

# NEW PRODUCT NEWS

## CHASE<sup>2</sup>BALL



## OPTIMIZED DOUBLE SIDED INSERTS FOR ROUGH MILLING

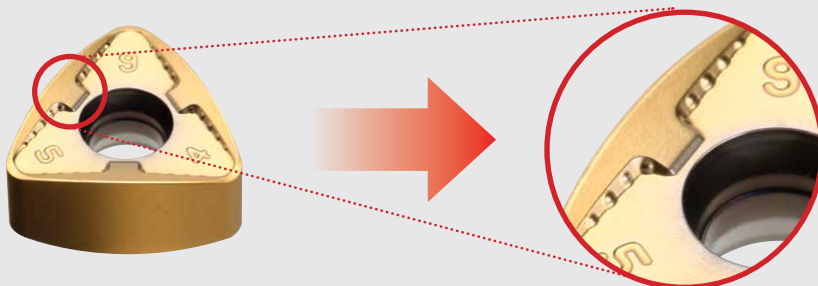


# CHASE<sup>2</sup>BALL

## Optimized double sided inserts for rough milling

### FEATURES

- 6 cutting edges promote economy and productivity in cast iron and tool steel
- Low cutting resistance credit to half effective flute design
- Thick inserts (8mm) enable stable machining
- Insert design with high positive cutting edges
- Excellent performance in heat treated steel and welded components
- Enhanced protection of the holder pocket due to reinforced design



Reinforced insert design prevents breakage in hard cutting conditions



TaeguTec is pleased to launch the double-sided CHASE2BALL.

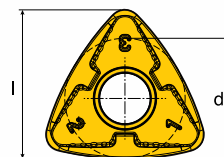
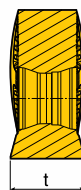
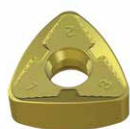
Optimally suited for press & die items in the mold & die industry and copy milling in heavy industry, the CHASE2BALL is a double-sided insert that easily handles roughing of complicated profiles.

As it is a double sided insert-6 corners; 3 per side—economy is one of its key advantages. Another advantage is low cutting resistance due to its half-effective tool design.

Other benefits include exceptionally stable machining in deep depth of cut applications due to the CHASE2BALL's 8mm insert thickness. Included is a built-in reinforced insert design that gives improved insert and tool security even in heavy rough machining situations.

# Inserts

## 6RBE 50-M

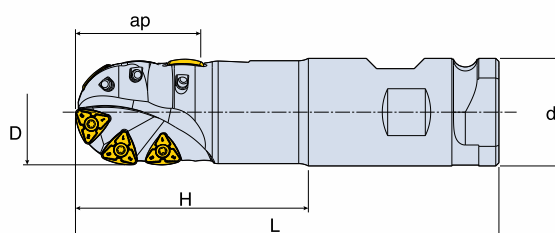


Designation	Dimension (mm)			Grade				
	d	t	l	TT6080	TT6800	TT7800	TT8020	TT9080
<b>6RBE 50-M</b>	13	8	16	●	⊙	⊙	●	●

● : Standard items    ⊙ : Produced upon request only

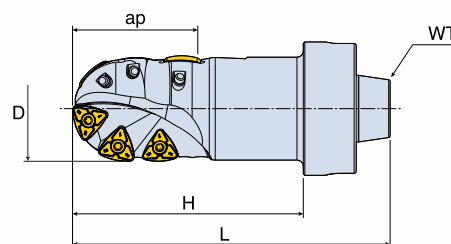
## TDB50X --

### Combination Shank Type



Designation	Insert		Dimension (mm)					Screw	Wrench
			D	L	ap	H	d		
<b>TDB50X 59-CN50.8-L200</b>	6RBE 50-M	6	50	200	59	110	50.8	TS50B106I/HG	T-T20
<b>TDB50X 69-CN50.8-L250</b>		7	50	250	69	160	50.8	TS50B106I/HG	T-T20

### WT30 Shank Type



Designation	Insert		Dimension (mm)					Screw	Wrench
			D	L	ap	H	WT		
<b>TDB50X 59-WT30-L150</b>	6RBE 50-M	6	50	150	59	109	30	TS50B106I/HG	T-T20
<b>TDB50X 69-WT30-L200</b>		7	50	200	69	159	30	TS50B106I/HG	T-T20

## Weldon Shank Type

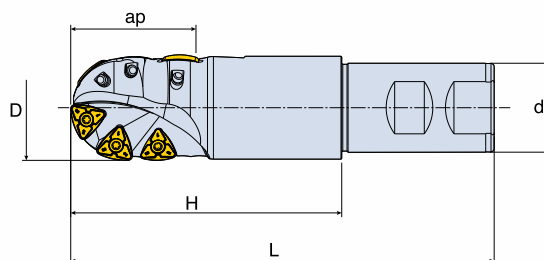


Fig.1

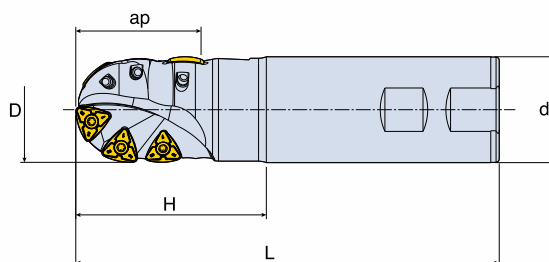


Fig.2

Designation	Insert		Dimension (mm)					Fig.	Screw	Wrench
			D	L	ap	H	d			
<b>TDB50X 59-W40-L200</b>	6RBE 50-M	6	50	200	59	128	40	1	TS50B106I/HG	T-T20
<b>TDB50X 69-W40-L250</b>		7	50	250	69	178	40	1	TS50B106I/HG	T-T20
<b>TDB50X 59-W42-L200</b>		6	50	200	59	128	42	1	TS50B106I/HG	T-T20
<b>TDB50X 69-W42-L250</b>		7	50	250	69	178	42	1	TS50B106I/HG	T-T20
<b>TDB50X 59-W50-L200</b>		6	50	200	59	90	50	2	TS50B106I/HG	T-T20
<b>TDB50X 69-W50-L250</b>		7	50	250	69	140	50	2	TS50B106I/HG	T-T20

## Operating Guidelines for **CHASE<sup>2</sup>BALL**

Material	Brinell (HB)	Speed (m/min)	Best grades	Feed (mm/tooth)		
				Side deep cutting	Side cutting	Grooving
Low Carbon Steel	85~175	200~350	TT9080, TT7800	0.15 - 0.5	0.2 - 0.9	0.1 - 0.3
High Carbon Steel	175~225	180~320	TT9080	0.1 - 0.45	0.15 - 0.8	0.05 - 0.25
Alloyed Steel	275~325	120~250	TT9080, TT6800	0.1 - 0.45	0.15 - 0.65	0.05 - 0.3
Tool Steel	200~250	100~200	TT9080	0.15 - 0.45	0.2 - 0.5	0.1 - 0.4
Stainless 300 Series		180~280	TT8020	0.08 - 0.25	0.12 - 0.35	0.05 - 0.25
Stainless 400 Series		200~300	TT8020	0.1 - 0.3	0.15 - 0.45	0.05 - 0.25
High Temp. Super Alloy		20~80	TT8020	0.05 - 0.2	0.1 - 0.3	0.08 - 0.15
Titanium Alloy		40~110	TT8020	0.05 - 0.2	0.1 - 0.3	0.08 - 0.15
Gray Cast Iron		240~380	TT6080, TT6800	0.15 - 0.4	0.2 - 0.5	0.1 - 0.3
Nodular Cast Iron		180~280	TT6080, TT6800	0.1 - 0.35	0.2 - 0.5	0.1 - 0.15