NEW PRODUCT NEWS

TRIOBALL

new

High Feed Rough Copy Milling

TaeguTec
Member IMC Group

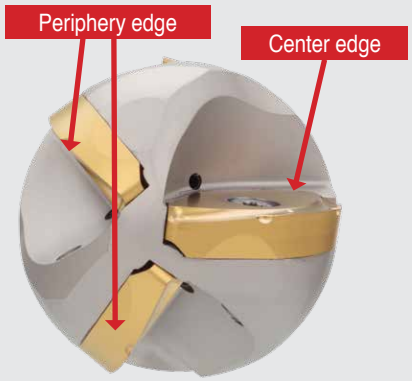
TRIOBALL

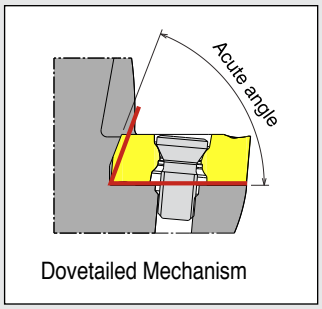
High feed rough copy milling

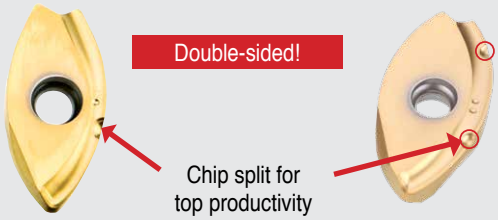
FEATURES

- **Effective 3 flute design enables high feed machining to enhance productivity**
- **Unique double-sided insert with 2 cutting edges**
- **A highly stable cutting performance with thick cutting edges**
- **Excellent chip evacuation with a coolant hole**
- **Dovetail mechanism clamping provides increased security and insert clamping**

TaeguTec is pleased to add the new TRIOBALL line following the success of the existing low resistance CHASEBALLline. The TRIOBALL line with its 3 flute design and dove-tail mechanism promoting rigid clamping permits high feed copy milling, groove machining and deep cavity machining with superior stability. Double-sided inserts improve economy and make the TRIOBALL a cost effective solution for customers.
Moreover, the double-sided inserts improve economy and make the TRIOBALL a cost effective solution for customers.



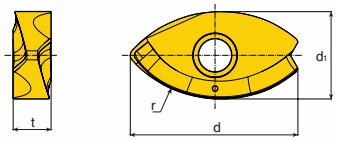




3FB
Inserts

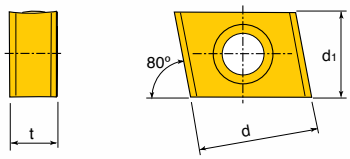

C-M


P-M



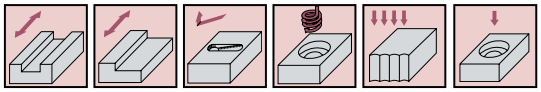
Designation	Dimension (mm)					Grade			Application
	d	d1	t	r	ap	TT9080	TT8080	TT7800	Ball end mill
3FB320C-M	23	12	5.2	16	16	●	●	●	3F 32-□□-W□□-□□□ 3F 50-□□-W□□-□□□ 3F 50-□□-CN50.8-□□□
3FB320P-M	21	9.9	5.2	16	16	●	●	●	
3FB500C-M	36	18.6	7	25	25	●	●	●	
3FB500P-M	32.9	15.3	7	25	25	●	●	●	

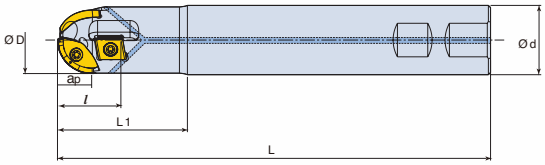
CNHX
Inserts



Designation	Dimension (mm)			Grade	Application
	d	d1	t	TT7800	Ball end mill
CNHX 131108T	12.7	11	5.4	●	3F 32-□□-W□□-□□□ 3F 50-□□-W□□-□□□ 3F 50-□□-CN50.8-□□□
CNHX 160608T	16	12	6.4	●	

3F □□-□□-W□□-□□
Weldon shank type

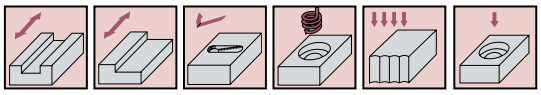


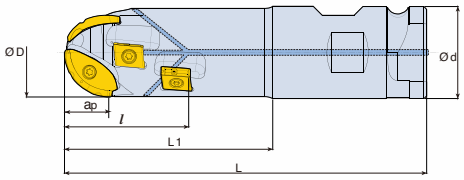


Designation	Inserts						Dimension (mm)					
	Ball 1		Ball 2		Periphery		D	d	L	L1	l	ap
	Designation		Designation		Designation							
3F 32-39-W32-150	3FB320C-M	1	3FB320P-M	2	CNHX 131108T	2	32	32	150	60	39	16
3F 32-39-W32-200	3FB320C-M	1	3FB320P-M	2	CNHX 131108T	2	32	32	200	60	39	16
3F 32-39-W32-250	3FB320C-M	1	3FB320P-M	2	CNHX 131108T	2	32	32	250	60	39	16
3F 50-54-W40-150	3FB500C-M	1	3FB500P-M	2	CNHX 160608T	2	50	40	150	70	54	25
3F 50-80-W50-200	3FB500C-M	1	3FB500P-M	2	CNHX 160608T	4	50	50	200	110	80	25
3F 50-80-W50-250	3FB500C-M	1	3FB500P-M	2	CNHX 160608T	4	50	50	250	110	80	25

• Coolant through type
• When machining over 'ap', please calculate Z=1

3F 50-□□-CN50.8-□□□
Combination shank type

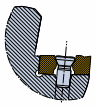




Designation	Inserts						Dimension (mm)					
	Ball 1		Ball 2		Periphery		D	d	L	L1	l	ap
	Designation		Designation		Designation							
3F 50-68-CN50.8-200	3FB500C-M	1	3FB500P-M	2	CNHX 160608T	3	50	50.8	200	115	68	25
3F 50-94-CN50.8-250	3FB500C-M	1	3FB500P-M	2	CNHX 160608T	5	50	50.8	250	165	94	25

• Coolant through type
• When machining over 'ap', please calculate Z=1

Components

Designation	Screw	Wrench
		
3F 32 (D32)	TS 40093I	TD 15
3F 50 (D50)	TS 50115I	T-T20

Recommended cutting conditions

Operating guidelines for TRIOBALL - 3F using 3FB □□□P-M, 3FB □□□C-M inserts

Material	Brinell	Speed (m/min)	Grades***	Feed (mm/tooth)		
				Side deep cutting	Side cutting	Grooving
Low Carbon Steel	85-175	200-350	TT9080, TT7800	0.15 - 0.45	0.2 - 0.5	0.1 - 0.3
High Carbon Steel	175-225	180-320	TT9080, TT7800	0.1 - 0.35	0.15 - 0.4	0.05 - 0.2
Alloyed Steel	275-325	120-250	TT9080, TT7800,TT8080	0.1 - 0.3	0.15 - 0.35	0.05 - 0.25
Tool Steel	200-250	100-200	TT9080, TT7800,TT8080	0.15 - 0.35	0.2 - 0.4	0.1 - 0.3
Stainless 300 Series	-	180-280	TT8080, TT9080	0.08 - 0.25	0.12 - 0.35	0.05 - 0.25
Stainless 400 Series	-	200-300	TT8080, TT9080	0.1 - 0.3	0.15 - 0.45	0.05 - 0.25
High-Temp Alloy Inconel	-	20-80	TT8080, TT9080	0.05 - 0.2	0.1 - 0.3	0.08 - 0.15
Titanium Alloy	-	40-110	TT9080, TT8080	0.05 - 0.2	0.1 - 0.3	0.08 - 0.15
Gray Cast Iron	-	240-380	TT9080, TT7800	0.15 - 0.4	0.2 - 0.5	0.1 - 0.3
Ductile / Nodular Cast Iron	-	180-280	TT9080, TT7800	0.1 - 0.35	0.2 - 0.5	0.1 - 0.15