

# NPN

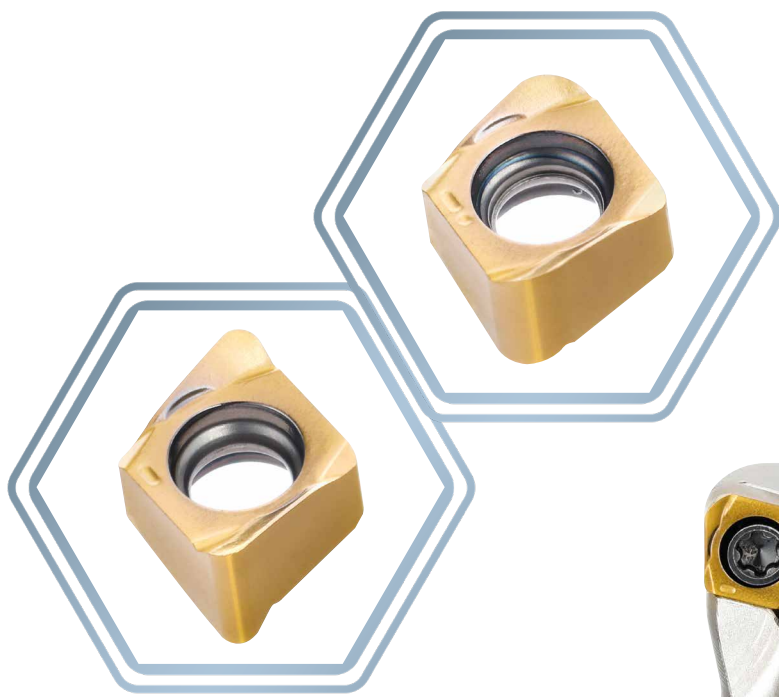
New Product News



## CHASE4MILL

90° MILLING

Shoulder Finishing  
4NHT 04-F Insert



## KEY POINT

**CHASE-4-MILL now includes the 4NHT 04-F type inserts for improved shoulder machining surface finish.**

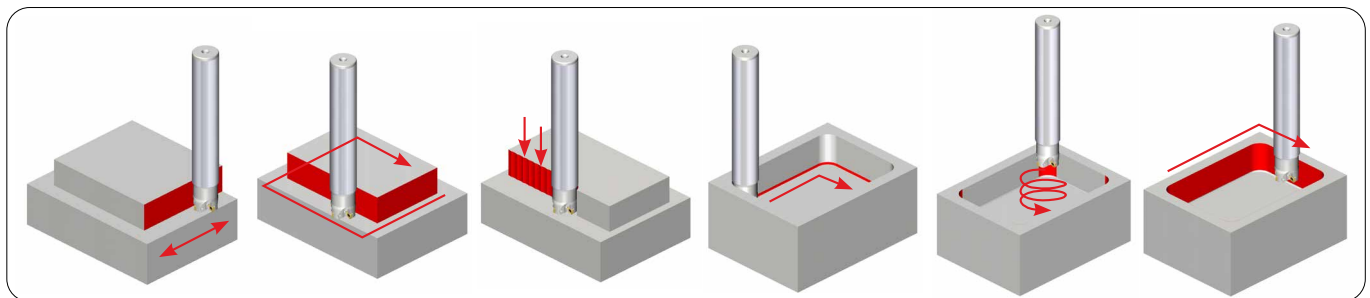
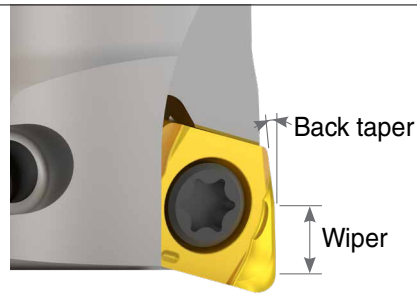
The 4NHT 06-F inserts, with a wiper design on four side cutting edges, are noted for their exceptional surface finish that reduces mismatch, especially in long overhang machining, making them a popular choice in the mold and die industry. TaeguTec now introduces the 4NHT 04-F line of inserts that replaces smaller sized blade type inserts and the solid carbide end mill in the finishing market.

### Features

- Double-sided 4-corner ground insert
- Wiper design for excellent surface finish
- Stable machining even in long overhang machining
- Compatible with the existing small size carbide end mill range



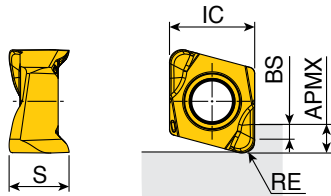
4NHT-F



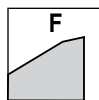
## 4NHT-F



### Inserts



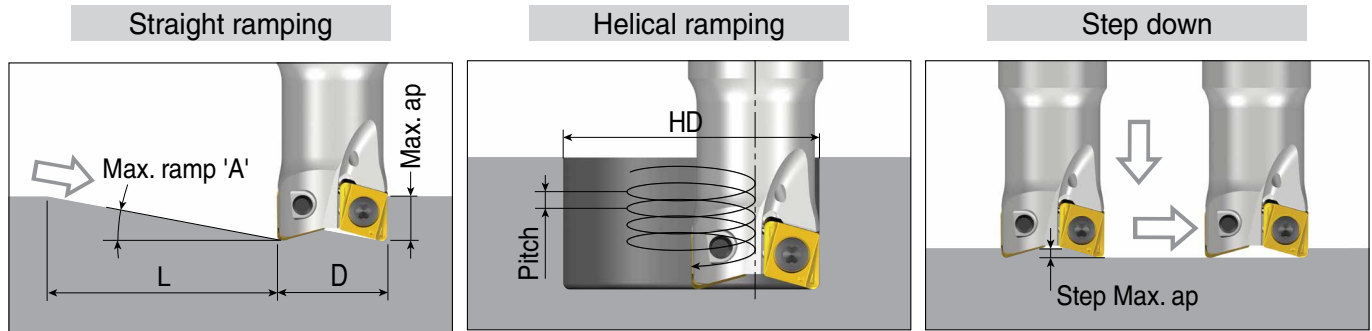
Size	Dimension (mm)				
	IC	S	APMX	BS	RE
<b>04-05R</b>	4.0	3.1	2.2	1.7	0.5
<b>04-10R</b>	4.0	3.0	2.0	1.0	1.0
<b>06-05R</b>	6.6	4.9	2.3	1.8	0.5
<b>06-10R</b>	6.6	4.7	2.1	1.1	1.0
<b>06-15R</b>	6.6	4.5	3.3	1.8	1.5
<b>06-20R</b>	6.6	4.3	3.0	1.1	2.0



Insert	Designation	Recommended machining conditions		Coated								Uncoated			
		ap (mm)	Feed (mm/tooth)	TT9080	TT8080	TT8020	TT8525B	TT7080	TT7515	TT6080	TT2510			K10	
	<b>4NHT 040205R-F</b> <span style="color:red">new</span>	0.2-2.0	0.30-0.07												
	<b>040210R-F</b> <span style="color:red">new</span>	0.2-1.8	0.30-0.07								●				
	<b>060305R-F</b>	0.2-2.0	0.30-0.07	●								●			
	<b>060310R-F</b>	0.2-1.8	0.30-0.07	●								●			
	<b>060315R-F</b>	0.2-3.0	0.30-0.07	●								●			
	<b>060320R-F</b>	0.2-2.7	0.30-0.07	●								●			

●: Standard items

## Ramping Data

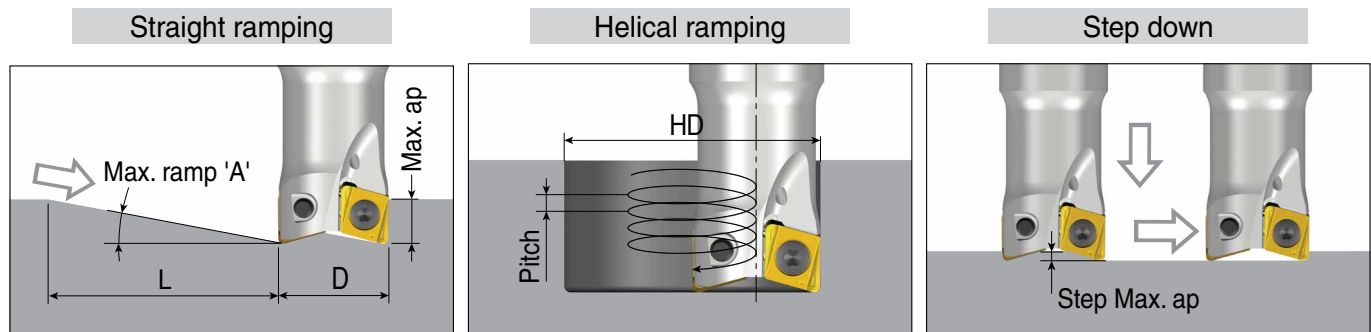


### 4NHT 04 : R0.5-F

(unit: mm)

Cutter dia. (D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia. (HD)	Max. dia. (HD)	Max. pitch/rev.	Max. ap
Ø8	3.4	2.2	37	9.9		0.3	0.3
					16	1.3	
Ø10	4.0	2.2	31	13.9		0.7	0.5
					20	1.9	
Ø11	4.6	2.2	27	15.9		1.1	0.6
					22	2.4	
Ø12	4.3	2.2	29	17.9		1.2	0.7
					24	2.4	
Ø13	4.6	2.2	27	19.9		1.5	0.8
					26	2.8	
Ø16	3.9	2.2	32	25.9		1.8	0.9
					32	2.9	
Ø20	2.9	2.2	43	33.9		1.9	0.9
					40	2.7	
Ø25	2.2	2.2	57	43.9		1.9	0.9
					50	2.6	
Ø32	1.6	2.2	76	57.9		2.0	0.9
					64	2.5	
Ø40	1.3	2.2	97	73.9		2.1	0.9
					80	2.4	

## Ramping Data



### 4NHT 04 : R1.0-F

(unit: mm)

Cutter dia. (D)	Straight ramp down			Helical ramp down			Step down
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia. (HD)	Max. dia. (HD)	Max. pitch/rev.	Max. ap
Ø8	1.5	2.0	74	9.9		0.1	0.1
					16	0.6	
Ø10	2.5	2.0	45	13.9		0.5	0.3
					20	1.2	
Ø11	3.3	2.0	35	15.9		0.8	0.4
					22	1.7	
Ø12	3.1	2.0	37	17.9		0.9	0.5
					24	1.7	
Ø13	3.5	2.0	33	19.9		1.1	0.5
					26	2.1	
Ø16	3.0	2.0	38	25.9		1.4	0.6
					32	2.2	
Ø20	2.2	2.0	51	33.9		1.5	0.7
					40	2.1	
Ø25	1.7	2.0	65	43.9		1.5	0.7
					50	2.0	
Ø32	1.3	2.0	88	57.9		1.6	0.7
					64	1.9	
Ø40	1.0	2.0	115	73.9		1.6	0.7
					80	1.9	