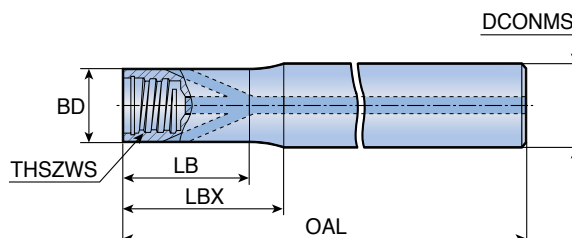
MAXIRUSH
INDEFATIGABLE SOLID END MILLS



Designation	Dimension (mm)						Shank type	Shank material
	THSZWS	DCONMS	BD	OAL	LB	LBX		
MXSSD 08L060S05-S	S05	8	7.6	60	12.8	15	Cylindrical	Steel
08L070S05-C	S05	8	7.6	70	19	20	Cylindrical	Carbide
08L090S05-C	S05	8	7.6	90	39	40	Cylindrical	Carbide
08L110S05-C	S05	8	7.6	110	59	60	Cylindrical	Carbide
10L070S06-C	S06	10	9.6	70	18.5	20	Cylindrical	Carbide
10L075S06-S	S06	10	9.6	75	17.7	20	Cylindrical	Steel
10L090S06-C	S06	10	9.6	90	38.5	40	Cylindrical	Carbide
10L110S06-C	S06	10	9.6	110	58.5	60	Cylindrical	Carbide
10L150S06-C	S06	10	9.6	150	98.5	100	Cylindrical	Carbide
12L055W05-S	S05	12	7.6	55	-	3.8	Weldon	Steel
12L070S08-C	S08	12	11.5	70	17	20	Cylindrical	Carbide
12L090S08-C	S08	12	11.5	90	37	40	Cylindrical	Carbide
12L090S08-S	S08	12	11.5	90	13.6	16	Cylindrical	Steel
12L110S08-C	S08	12	11.5	110	57	60	Cylindrical	Carbide
12L130S08-C	S08	12	11.5	130	77	80	Cylindrical	Carbide
16L065W06-S	S06	16	9.6	65	-	6	Weldon	Steel
16L065W08-S	S08	16	11.5	65	-	4	Weldon	Steel
16L090S10-C	S10	16	15.2	90	38	40	Cylindrical	Carbide
16L100S10-S	S10	16	15.2	100	18	20	Cylindrical	Steel
16L110S10-C	S10	16	15.2	110	58	60	Cylindrical	Carbide
16L130S10-C	S10	16	15.2	130	78	80	Cylindrical	Carbide
16L150S10-C	S10	16	15.2	150	98	100	Cylindrical	Carbide
20L070W10-S	S10	20	15.2	70	-	4	Weldon	Steel
20L090S12-C	S12	20	18.3	90	37	40	Cylindrical	Carbide
20L120S12-S	S12	20	18.3	120	20.5	25	Cylindrical	Steel
20L130S12-C	S12	20	18.3	130	77	80	Cylindrical	Carbide

• THSZWS: Connection thread size

MAXIRUSH
UNBEATABLE SON-TO-HEADS

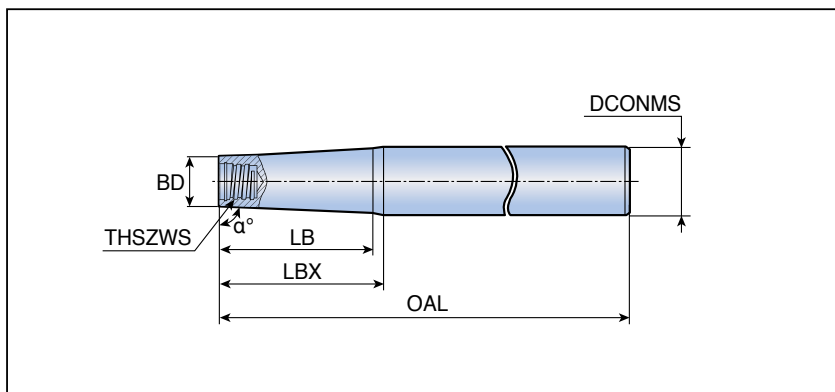


- **THSZWS:** Connection thread size

MXTSD



Straight shank and taper neck



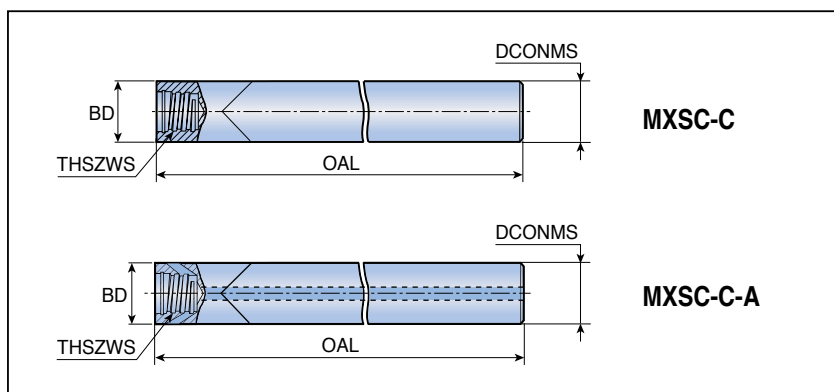
Designation	Dimension (mm)							Shank material
	α°	THSZWS	DCONMS	BD	OAL	LB	LBX	
MXTSD 12L080S05-S	85	S05	12	7.6	80	-	25	Steel
12L100S05-S	89	S05	12	7.6	100	31.0	35	Steel
12L110S05-C	89	S05	12	7.6	110	58.0	60	Carbide
12L130S05-C	89	S05	12	7.6	130	79.0	80	Carbide
16L125S06-S	85	S06	16	9.6	125	31.6	34	Steel
16L130S08-C	89	S08	16	11.5	130	78.8	80	Carbide
16L140S08-S	85	S08	16	11.5	140	19.3	22	Steel
16L150S05-C	89	S05	16	7.6	150	96.0	100	Carbide
16L150S06-C	89	S06	16	9.6	150	98.0	100	Carbide
16L150S08-C	89	S08	16	11.5	150	-	100	Carbide
16L160S06-S	89	S06	16	9.6	160	45.9	55	Steel
16L170S06-C	89	S06	16	9.6	170	119.0	120	Carbide
20L140S10-S	85	S10	20	15.2	140	-	27.5	Steel
20L170S08-C	89	S08	20	11.5	170	117.0	120	Carbide
20L170S08-S	89	S08	20	11.5	170	68.6	80	Steel
20L170S10-C	89	S10	20	15.2	170	-	120	Carbide
20L190S10-C	89	S10	20	15.2	190	-	140	Carbide
20L190S10-S	89	S10	20	15.2	190	73.0	80	Steel
20L210S10-C	89	S10	20	15.2	210	-	160	Carbide
25L160S12-S	85	S12	25	18.3	160	-	40	Steel
25L170S10-S	85	S10	25	15.2	170	-	56	Steel
25L180S12-C	89	S12	25	18.3	180	-	120	Carbide
25L210S12-S	89	S12	25	18.3	210	91.0	100	Steel
25L250S12-C	89	S12	25	18.3	250	-	140	Carbide
32L155S15-S	85	S15	32	23.9	155	40.0	45	Steel
32L190S12-S	85	S12	32	18.3	190	-	80	Steel

• THSZWS: Connection thread size

MXSC



Straight carbide shanks for TST type slotting head



Designation	Dimension (mm)				Internal coolant	Shank material
	THSZWS	DCONMS	BD	OAL		
MXSC 100L100S06-C	S06	10	10	100	x	Carbide
120L100S08-C-A	S08	12	12	100	•	Carbide

- THSZWS: Connection thread size

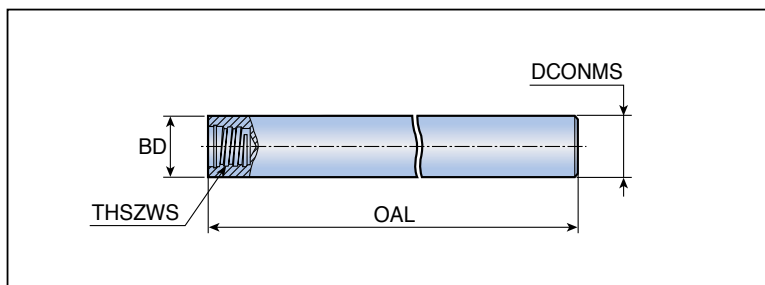
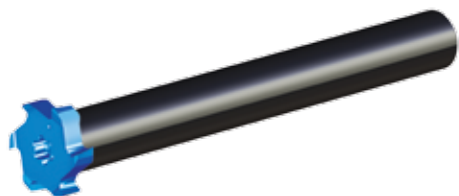
Note:

- For MXSC type shank, it is recommended to use the TST slotting head only. If other heads are used on the MXSC shank, the depth of cut must be smaller than the max. ap in each head. The MXSC type shank does not have external clearance, so the shank may interfere with the work piece.

MXSTD



Straight shanks for TTB type slotting head



Designation	Dimension (mm)				Shank material
	THSZWS	DCONMS	BD	OAL	
MXSTD 08L070S05-S	S05	8	8	70	Steel
10L080S06-S	S06	10	10	80	Steel
12L090S08-S	S08	12	12	90	Steel
16L100S10-S	S10	16	16	100	Steel

- THSZWS: Connection thread size

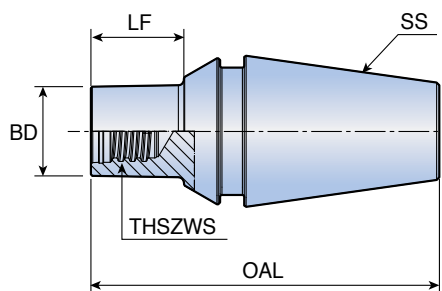
Note:

- For MXSTD type shank, it is recommended to use the TTB slotting head only. If other heads are used on the MXSTD shank, the depth of cut must be smaller than the max. ap in each head. The MXSTD type shank does not have external clearance, so the shank may interfere with the work piece.

MXER



ER collet chucks conversion adaptor with MAXI-RUSH



Designation	Dimension (mm)					Shank material
	SS	THSZWS	BD	LF	OAL	
MXER 11CL006S05-S	ER11	S05	7.92	6	24.0	Steel
11CL020S05-S	ER11	S05	7.92	20	38.0	Steel
16CL012S05-S	ER16	S05	7.92	12	39.5	Steel
16CL020S05-S	ER16	S05	7.92	20	47.5	Steel
16CL010S06-S	ER16	S06	9.92	10	37.5	Steel
16CL020S06-S	ER16	S06	9.92	20	47.5	Steel
16CL006S08-S	ER16	S08	11.6	6	33.5	Steel
16CL020S08-S	ER16	S08	11.6	20	47.5	Steel

- THSZWS: Connection thread size

Wrench

Appearance	Designation	Connection thread size	Torque (N.m)	Head
	MX KEY-S05	S05	7	Square Ball Round Drilling Chamfering Counter boring
	MX KEY-S05	S06	10	
	MX KEY-S08	S08	15	
	MX KEY-S10	S10	28	
	MX KEY-S12	S12	28	
	MX KEY-S15	S15	40	
	MX SKEY-S06	S06	10	Slotting TST type
	MX SKEY-S08	S08	15	
	MX SKEY-T40L	S08	15	Slotting TST, TTB type
		S10	28	
	MX SKEY-T20	S05	7	
		S06	10	
	MX SKEY-T25	S06	10	
	MX SKEY-T30L	S08	15	
	MX SKEY-T50L	S08	15	
		S10	28	

• Wrench should be ordered separately

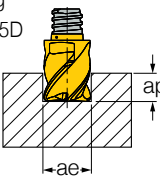
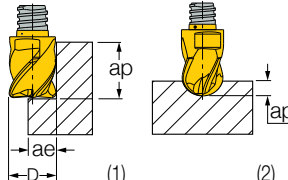
Torque wrench

Appearance	Designation	Connection	TM head designation	Torque (N.m)
Handle 	TORQUE WRENCH 5-50Nm 9X12	-	-	-
Open wrench for cylindrical head 	MX WRENCH 6-05	S05	MXED, MXEE	7
	MX WRENCH 8-06	S06	MXEE-I, MXEE-R	10
	MX WRENCH 10-08	S08	MXEE-C, MXEE-A	15
	MX WRENCH 13-10	S10	MXRD, MXBD-BG	28
	MX WRENCH 16-12	S12	MXBE-BGA	28
	MX WRENCH 20-15	S15	MXDP, MXCA	40
Open wrench for 2 flutes head 	MX WRENCH 4E-05	S05	MXRB, MXRC	7
	MX WRENCH 5E-06	S06	MXFX, MXBB-BM	10
	MX WRENCH 7E-08	S08	MXBB-BG	15
	MX WRENCH 8E-10	S10	MXCP, MXGC	28
	MX WRENCH 9E-12	S12	MXCW, MXCR	28
90° adapter for torx bit 	INSERT TOOL 9X12mm	-	-	-
Torx bit socket 	BIT SOCKET T20 DRIVE	S05, S06	TTB135 TTB160W2.00 TTB165W2.00	7, 10
	BIT SOCKET T25 DRIVE	S06	TTB160W3.00 TTB160W4.00	10
	BIT SOCKET T30 DRIVE	S08	TTB165W3.00	15
	BIT SOCKET T40 DRIVE	S08, S10	TTB165W4.00 TTB195	15, 28
	BIT SOCKET T50 DRIVE	S08, S10	TST277 TTB225 TTB250	15, 28

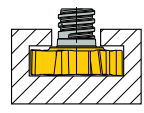
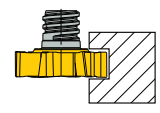
• Wrench should be ordered separately

Recommended Cutting Conditions

Fz for Square & Round heads

Slotting $ap \leq 0.5D$ $ae \leq D$ 		Side Milling $ae \leq 0.5D$ (1) $ap \leq D$ (2) $ap \leq 0.05D$ 	
D (mm)	Fz (mm/t)	D (mm)	Fz (mm/t)
6	0.027-0.05	6	0.027-0.06
8	0.032-0.07	8	0.032-0.08
10	0.034-0.08	10	0.034-0.09
12	0.036 - 0.1	12	0.036-0.11
16	0.05 - 0.12	16	0.05 - 0.13
20	0.052-0.14	20	0.052-0.15
25	0.062-0.15	25	0.062-0.17

Fz for Slotting heads

ISO		
P	0.025-0.12	0.035-0.15
M	0.025-0.10	0.025-0.12
K	0.025-0.15	0.035-0.17
Thread Size	Key	Clamping Torque (N.m)
S05	MX KEY-S05	7
S06	MX KEY-S06	10
S08	MX KEY-S08	15
S10	MX KEY-S10	28
S12	MX KEY-S12	28
S15	MX KEY-S15	40

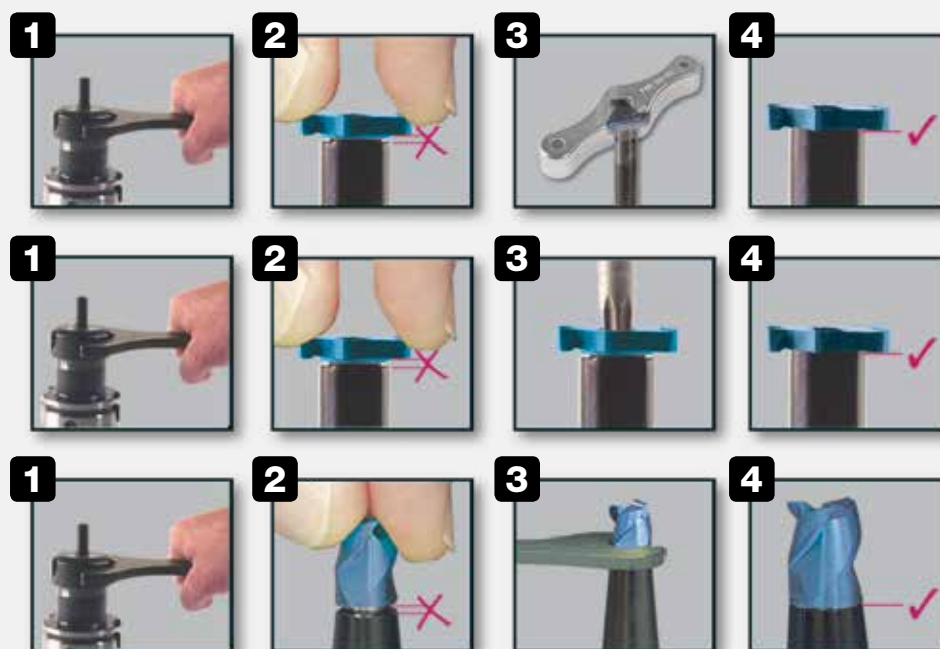
Recommended Cutting Speed Vc(m/min)

ISO	Material Group	Hardness HB	Vc m/min
P	1	125	220-240
	2	190	170-200
	3-6	200	140-160
	7-8	300	110-130
	9-11	200	100-130
M	12-13	240	90-150
	14	180	70-100
K	15	180	70-240
	16	260	110-220
	17	170	130-250
	19	130	130-230
	20	230	100-200
N	21-24	90	600-700
S	33-35	350	10-20
	36-37		30-50
H	38	HRC55	30-40
	39	HRC60	25-30

High feed milling - MXFX Only

ISO	Material Group	Fz (mm/t) vs. Tool Diameter D(mm)							
		Ap	Ae	8	10	12	16	20	25
P	1	0.045xD	0.7xD	0.50	0.60	0.70	0.80	0.95	1.05
	2	0.045xD	0.7xD	0.50	0.60	0.70	0.80	0.95	1.05
	3	0.045xD	0.7xD	0.50	0.60	0.70	0.80	0.95	1.05
	4	0.045xD	0.7xD	0.50	0.60	0.70	0.80	0.95	1.05
	5	0.045xD	0.7xD	0.45	0.55	0.60	0.70	0.80	0.90
	6	0.045xD	0.7xD	0.35	0.45	0.50	0.60	0.70	0.80
	7	0.045xD	0.7xD	0.35	0.45	0.50	0.60	0.70	0.80
	8	0.045xD	0.7xD	0.35	0.40	0.45	0.55	0.65	0.75
	9	0.045xD	0.7xD	0.35	0.40	0.45	0.55	0.65	0.75
	10	0.04xD	0.6xD	0.30	0.35	0.40	0.50	0.6	0.70
	11	0.04xD	0.6xD	0.30	0.35	0.40	0.45	0.55	0.65
M	12-14	0.04xD	0.6xD	0.35	0.40	0.45	0.55	0.65	0.75
K	15-16	Apmax	0.7xD	0.50	0.55	0.65	0.75	0.85	0.95
	17-20	Apmax	0.7xD	0.40	0.50	0.55	0.65	0.75	0.85
H	38.1	0.035xD	0.45xD	0.25	0.30	0.35	0.45	0.50	0.60
	38.2	0.03xD	0.3xD	0.20	0.25	0.35	0.40	0.50	0.55
	39	0.02xD	0.25xD	0.15	0.20	0.20	0.25	0.25	0.30

Clamping Instructions



- Use TaeguTec cutting heads only

- Before mounting, clean the connection area of both the head and the holder
- Do not apply lubricant onto the connection areas
- Use the correct TT designated wrench (sold separately)
- Apply the proper clamping torque listed in this guide; excessive tightening may cause the cutting head to break