

NPN

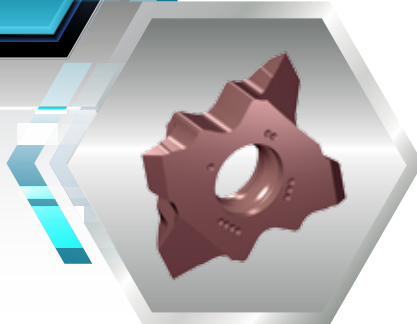
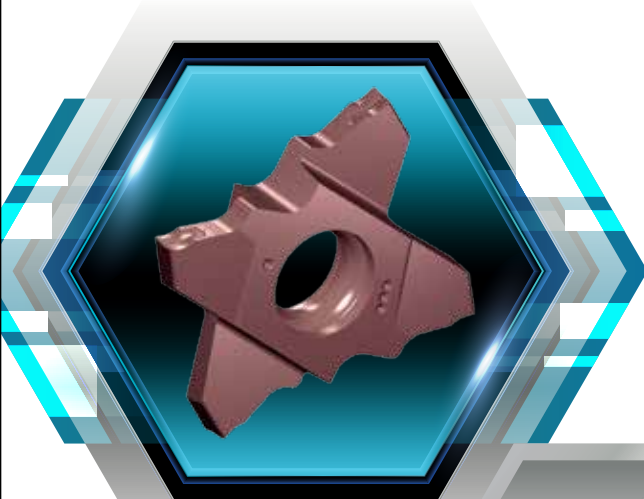
New Product News



QUAD RUSH

PARTING & GROOVING

Small Size QUAD-RUSH Inserts and Holders for Swiss Type Automatic Lathes



KEY POINT

TaeguTec launches QUAD-RUSH small size inserts and holders for Swiss type automatic lathes.

The **QUAD-RUSH** line has been highly acclaimed in the market due to its longer tool life with stable performance from a powerful clamping system. In this regard, TaeguTec has miniaturized the popular **QUAD-RUSH** line for Swiss type automatic lathes.

Available as standard inserts with a grooving width of 0.5 to 3.0 mm and a grooving depth of 2.2 to 5.0 mm, the inserts are suitable for small diameter workpieces. With special edge treatment for sharp cutting edges and the new PVD coated TT4430 grade, tool life has been improved with excellent surface finish, less burrs and built-up-edge.

The stable and strong clamping of the **QUAD-RUSH** line provides better tool life, as well as excellent insert position repeatability. **QUAD-RUSH** also provides the optimal solution for various applications such as grooving, parting, turning, profiling and threading. It is available in a wide range of shank sizes (1010, 1212, 1616, 2020) with short heads, and also provides standard COOL-BURST holders with high-pressure coolant up to 300 bar.

* As part of the new campaign, the design for the new **QUAD-RUSH** line highlights TaeguTec's new direction.

Features

- 4 cutting edge grooving insert for Swiss type automatic lathes
- Variety of applications for grooving, parting, turning, profiling, threading and machining next to the shoulder
- Grooving width 0.5 - 3.0 mm; grooving depth 2.2 - 5.0 mm
- Superior insert position repeatability and longer tool life with strong clamping force
- Available in 1010, 1212, 1616, 2020 shank size holders for Swiss type automatic lathes
- Available as standard high-pressure coolant COOL-BURST holders up to 300 bar
- PVD coated TT4430 grade and special edge treatment for excellent surface finish and tool life



QUAD-RUSH insert size range



TQS/J 20
Max. cutting depth 5.0 mm



TQC/J/S 27
Max. cutting depth 6.4 mm

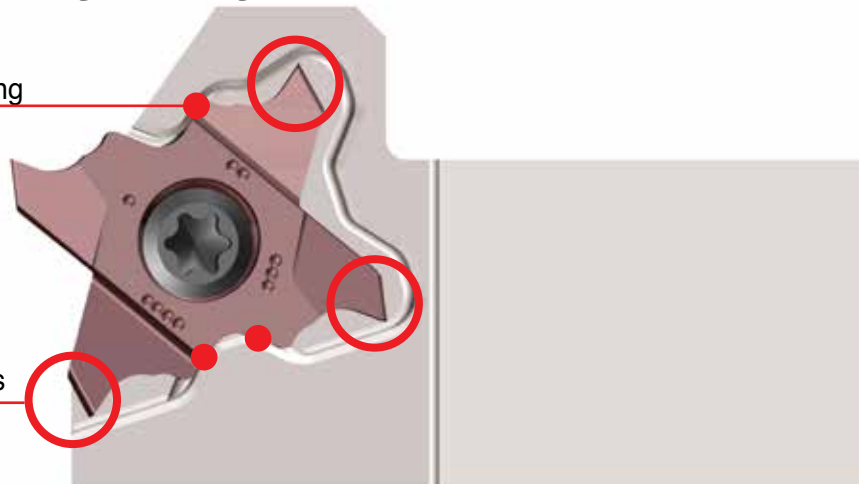


TQC 34
Max. cutting depth 10 mm

4 corner insert for shallow grooving

3-area support for strong clamping

Protection of unused cutting edges



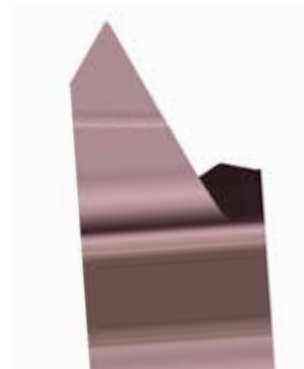
Various applications



Parting and grooving



Profiling

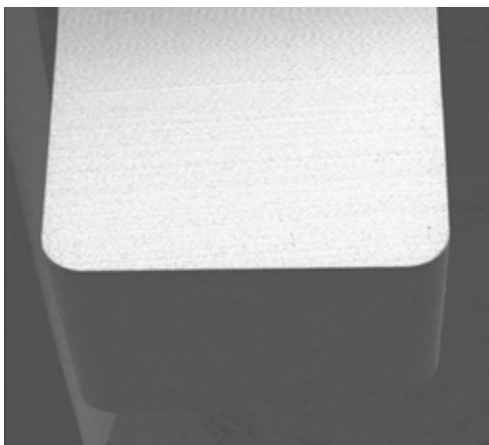


Threading

Machining next to the shoulder



TT4430 new PVD coated grade and edge treatment



TT4430 PVD grade

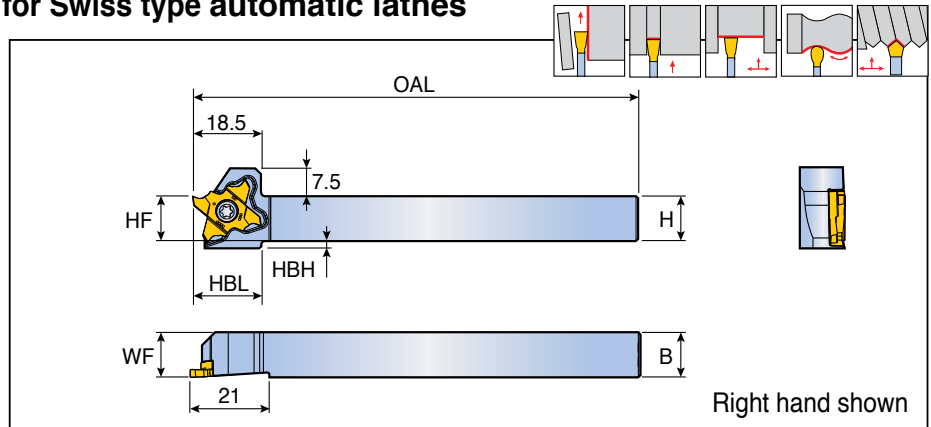
- Ideal combination of a tough submicron substrate and a multi AlTiCrN coated layer for anti-chipping and reliable performance
- General machining of miniature parts for steel, stainless steel and titanium alloy

- Sharp cutting edge without micro chipping
- Improved tool life and reduced burrs
- Good workpiece surface finish



TQHR/L-20

Grooving and turning holders for Swiss type automatic lathes



Designation	Dimension (mm)							Insert
	H	HF	B	WF	OAL	HBL	HBH	
TQHR/L 10-20	10	10	10	10	120	18.5	4	TQS 20 TQJ 20
12-20	12	12	12	12	120	18.5	2	
16-20	16	16	16	16	120	-	-	
20-20	20	20	20	20	120	-	-	
25-20	25	25	25	25.3	135	-	-	

Spare parts

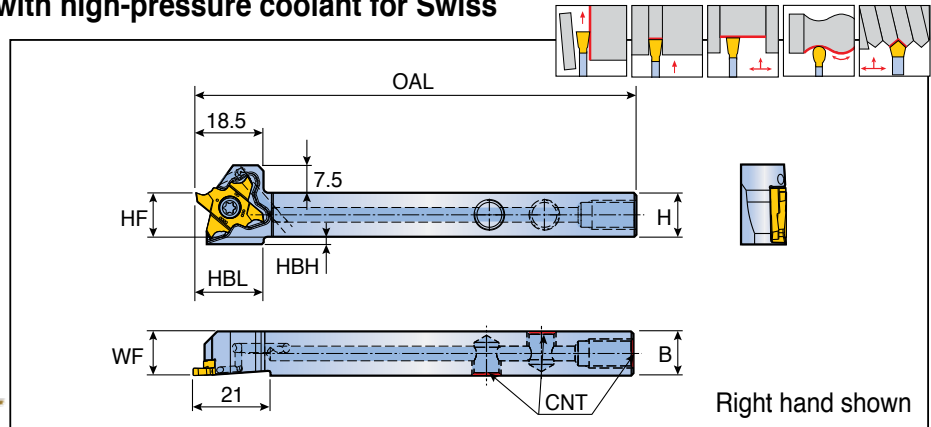
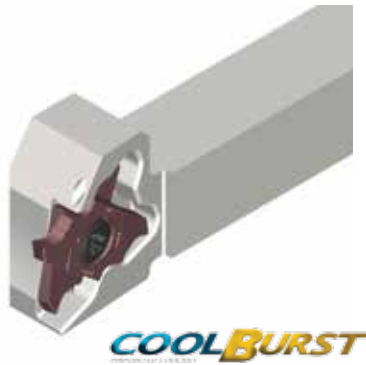
Designation	Screw	Wrench		
	TQHR/L...20	 TS 40A100L ⁽¹⁾ TS 40A100 ⁽²⁾	 T-1508/5	

• (1) For TQHR • (2) For TQHL



TQHR/L-20-TB

Grooving and turning holders with high-pressure coolant for Swiss type automatic lathes



Designation	Dimension (mm)							CNT	Insert
	H	HF	B	WF	OAL	HBL	HBH		
TQHR/L 12-20-TB	12	12	12	12	120	18.5	2	UNF 5/16	TQS 20 TQJ 20
16-20-TB	16	16	16	16	120	-	-	UNF 5/16	
20-20-TB	20	20	20	20	120	-	-	G 1/8	

	70 bar flow rate (ℓ/min)	100 bar flow rate (ℓ/min)	140 bar flow rate (ℓ/min)
TQHR/L- TB	9-11	11-13	12-14

Spare parts

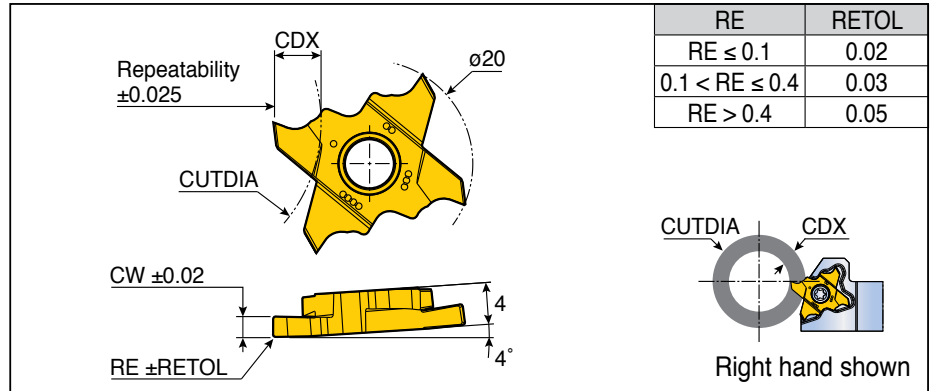
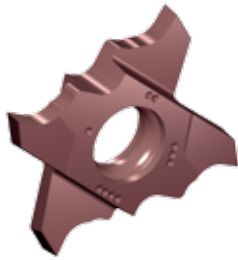
Designation	Screw	Plug	Wrench	
TQHR/L 12/16-20-TB	TS 40A100L (1)	PLG 5/16 UNF	T-1508/5	L-W 5/32
TQHR/L 20-20-TB	TS 40A100 (2)	PLG G1/8-L6.5	T-1508/5	L-W 5

• (1) For TQHR • (2) For TQHL

TQS 20



Parting and grooving precise inserts with ground chip breaker



Designation	Feed (mm/rev)	CW	RE	CDX	CUTDIA						Grade
					CDX ≤ 2.2	2.2 < CDX ≤ 2.7	2.7 < CDX ≤ 3.5	3.5 < CDX ≤ 4.0	4.0 < CDX ≤ 4.5	4.5 < CDX ≤ 5.0	
TQS 20-0.50-0.05-R/L	0.03-0.07	0.50	0.05	2.2	N.L.	-	-	-	-	-	●
20-1.00-0.10-R/L	0.03-0.07	1.00	0.10	2.7	N.L.	N.L.	-	-	-	-	●
20-1.50-0.10-R/L	0.03-0.10	1.50	0.10	5.0	N.L.	N.L.	70	50	30	16	●
20-2.00-0.10-R/L	0.04-0.12	2.00	0.10	5.0	N.L.	N.L.	70	50	30	16	●
20-2.00-1.00-R/L*	0.05-0.13	2.00	1.00	5.0	N.L.	N.L.	70	50	30	16	●
20-2.50-0.10-R/L	0.04-0.15	2.50	0.10	5.0	N.L.	N.L.	70	50	30	16	●
20-3.00-0.10-R/L	0.04-0.16	3.00	0.10	5.0	N.L.	N.L.	70	50	30	16	●
20-3.00-1.50-R/L*	0.04-0.16	3.00	1.50	5.0	N.L.	N.L.	70	50	30	16	●

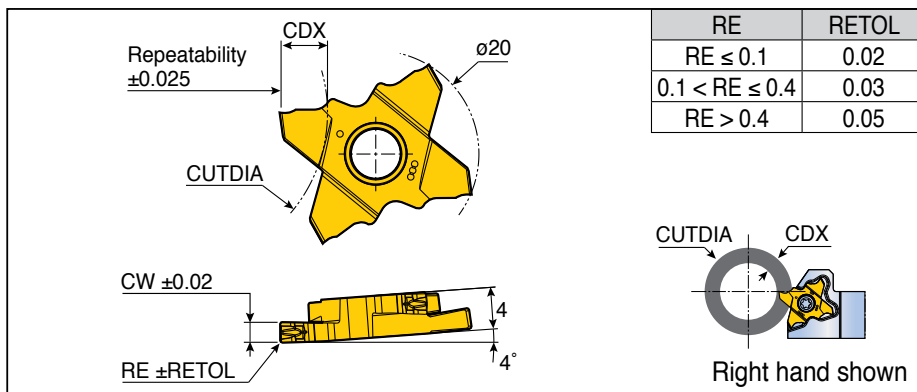
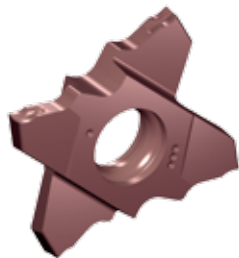
- N.L.: No limit
- *: Full radius insert

- : Standard items



TQJ 20

Parting and grooving precise inserts with J-Type chip breaker



RE	RETOL
RE ≤ 0.1	0.02
0.1 < RE ≤ 0.4	0.03
RE > 0.4	0.05

Designation	Feed (mm/rev)	CW	RE	CDX	CUTDIA					Grade
					CDX ≤ 2.7	CDX ≤ 3.5	CDX ≤ 4.0	CDX ≤ 4.5	CDX ≤ 5.0	
TQJ 20-1.00-0.10-R/L	0.03-0.07	1.00	0.10	2.7	N.L.	-	-	-	-	●
20-1.50-0.20-R/L	0.03-0.08	1.50	0.20	5.0	N.L.	70	50	30	16	●
20-2.00-0.20-R/L	0.04-0.10	2.00	0.20	5.0	N.L.	70	50	30	16	●

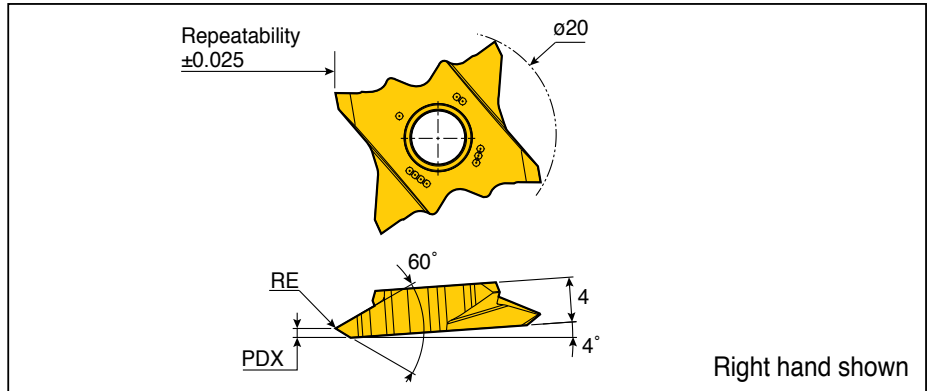
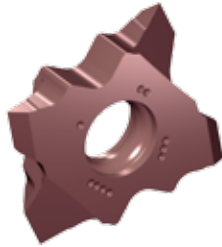
• N.L.: No limit

●: Standard items



TQS 20-MT

Partial profile 60° threading inserts



Right hand shown

Designation	Dimension (mm)						Grade
	TPN	TPX	TPIX	TPIN	RE	PDX	TT4430
TQS 20-MT-0.05-R/L	0.30	1.75	48	14	0.05	0.8	●

- TPN: Thread pitch minimum (mm) • TPX: Thread pitch maximum (mm)
- TPIN: Thread per inch minimum • TPIX: Thread per inch maximum
- : Standard items

KIT COLLECTIONS

These kit products are available in the format listed below.



Cat. No.	Designation	Bill of materials	Qty.
6334826	KISFT-TQS 20-1001-TB12L	TQHL 12-20-TB	1
		TQS 20-1.00-0.10-L TT4430	3
6334827	KISFT-TQS 20-1501-TB12L	TQHL 12-20-TB	1
		TQS 20-1.50-0.10-L TT4430	3
6334828	KISFT-TQS 20-2001-TB12L	TQHL 12-20-TB	1
		TQS 20-2.00-0.10-L TT4430	3
6334829	KISFT-TQS 20-1001-TB16L	TQHL 16-20-TB	1
		TQS 20-1.00-0.10-L TT4430	3
6334830	KISFT-TQS 20-1501-TB16L	TQHL 16-20-TB	1
		TQS 20-1.50-0.10-L TT4430	3
6334831	KISFT-TQS 20-2001-TB16L	TQHL 16-20-TB	1
		TQS 20-2.00-0.10-L TT4430	3
6334832	KISFT-TQS 20-1001-TB12R	TQHR 12-20-TB	1
		TQS 20-1.00-0.10-R TT4430	3
6334833	KISFT-TQS 20-1501-TB12R	TQHR 12-20-TB	1
		TQS 20-1.50-0.10-R TT4430	3
6334834	KISFT-TQS 20-2001-TB12R	TQHR 12-20-TB	1
		TQS 20-2.00-0.10-R TT4430	3
6334835	KISFT-TQS 20-1001-TB16R	TQHR 16-20-TB	1
		TQS 20-1.00-0.10-R TT4430	3
6334836	KISFT-TQS 20-1501-TB16R	TQHR 16-20-TB	1
		TQS 20-1.50-0.10-R TT4430	3
6334837	KISFT-TQS 20-2001-TB16R	TQHR 16-20-TB	1
		TQS 20-2.00-0.10-R TT4430	3



Cat. No.	Designation	Bill of materials	Qty.
6337891	KISFS-TQS 20-1001-TB12L	TQHL 12-20-TB	1
		TQS 20-1.00-0.10-L TT4430	20
6337892	KISFS-TQS 20-1501-TB12L	TQHL 12-20-TB	1
		TQS 20-1.50-0.10-L TT4430	20
6337893	KISFS-TQS 20-2001-TB12L	TQHL 12-20-TB	1
		TQS 20-2.00-0.10-L TT4430	20
6337894	KISFS-TQS 20-1001-TB16L	TQHL 16-20-TB	1
		TQS 20-1.00-0.10-L TT4430	20
6337895	KISFS-TQS 20-1501-TB16L	TQHL 16-20-TB	1
		TQS 20-1.50-0.10-L TT4430	20
6337896	KISFS-TQS 20-2001-TB16L	TQHL 16-20-TB	1
		TQS 20-2.00-0.10-L TT4430	20
6337897	KISFS-TQS 20-1001-TB12R	TQHR 12-20-TB	1
		TQS 20-1.00-0.10-R TT4430	20
6337898	KISFS-TQS 20-1501-TB12R	TQHR 12-20-TB	1
		TQS 20-1.50-0.10-R TT4430	20
6337899	KISFS-TQS 20-2001-TB12R	TQHR 12-20-TB	1
		TQS 20-2.00-0.10-R TT4430	20
6337900	KISFS-TQS 20-1001-TB16R	TQHR 16-20-TB	1
		TQS 20-1.00-0.10-R TT4430	20
6337901	KISFS-TQS 20-1501-TB16R	TQHR 16-20-TB	1
		TQS 20-1.50-0.10-R TT4430	20
6337906	KISFS-TQS 20-2001-TB16R	TQHR 16-20-TB	1
		TQS 20-2.00-0.10-R TT4430	20



Cat. No.	Designation	Bill of materials	Qty.
6338456	KISFF-A-TQS20-1001LTT4430	TQS 20-1.00-0.10-L TT4430	50
6338457	KISFF-B-TQS20-1001LTT4430		100
6338458	KISFF-A-TQS20-1501LTT4430	TQS 20-1.50-0.10-L TT4430	50
6338459	KISFF-B-TQS20-1501LTT4430		100
6338460	KISFF-A-TQS20-2001LTT4430	TQS 20-2.00-0.10-L TT4430	50
6338461	KISFF-B-TQS20-2001LTT4430		100
6338462	KISFF-A-TQS20-1001RTT4430	TQS 20-1.00-0.10-R TT4430	50
6338463	KISFF-B-TQS20-1001RTT4430		100
6338464	KISFF-A-TQS20-1501RTT4430	TQS 20-1.50-0.10-R TT4430	50
6338465	KISFF-B-TQS20-1501RTT4430		100
6338466	KISFF-A-TQS20-2001RTT4430	TQS 20-2.00-0.10-R TT4430	50
6338467	KISFF-B-TQS20-2001RTT4430		100