

# NPN

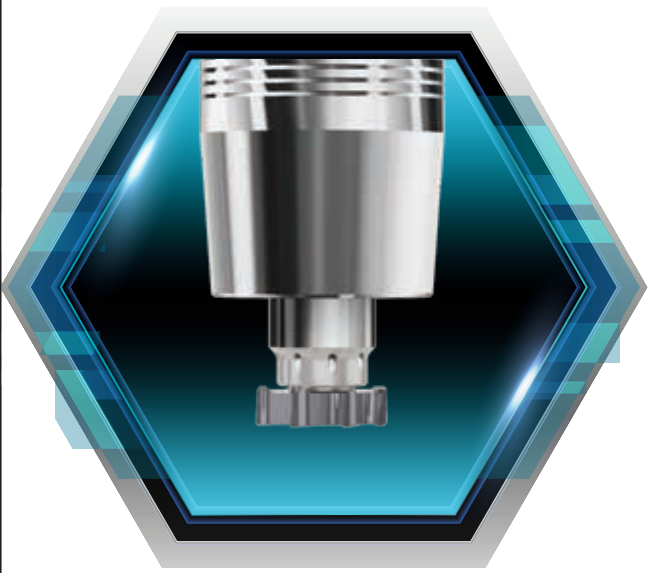
New Product News



## MAXISLOT

INDEXABLE SOLID HEADS

**Quick Changeable Solid Carbide Head  
for Multiple Machining**



## KEY POINT

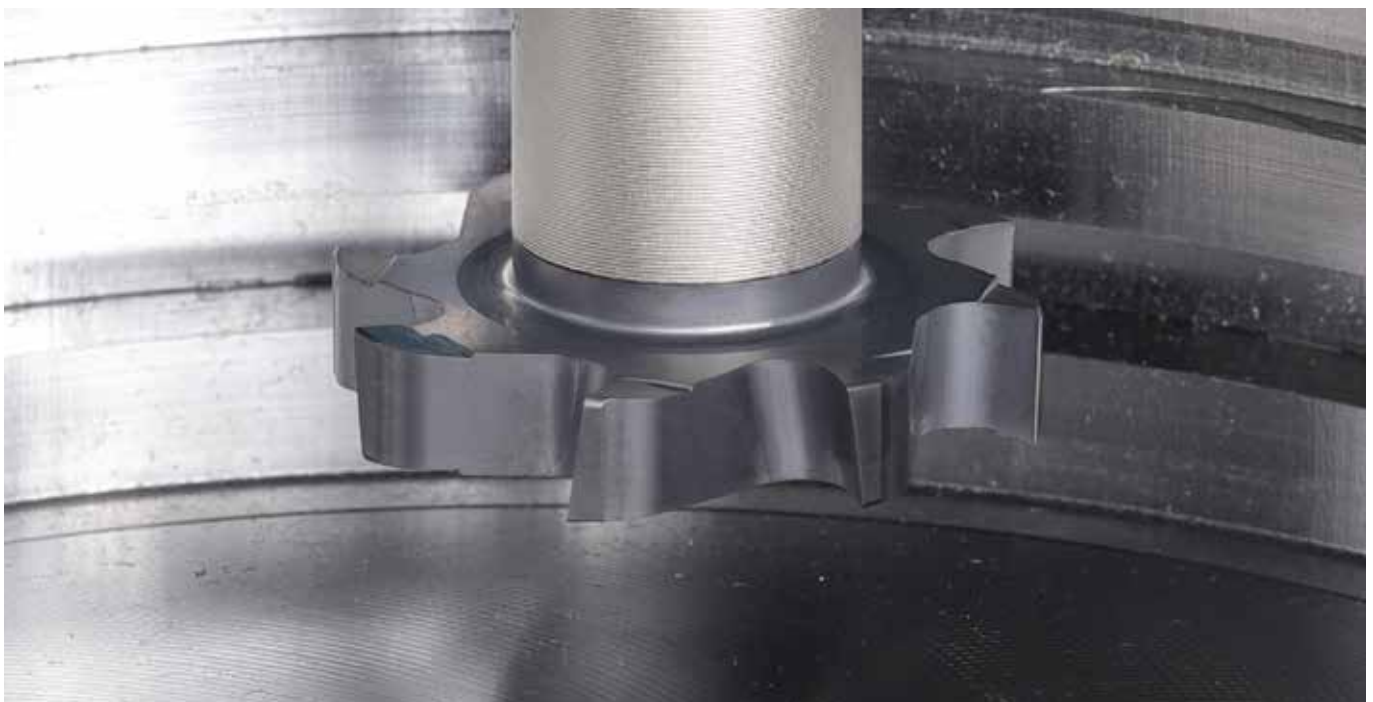
**TaeguTec has introduced a multi-purpose, head-exchangeable line for various applications.**

**MAXI-SLOT** is an optimized slotting line dedicated to the machining of various machinery components and other slotting applications in mini-sized operations that out perform equivalent insert types.

TaeguTec's unique yet simple design allows for precise and rigid mounting of a head exchangeable slotting cutter with the use of only one clamping screw, thereby eliminating the need for additional setup time. Furthermore, it is a more productive solution compared to the slotting insert type, due to the cutter's additional cutting edges being applied to the same diameter.

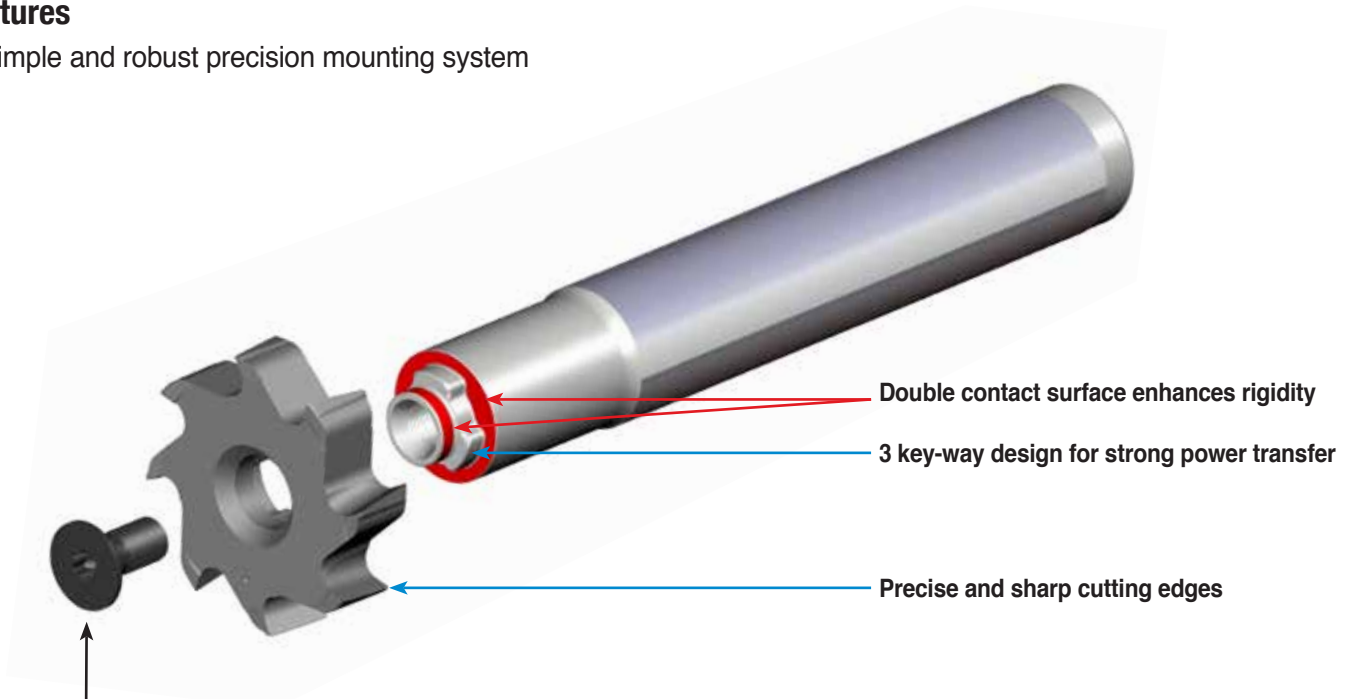
In addition to slotting, the head-exchangeable head can be used in other machining applications including facing and threading.

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



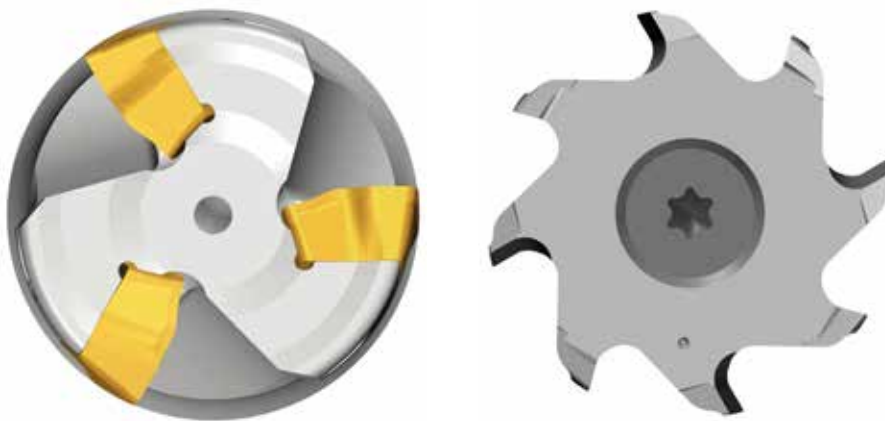
## Features

- Simple and robust precision mounting system



Easy fastening one screw set-up  
- No setup time required

- More cutting edges maximize productivity

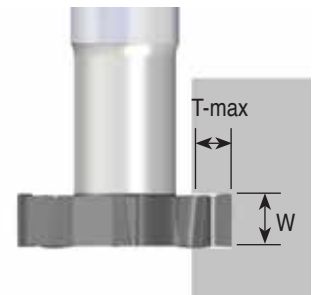


- Suited for a wide variety of applications :  
- Slotting, Facing and Threading

■ Wider usage due to several diameters and thicknesses

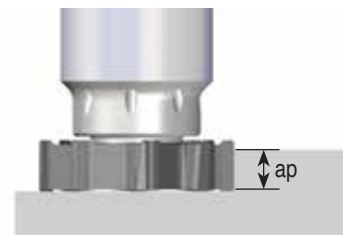
Slotting (TR-S)

Tool diameter (mm)	W (slot width) (mm)	T-max (mm)
24.7	3-8	5.5
31.7	3-8	8
39.7	4-10	11



Facing (TR-F)

Tool diameter (mm)	Max. ap (mm)	Number of teeth
24.25	8	6
31.25	8	8
39.25	10	10



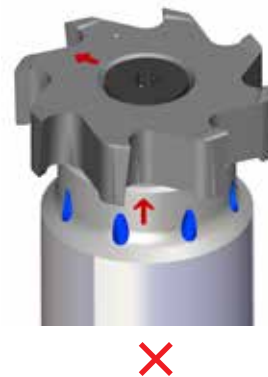
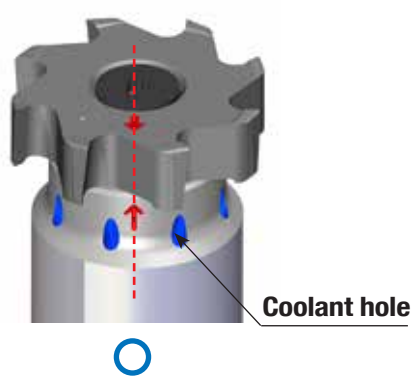
Threading (TR-T)

Tool diameter (mm)	Screw profile	Number of teeth
24.7	M60 / W55	6
31.7	M60 / W55	8
39.7	M60 / W55	10



**Attention**

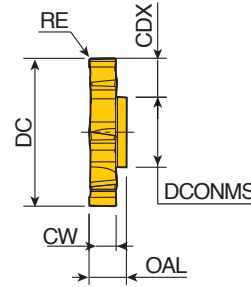
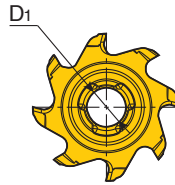
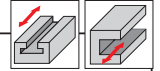
When internal coolant is applied by combining the TR-F head with the TR-F-C holder, the arrows shown on the head and holder must be positioned opposite to each other (as shown below) in order to ensure a smooth coolant flow to the cutting edge.



## TR-S



Interchangeable solid carbide slot milling heads



Designation	Feed (mm/tooth)	Dimension (mm)								Grade TT5525
		DC	CW	CDX	NOF	RE	D1	DCONMS	OAL	
<b>TR13-S-24.7-3.0R0.4</b>	0.02-0.15	24.7	3	5.5	6	0.4	7.5	13	8	●
<b>24.7-4.0R0.4</b>	0.02-0.15	24.7	4	5.5	6	0.4	7.5	13	8	●
<b>24.7-5.0R0.4</b>	0.02-0.15	24.7	5	5.5	6	0.4	7.5	13	8	●
<b>24.7-6.0R0.4</b>	0.02-0.15	24.7	6	5.5	6	0.4	7.5	13	8	●
<b>24.7-7.0R0.4</b>	0.02-0.15	24.7	7	5.5	6	0.4	7.5	13	8	●
<b>24.7-8.0R0.4</b>	0.02-0.15	24.7	8	5.5	6	0.4	7.5	13	8	●
<b>TR15-S-31.7-3.0R0.4</b>	0.022-0.18	31.7	3	8	8	0.4	8.4	15	8	●
<b>31.7-4.0R0.4</b>	0.022-0.18	31.7	4	8	8	0.4	8.4	15	8	●
<b>31.7-5.0R0.4</b>	0.022-0.18	31.7	5	8	8	0.4	8.4	15	8	●
<b>31.7-6.0R0.4</b>	0.022-0.18	31.7	6	8	8	0.4	8.4	15	8	●
<b>31.7-7.0R0.4</b>	0.022-0.18	31.7	7	8	8	0.4	8.4	15	8	●
<b>31.7-8.0R0.4</b>	0.022-0.18	31.7	8	8	8	0.4	8.4	15	8	●
<b>TR17-S-39.7-4.0R0.4</b>	0.025-0.20	39.7	4	11	10	0.4	9.8	17	10	●
<b>39.7-5.0R0.4</b>	0.025-0.20	39.7	5	11	10	0.4	9.8	17	10	●
<b>39.7-6.0R0.4</b>	0.025-0.20	39.7	6	11	10	0.4	9.8	17	10	●
<b>39.7-7.0R0.4</b>	0.025-0.20	39.7	7	11	10	0.4	9.8	17	10	●
<b>39.7-8.0R0.4</b>	0.025-0.20	39.7	8	11	10	0.4	9.8	17	10	●
<b>39.7-9.0R0.4</b>	0.025-0.20	39.7	9	11	10	0.4	9.8	17	10	●
<b>39.7-10.0R0.4</b>	0.025-0.20	39.7	10	11	10	0.4	9.8	17	10	●

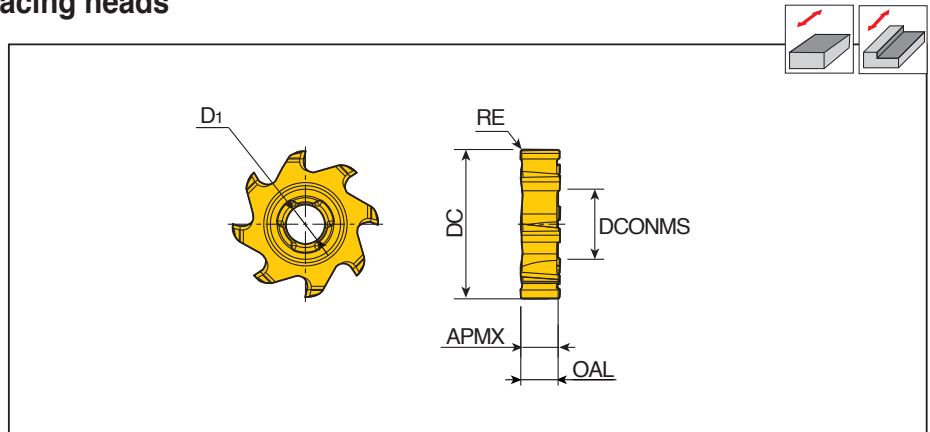
● NOF: Number of flutes

●: Standard items

## TR-F



Interchangeable solid carbide facing heads



Designation	Feed (mm/tooth)	Dimension (mm)							Grade
		DC	APMX	NOF	RE	D1	DCONMS	OAL	
<b>TR13-F-25-8.0-R0.4</b>	0.04-0.15	24.25	8	6	0.4	7.5	13	8	●
<b>15-F-32-8.0-R0.4</b>	0.04-0.15	31.25	8	8	0.4	8.4	15	8	●
<b>17-F-40-10.0-R0.4</b>	0.04-0.15	39.25	10	10	0.4	9.8	17	10	●

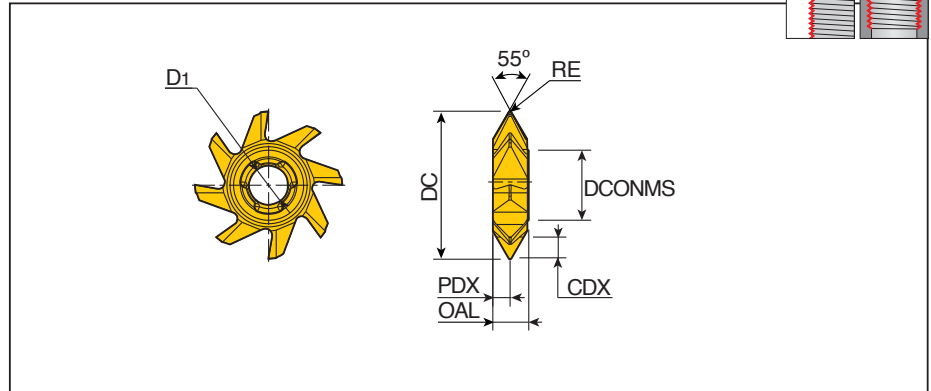
• NOF: Number of flutes

●: Standard items

## TR-T-W55



Interchangeable solid carbide threading heads – 55° partial profile



Designation	TPI	Dimension (mm)										Grade
		DC	DMIN	PDX	RE	D <sub>1</sub>	CDX	OAL	ZEFP	DCONMS	TT5525	
<b>TR13-T-24.7-W55-3T</b>	5-3	24.7	36	2.2	0.5	7.5	3.5	7.7	6	13	●	
<b>15-T-31.7-W55-4T</b>	6-4	31.7	46	3.7	0.5	8.4	4.7	7.7	8	15	●	
<b>17-T-39.7-W55-3T</b>	4-3	39.7	57	4.5	0.8	9.8	6.2	9.5	10	17	●	

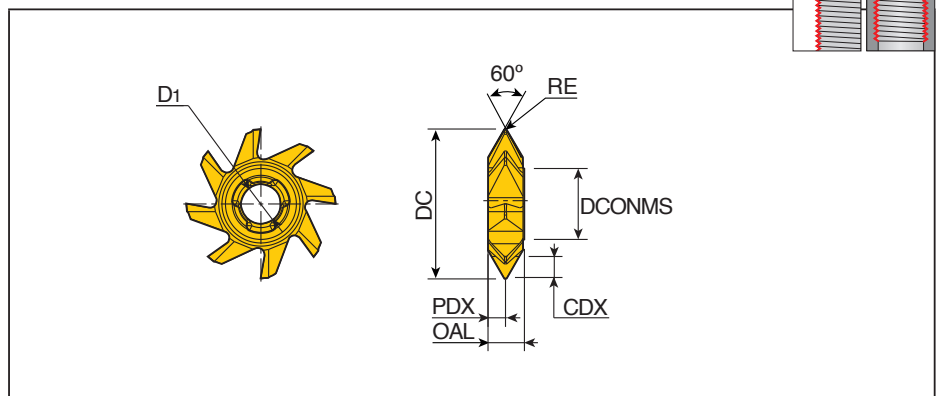
- TPI: Threads per inch
- ZEFP: Peripheral effective cutting edge count

●: Standard items

## TR-T-M60



Interchangeable solid carbide threading heads – 60° partial profile



Designation	TPI		Dimension (mm)										Grade
	TP(mm)	TPI	DC	DMIN	PDX	RE	D <sub>1</sub>	CDX	OAL	ZEFP	DCONMS	TT5525	
<b>TR13-T-24.7-M60-5P</b>	3-5	5-3	24.7	36	2.2	0.2	7.5	3.5	7.7	6	13	●	
<b>15-T-31.7-M60-6P</b>	4-6	6-4	31.7	46	3.7	0.3	8.4	4.7	7.7	8	15	●	
<b>17-T-39.7-M60-8P</b>	6-8	4-3	39.7	57	4.5	0.4	9.8	6.2	9.5	10	17	●	

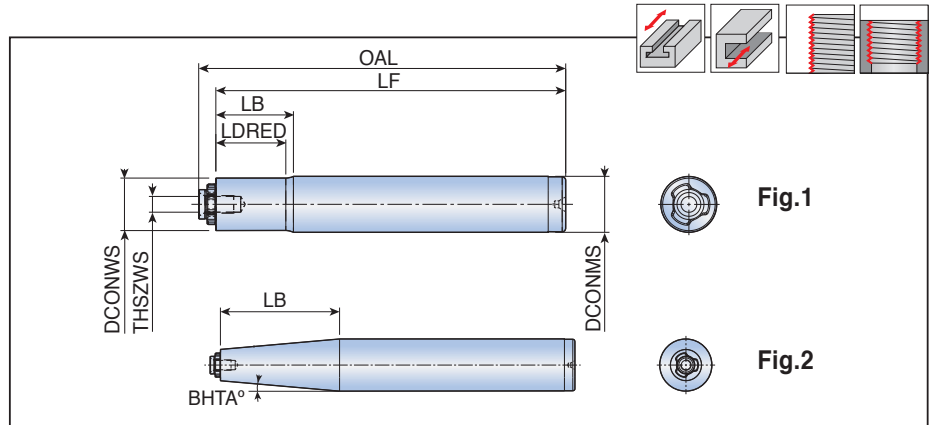
- TP: Threads pitch, TPI: Threads per inch
- ZEFP: Peripheral effective cutting edge count

●: Standard items

## TR



### Slotting & threading holders



Designation	Dimension (mm)								Coolant	Fig.	Insert
	DCONMS	DCONWS	LB	LF	OAL	THSZWS	LDRED	BHTA°			
<b>TR13-16-L100</b>	16	13	16.6	100	104.35	M4x0.5	13.0	-	x	1	TR-S.. TR-T..
<b>15-16-L100</b>	16	15	18.2	100	104.90	M5x0.5	16.0	-	x	1	
<b>15-16-L130</b>	16	15	18.2	130	134.90	M5x0.5	16.0	-	x	1	
<b>17-20-L140</b>	20	17	23.8	140	146.00	M6x0.5	20.2	-	x	1	
<b>15-25-TC170</b>	25	15	57.2	170	174.90	M5x0.5	-	5	x	2	

### Spare parts

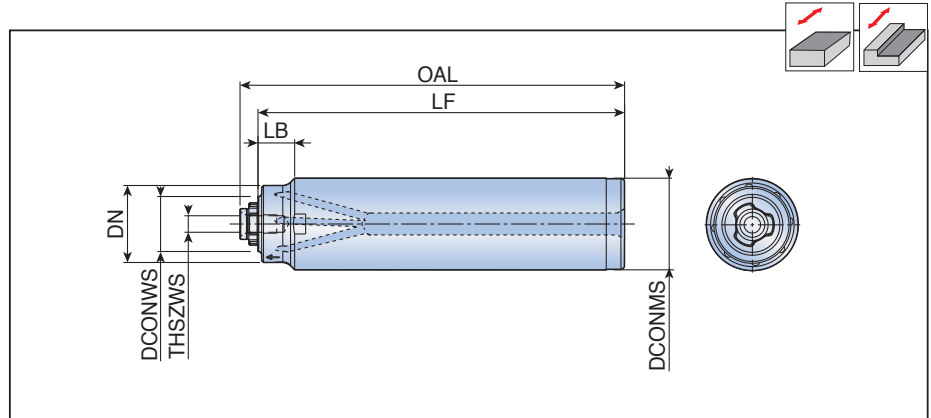
Designation	Screw	Wrench	Wrench handle		
<b>TR13</b>	TS 40T098/HG-P	BLD IP15/S7	SW6-T		
<b>TR15</b>	TS 50T110/HG-P	BLD IP20/S7	SW6-T		
<b>TR17</b>	TS 60T130/HG-P	BLD IP20/S7	SW6-T		





## TR-F-C

### Facing holders



Designation	Dimension (mm)							Coolant	Insert
	DCONMS	DCONWS	LB	LF	OAL	THSZWS	DN		
<b>TR13-20-L100-F-C</b>	20	13	10	100	104.35	M4x0.5	16	●	TR-F....
<b>13-25-L100-F-C</b>	25	13	12.5	100	104.35	M4x0.5	16	●	
<b>15-25-L100-F-C</b>	25	15	10	100	104.90	M5x0.5	21	●	
<b>15-32-L110-F-C</b>	32	15	13.5	110	114.90	M5x0.5	21	●	
<b>17-32-L140-F-C</b>	32	17	10	140	146.00	M6x0.5	28	●	
<b>17-42-L140-F-C</b>	42	17	15	140	146.00	M6x0.5	28	●	

### Spare parts

Designation	Screw	Wrench	Wrench handle		
<b>TR13</b>	TS 40T098/HG-P	BLD IP15/S7	SW6-T		
<b>TR15</b>	TS 50T110/HG-P	BLD IP20/S7	SW6-T		
<b>TR17</b>	TS 60T130/HG-P	BLD IP20/S7	SW6-T		

## Recommended Cutting Conditions

ISO	Material			Vc(m/min)	f (mm/tooth)		
		AISI/SAE/ASTM	HB		TR13	TR15	TR17
<b>P</b>	Non-alloy steel	1020	130-180	120-200	0.04-0.12	0.05-0.15	0.06-0.15
	Low alloy steel	4030	260-300	200-300	0.04-0.12	0.05-0.15	0.06-0.15
	Low alloy steel	3135	HRC 35-40	80-120	0.02-0.06	0.03-0.12	0.04-0.12
	High alloy steel	H13	200-220	100-150	0.03-0.07	0.04-0.12	0.04-0.12
<b>M</b>	Martensitic stainless steel	420	200	100-150	0.02-0.06	0.04-0.12	0.04-0.12
	Austenitic stainless steel	304L	200	80-120	0.02-0.06	0.03-0.10	0.03-0.12
<b>K</b>	Gray cast iron	Class 40	250	150-200	0.04-0.12	0.05-0.20	0.05-0.20
	Malleable cast iron	Class 65 45 12	200	130-180	0.04-0.10	0.05-0.18	0.05-0.18
<b>S</b>	High temp. alloys	Inconel 718	HRC 36-40	20-30	0.015-0.10	0.02-0.12	0.02-0.12
		AMS R56400	HRC40-45	30-40	0.015-0.06	0.02-0.12	0.02-0.12

■ Steel   
 ■ Stainless steel   
 ■ Cast iron   
 ■ Nonferrous   
 ■ High temp. alloys   
 ■ Hardened steel