

# NPN

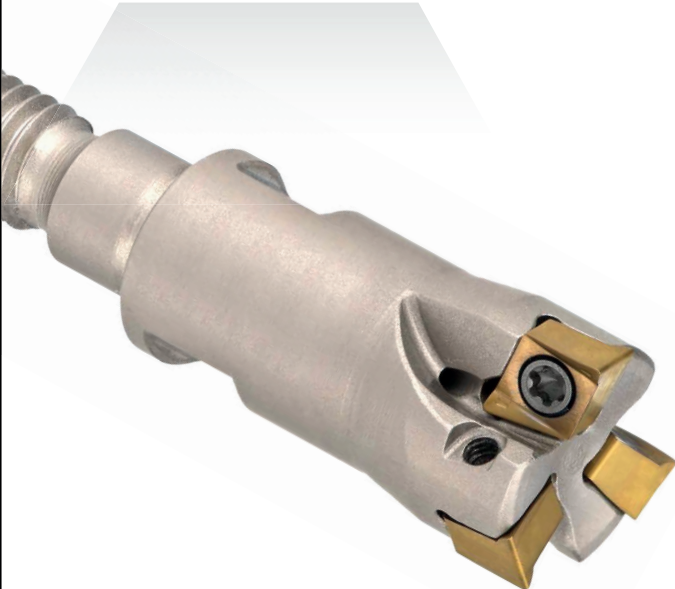
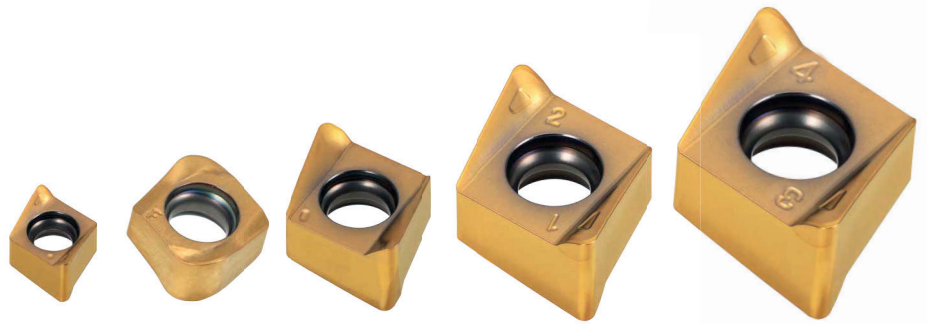
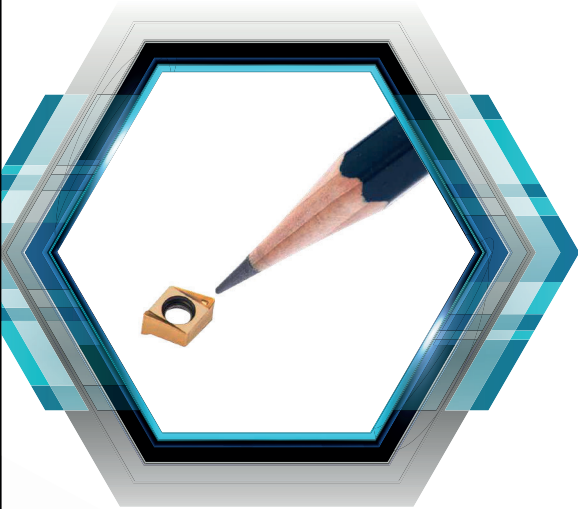
New Product News



## CHASE4MILL

90° MILLING

90° Shoulder Mill 4 Cutting Edge Insert with High Ramping Capability



## KEY POINT

**TaeguTec introduces a new and wide line of inserts and cutters, the CHASE-4-MILL 4NK(H)T line.**

Due to the high acclaim of the current 4NKT 06 line of milling products, TaeguTec has introduced the **CHASE-4-MILL 4NK(H)T 04, 09, 11 and 14** line of inserts and cutters.

The 4NK(H)T 04, 09, 11 and 14 inserts and cutters have the same features as the 4NKT 06 line-up but in a wider range of sizes to cover various applications.

These inserts are designed in several types; **M** for use in general purpose conditions, **ML** for low power machining in unstable setups and long overhangs. **HF** for high feed rate operations, **PNR-M** which has a wiper cutting edge for optimal surface roughness, and the new line also includes an **AL** type for aluminum machining.

The **CHASE-4-MILL's** 4NK(H)T 04, 06, 09, 11 and 14 line covers a wide range of applications and machining conditions, making it not only suitable for general-purpose machining but also the mold and die, automotive and miniature industries' requirements such as facing, shouldering, slotting to ramping.

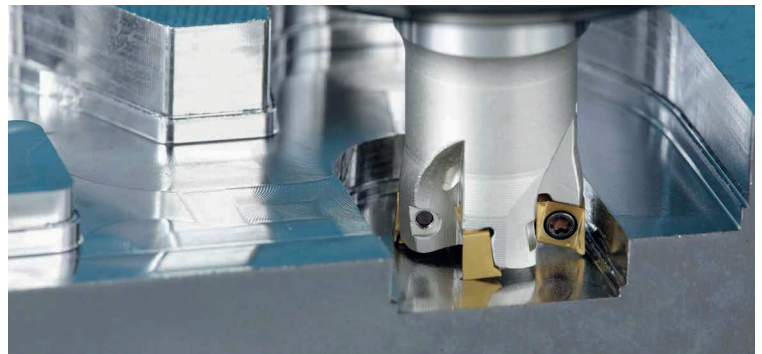
\* As part of the new campaign, the design for the new **CHASE-4-MILL** line highlights TaeguTec's new direction.

\* The new **CHASE-4-MILL** logo will be applied to the 4NK(H)T 06 inserts and cutters as well.

For further technical inquiries, please contact your product manager.

### Features

- True 90° shoulder milling capability
- High axial and radial positive geometry
- High ramp down angle
- High productivity due to fine pitch cutters

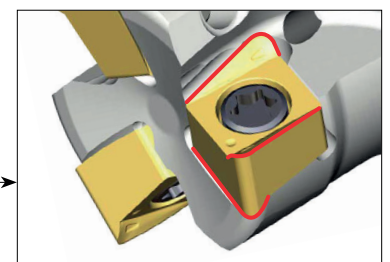


### Cutters

- Internal coolant system
- Wide bottom pocket for improved machining stability and cutter durability
- Strong screw allows for stable clamping

### Inserts

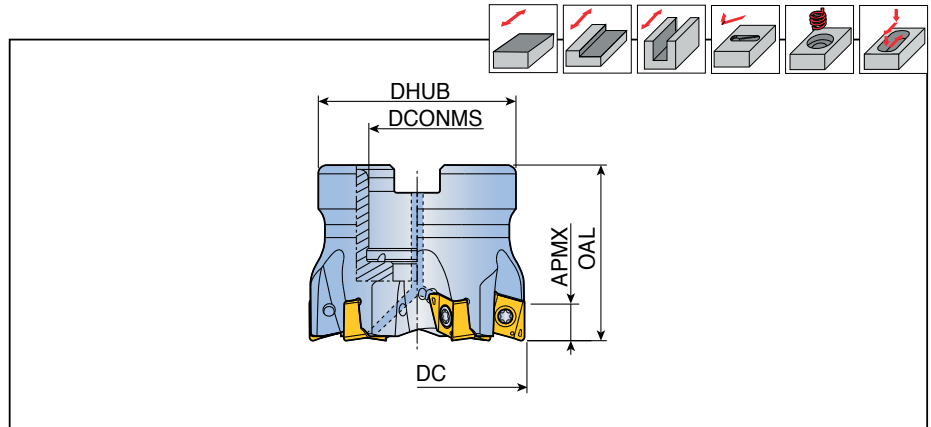
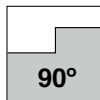
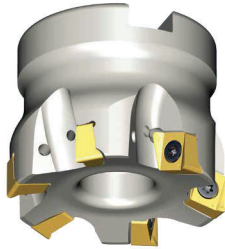
- Double-sided 4 corner insert
- High positive geometry for low cutting force
- Thick and strong insert
- Strong cutting edge due to crossed edges between the top and the bottom
- High feed rate HF means better productivity



## 4N TF90-09



Face mills



Designation		Dimension (mm)					Coolant	Arbor type	Kg	Mounting bolt	Insert
		DC	DCONMS	DHUB	OAL	APMX					
<b>4N TF90-540-16R-09</b>	5	40	16	38	40	8.0	•	A	0.3	SH M8x25	4NK(H)T 0904...
<b>650-22R-09</b>	6	50	22	45	40	8.0	•	A	0.3	LH M10x25	
<b>763-22R-09</b>	7	63	22	47	40	8.0	•	A	0.5	LH M10x25	
<b>980-27R-09</b>	9	80	27	58	50	8.0	•	A	1.1	SH M12x35	

• Cutter body for '4NKT 090432R-HF' insert should be modified with body corner radius 3.2 mm

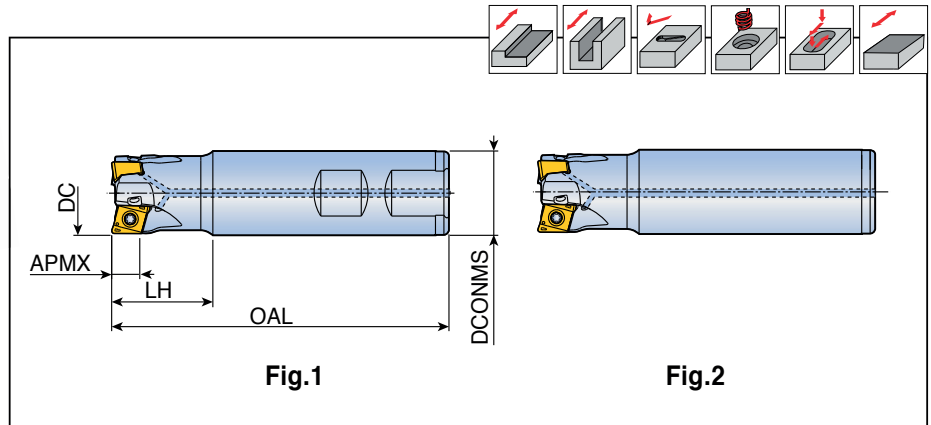
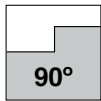
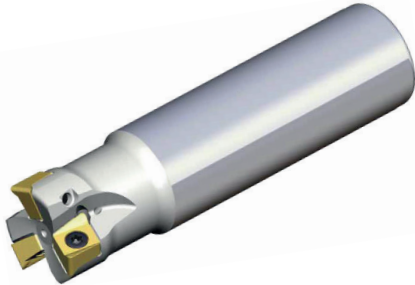
### Spare parts

Designation	Screw	Wrench	Wrench handle		
<b>4N TF90-09</b>	TS 35A088I/HG	TBLD T10P-W6	THND 6W		



## 4N TE90-09

End mills



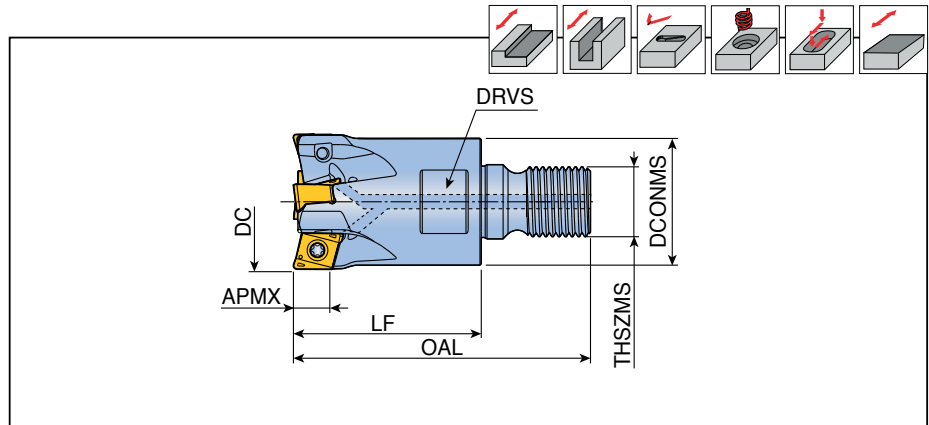
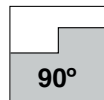
Designation	Symmetry	Dimension (mm)					Coolant	Fig.	Insert
		DC	DCONMS	OAL	LH	APMX			
<b>4N TE90- 220-W20-09</b>	2	20	20	100	30	8.0	●	1	4NK(H)T 0904...
<b>220-20-09-L170</b>	2	20	20	170	30	8.0	●	2	
<b>225-W25-09</b>	2	25	25	100	30	8.0	●	1	
<b>225-25-09-L200</b>	2	25	25	200	40	8.0	●	2	
<b>325-W25-09</b>	3	25	25	100	30	8.0	●	1	
<b>325-25-09-L210</b>	3	25	25	210	30	8.0	●	2	
<b>332-W32-09</b>	3	32	32	110	40	8.0	●	1	
<b>332-32-09-L250</b>	3	32	32	250	40	8.0	●	2	
<b>432-W25-09</b>	4	32	25	130	35	8.0	●	1	
<b>432-25-09-L200</b>	4	32	25	200	40	8.0	●	2	
<b>432-W32-09</b>	4	32	32	110	40	8.0	●	1	
<b>440-W32-09</b>	4	40	32	115	40	8.0	●	1	
<b>440-32-09-L250</b>	4	40	32	250	40	8.0	●	2	
<b>540-W32-09</b>	5	40	32	115	40	8.0	●	1	

• Cutter body for '4NKT 090432R-HF' insert should be modified with body corner radius 3.2 mm



## 4N TE90-M-09

Modular heads for T-FLEXTEC



Designation		Dimension (mm)							Coolant	Insert
		DC	DCONMS	LF	OAL	THSZMS	APMX	DRVS		
<b>4N TE90- 220-M10-09</b>	2	20	18	30	50	M10	8.0	15	●	4NK(H)T 0904...
<b>325-M12-09</b>	3	25	21	35	57	M12	8.0	17	●	
<b>432-M16-09</b>	4	32	29	43	68	M16	8.0	25	●	
<b>540-M16-09</b>	5	40	29	43	68	M16	8.0	25	●	

- Cutter body for '4NKT 090432R-HF' insert should be modified with body corner radius 3.2 mm
- Matched with T-FLEXTEC holder

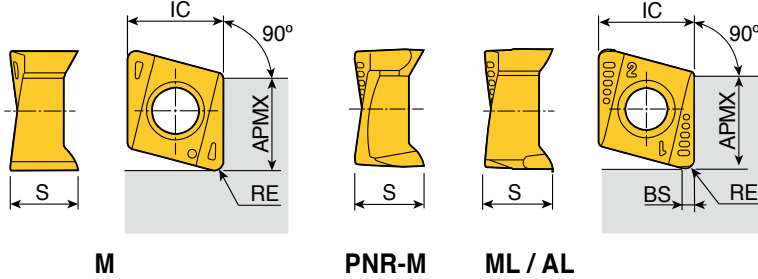
### Spare parts

Designation	Screw	Wrench	Wrench handle		
<b>4N TE90-09</b>	TS 35A088I/HG	TBLD T10P-W6	THND 6W		

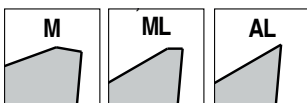
## 4NK(H)T



### Inserts



Size	Dimension (mm)				
	IC	S	APMX	BS	RE
<b>04</b>	4.0	3.1	3.5	-	0.2-0.8
<b>09</b>	8.6	5.7-6.3	8.0	0.8-1.2	0.4-1.6
<b>11</b>	10.7	8.1	10.5	1.0	0.8
<b>14</b>	14.0	9.2-9.4	13.5-13.8	1.25	0.8



Insert	Designation	Recommended machining conditions		Coated							Uncoated	
		ap (mm)	Feed (mm/tooth)	TT9080	TT8080	TT8525	TT7515	TT7080	TT6080	TT2510	K10	
	<b>4NKT 040202R-M</b>	0.5-3.0	0.08-0.04	●	●							
	<b>040204R-M</b>	1.0-3.0	0.12-0.06	●	●				●			
	<b>040208R-M</b>	1.0-3.0	0.12-0.06	●	●							
	<b>090408R-M</b>	2.5-7.0	0.15-0.07	●	●		●		●	●		
	<b>090416R-M</b>	2.5-7.0	0.15-0.07	●	●				●			
	<b>110608R-M</b>	3.5-10.0	0.18-0.09	●	●				●			
	<b>140708R-M</b>	4.0-12.0	0.18-0.09	●	●	●		●	●			
	<b>4NKT 110608 PNR-M</b>	3.5-10.0	0.18-0.09	●	●	●						
	<b>140708 PNR-M</b>	4.0-12.0	0.18-0.09	●	●	●						
	<b>4NHT 090404R-ML</b>	2.5-7.0	0.10-0.04	●								
	<b>090408R-ML</b>	2.5-7.0	0.10-0.04	●	●							
	<b>4NHT 090404R-AL</b>	2.5-7.0	0.50-0.10									●
	<b>090408R-AL</b>	2.5-7.0	0.50-0.10									●

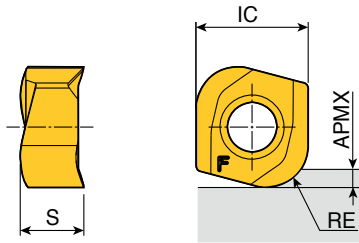
●: Standard items



## 4NKT-HF



### High feed inserts



Size	Dimension (mm)				
	IC	S	APMX	RE	
<b>04-HF</b>	4.0	2.65	0.5	1.2	
<b>06-HF</b>	6.6	3.85	1.0	2.0	
<b>09-HF</b>	8.6	4.76	1.5	3.2	
<b>11-HF</b>	10.7	6.56	2.0	4.0	
<b>14-HF</b>	14.0	7.34	3.0	5.0	

Insert	Designation	Recommended machining conditions		Coated							Uncoated		
		ap (mm)	Feed (mm/tooth)	TT9080	TT8080	TT8525	TT7515	TT7080	TT6080	TT2510			K10
	<b>4NKT 040212R-HF</b>	0.2-0.4	0.60-0.10	●						●			
	<b>060320R-HF</b>	0.2-0.6	0.80-0.20	●	●					●			
	<b>090432R-HF</b>	0.3-0.8	1.00-0.20	●									
	<b>110640R-HF</b>	0.3-1.2	1.20-0.30	●									
	<b>140750R-HF</b>	0.3-1.5	1.50-0.30	●									

●: Standard items