

NEW PRODUCT NEWS

CHASEMOLD



New Cutter with Strong Insert



CHASEMOLD

New cutter with strong insert

FEATURES

- Higher insert thickness, stronger screw systems for heavy or demanding applications
- Exceptional performance at very high feed rates
- Reliable machining even under difficult conditions
- Long tool life through optimum geometry of inserts
- Anti-rotating system (over R5 insert)

TaeguTec's new CHASEMOLD improves the existing line with its thick and robust new design including 8 indexing insert edges; our customers now have an improved solution for machining in stable conditions while reducing tooling costs.

For contour, copy and radius milling of mold & die applications and any other demanding operations such as roughing for aerospace parts and heavy industrial products, customers can obtain the following benefits.



Inserts

RYMX / RYHX

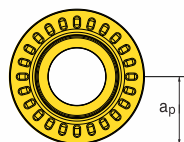
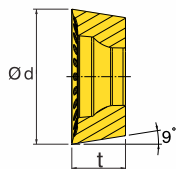


Fig. 1

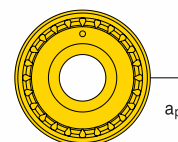
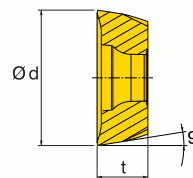


Fig. 2

Designation	Dimension (mm)				Grade										Fig.	Application
	R	d	t	ap	TT9080	TT8080	TT8020	TT7800	TT7080	TT6080	TT6030	DX40RP	DX40RC	K10		
RYMX 0803-M	4	8	3.2	4	•	•		•	•	•					1	End Mill & Cutter
RYMX 0803-ML		8	3.2	4	•	•		•								
RYMX 0803-MR		8	3.2	4	•				•							
RYMX 1004-M	5	10	4.0	5	•	•		•	•	•				2		
RYMX 1004-ML		10	4.0	5	•	•		•			•	•				
RYMX 1004-MR		10	4.0	5	•	•			•							
RYHX 1004-AL		10	4.0	5									•	2		
RYHX 1004-ML		10	4.0	5		•										
RYMX 1205-M	6	12	4.8	6	•	•		•	•	•						
RYMX 1205-ML		12	4.8	6	•	•	•	•			•					
RYMX 1205-MR		12	4.8	6	•	•			•	•	•					
RYHX 1205-AL		12	4.8	6									•	2		
RYHX 1205-ML		12	4.8	6		•					•	•				
RYMX 1606-M	8	16	6.1	8	•	•	•	•	•	•						
RYMX 1606-ML		16	6.1	8	•	•		•								
RYMX 1606-MR		16	6.1	8	•			•	•							
RYHX 1606-AL		16	6.1	8									•	2		
RYHX 1606-ML		16	6.1	8		•										
RYMX 2007-M	10	20	7.0	10	•	•		•								
RYMX 2007-ML		20	7.0	10	•	•		•								

End mill type

TERY □□□-□□□-□□

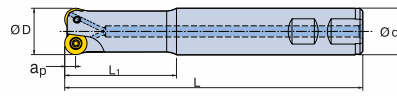
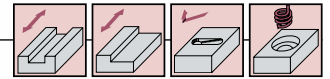


Fig.1

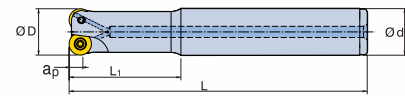


Fig.2

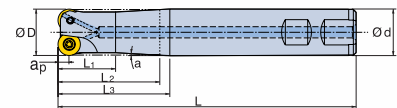


Fig.3

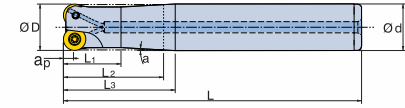


Fig.4

Designation	Insert	R		Dimension (mm)								Fig.		
				D	d	L	L1	L2	L3	α°	ap			
TERY 216-W20-08-L	RYMX 08/10/12/16 -M/ML/MR	4	2	16	20	110	25	45	55	4.1	4	2		
TERY 320-W20-08			3	20	20	150	40	-	-	-	4	1		
TERY 425-W25-08			4	25	25	150	40	-	-	-	4	1		
TERY 532-W32-08			5	32	32	160	60	-	-	-	4	1		
TERY 220-25-10-L		RYHX 10/12/16-AL/ML	5	2	20	25	250	37	60	80	3.5	5	4	
TERY 220-W20-10				2	20	20	160	60	-	-	-	5	1	
TERY 221-20-10-L200			2	21	20	200	30	-	-	-	5	2		
TERY 225-32-10-L			2	25	32	250	36	53	80	5.0	5	4		
TERY 225-W25-10			2	25	25	160	60	-	-	-	5	1		
TERY 325-W25-10			3	25	25	160	60	-	-	-	5	1		
TERY 226-25-10-L200			2	26	25	200	30	-	-	-	5	2		
TERY 432-W32-10			4	32	32	160	60	-	-	-	5	1		
TERY 225-W25-12			RYMX 20-M/ML	6	2	25	25	160	60	-	-	-	6	1
TERY 232-32-12-L					2	32	32	250	50	-	-	-	6	1
TERY 332-W32-12		3			32	32	160	64	-	-	-	6	1	
TERY 332-W32-12-S		3			32	32	105	35	-	-	-	6	1	
TERY 340-W32-12	3	40			32	160	50	-	-	-	6	1		
TERY 340-W32-12-S	3	40			32	105	35	-	-	-	6	1		
TERY 440-W32-12	4	40			32	150	35	-	-	-	6	1		
TERY 440-W32-12-S	4	40			32	105	35	-	-	-	6	1		
TERY 240-W32-16	8	2	40	32	160	50	-	-	-	8	1			
TERY 350-32-20	10	3	50	32	160	50	-	-	-	10	3			
TERY 350-40-20		3	50	40	200	60	-	-	-	10	3			

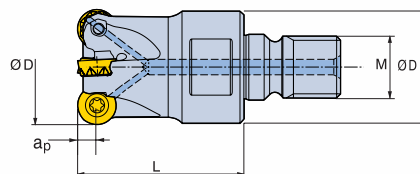
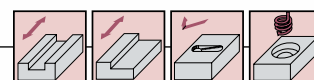
• Coolant through type

Components

	Screw	Wrench
TERY-08	TS 30A060I/HG	TD9
TERY-10	TS 35070I/HG(Under D21), TS 35085I/HG	TD15
TERY-12	TS 40093I	TD15
TERY-16	TS 50115I	TD20
TERY-20	TS 60A130I	TD25

Modular type

TERY □□□-M□□-□□



Designation	Insert	R		Dimension (mm)					
				D	D1	L	M	ap	
TERY 216-M08-08	RYMX 08/10/12/16 -M/ML/MR RYHX 10/12/16-AL/ML RYMX 20-M/ML	4		2	16	13	23	8	4
TERY 220-M10-08				2	20	18	30	10	4
TERY 320-M10-08				3	20	18	30	10	4
TERY 425-M12-08				4	25	21	35	12	4
TERY 532-M16-08				5	32	29	43	16	4
TERY 540-M16-08				5	40	29	43	16	4
TERY 640-M16-08				6	40	29	43	16	4
TERY 220-M10-10				5	2	20	18	30	10
TERY 225-M12-10		2			25	21	35	12	5
TERY 325-M12-10		3			25	21	35	12	5
TERY 430-M16-10		4			30	29	43	16	5
TERY 432-M16-10		4			32	29	43	16	5
TERY 435-M16-10		4			35	29	43	16	5
TERY 542-M16-10		5			42	29	43	16	5
TERY 225-M12-12		6			2	25	21	35	12
TERY 232-M16-12				2	32	29	43	16	6
TERY 332-M16-12				3	32	29	43	16	6
TERY 340-M16-12				3	40	29	43	16	6
TERY 442-M16-12				4	42	29	43	16	6
TERY 232-M16-16				8	2	32	29	43	16
TERY 240-M16-16		2			40	29	43	16	8
TERY 342-M16-16		3			42	29	43	16	8

• Coolant through type

Components

	Screw	Wrench
TERY-08	TS 30A060I/HG	TD9
TERY-10	TS 35070I/HG(Under D21), TS 35085I/HG	TD15
TERY-12	TS 40093I	TD15
TERY-16	TS 50115I	TD20
TERY-20	TS 60A130I	TD25

Face mill type

TFMRY □□□-□□R-□□

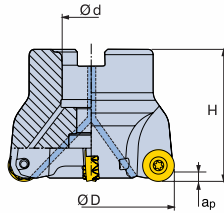


Fig.1

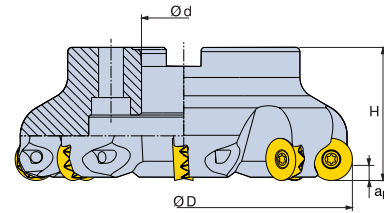


Fig.2

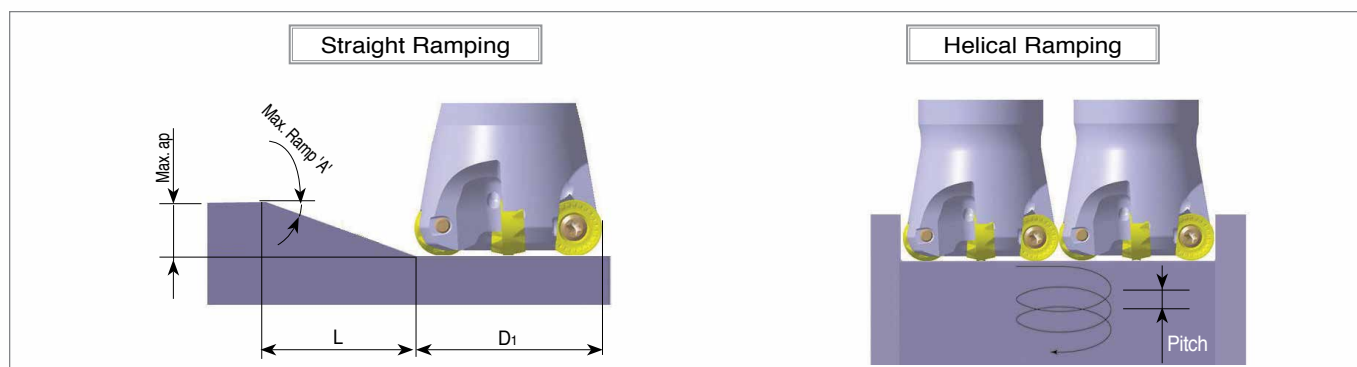
Designation	Insert	R		Dimension (mm)					Fig.	Weight (Kg)	Mounting Bolt				
				D	d	H	ap								
TFMRY 540-16R-10	RYMX 1004-M/ML/MR RYHX 1004-AL/ML	5		5	40	16	40	5	●	1	0.22	SH M8X1.25X30			
TFMRY 650-22R-10				6	50	22	50	5	●	1	0.33	SH M10X1.5X30			
TFMRY 652-22R-10				6	52	22	50	5	●	1	0.36	SH M10X1.5X30			
TFMRY 766-27R-10	RYMX 1205-M/ML/MR RYHX 1205-AL/ML	6		7	66	27	50	5	●	1	0.68	SH M12X1.75X30			
TFMRY 440-16R-12				4	40	16	40	6	●	1	0.15	SH M8X1.25X30			
TFMRY 450-22R-12				4	50	22	50	6	●	1	0.33	SH M10X1.5X30			
TFMRY 550-22R-12				5	50	22	50	6	●	1	0.33	SH M10X1.5X30			
TFMRY 552-22R-12				5	52	22	50	6	●	1	0.34	SH M10X1.5X30			
TFMRY 563-22R-12				5	63	22	50	6	●	1	0.58	SH M10X1.5X30			
TFMRY 663-22R-12				6	63	22	50	6	●	1	0.58	SH M10X1.5X30			
TFMRY 763-22R-12				7	63	22	50	6	●	1	0.71	SH M10X1.5X30			
TFMRY 666-27R-12				6	66	27	50	6	●	1	0.62	LH M12X1.75X30			
TFMRY 680-27R-12				6	80	27	50	6	●	1	0.90	LH M12X1.75X30			
TFMRY 780-27R-12				7	80	27	50	6	●	1	0.92	LH M12X1.75X30			
TFMRY 7100-32R-12				7	100	32	50	6	●	1	1.29	LH M16X2X35			
TFMRY 350-16R-16				RYMX 1606-M/ML/MR RYHX 1606-AL/ML	8		3	50	16	50	8	●	1	0.31	SH M8X1.25X35
TFMRY 450-16R-16							4	50	16	50	8	●	1	0.31	SH M8X1.25X35
TFMRY 452-22R-16	4	52	22				50	8	●	1	0.30	SH M10X1.5X30			
TFMRY 463-22R-16	4	63	22				50	8	●	1	0.50	SH M10X1.5X30			
TFMRY 463H-22R-16*	4	63	22				50	8	●	1	0.48	SH M10X1.5X30			
TFMRY 566-27R-16	5	66	27				50	8	●	1	0.58	LH M12X1.75X30			
TFMRY 580-27R-16	5	80	27				50	8	●	1	0.81	LH M12X1.75X30			
TFMRY 580H-27R-16*	5	80	27				50	8	●	1	0.77	LH M12X1.75X30			
TFMRY 680-27R-16	6	80	27				50	8	●	1	0.83	LH M12X1.75X30			
TFMRY 6100-32R-16	6	100	32				50	8	●	1	1.24	LH M16X2X35			
TFMRY 6100H-32R-16*	6	100	32				50	8	●	1	1.19	LH M16X2X35			
TFMRY 7125-40R-16	7	125	40				63	8	●	1	2.66	SH M20X2.5X40			
TFMRY 7125H-40R-16*	7	125	40				63	8	●	1	2.57	SH M20X2.5X40			
TFMRY 8125-40R-16	8	125	40				63	8	●	1	2.68	SH M20X2.5X40			
TFMRY 8160H-40R-16*	8	160	40				63	8	x	2	3.25	-			
TFMRY 463-22R-20	RYMX 2007-M/ML	10					4	63	22	50	10	●	1	0.46	SH M10X1.5X30
TFMRY 580-27R-20							5	80	27	50	10	●	1	0.76	LH M12X1.75X30
TFMRY 5100H-32R-20*							5	100	32	50	10	●	1	1.08	LH M16X2X35
TFMRY 6100-32R-20							6	100	32	50	10	●	1	1.17	LH M16X2X35
TFMRY 5125H-40R-20*							5	125	40	63	10	●	1	2.72	SH M20X2.5X40
TFMRY 7125-40R-20				7	125	40	63	10	●	1	2.50	SH M20X2.5X40			
TFMRY 6160H-40R-20*				6	160	40	63	10	x	2	2.72	-			
TFMRY 8160-40R-20				8	160	40	63	10	x	2	3.84	-			
TFMRY 8200H-60R-20*				8	200	60	63	10	x	2	5.27	-			

* Carbide shim type

Components

	Shim	Shim Screw	Screw	Wrench
TFMRY □□□H-16	TSRY 16N	TS 7050088S		
TFMRY □□□H-20	TSRY 20N	TS 8060011S		
TFMRY-10			TS 35085I/HG	T-T15
TFMRY-12			TS 40093I	T-T15
TFMRY-16			TS 50115I	T-T20
TFMRY-20			TS 60A130I	T-T25

Ramping data



RYMX-08

Cutter Dia.	Straight Ramp Down			Helical Ramp Down		
	Max. Ramp (A°)	Max. ap (mm)	Min. Length (L)	Min. Dia.	Max. Dia.	Max. Pitch/Rev.
Ø16	2.5	4	92	18	32	0.2
						1.9
Ø20	4	4	57	26	40	1.1
						3.7
Ø25	4	4	57	36	50	2.1
						3.4
Ø32	4	4	57	50	64	3.4
						3.4
Ø40	7	4	33	66	80	3.4
						3.4

RYMX-10

Cutter Dia.	Straight Ramp Down			Helical Ramp Down		
	Max. Ramp (A°)	Max. ap (mm)	Min. Length (L)	Min. Dia.	Max. Dia.	Max. Pitch/Rev.
Ø20	4.5	5	64	22	40	0.4
						4.2
Ø25	5	5	57	32	50	1.6
						4.3
Ø32	5	5	57	46	64	3.3
						4.3
Ø35	5	5	57	52	70	4.0
						4.3
Ø42	5	5	57	66	84	4.3
						4.3
Ø50	6.5	5	44	82	100	4.3
						4.3
Ø52	6	5	48	86	104	4.3
						4.3
Ø66	4.5	5	64	114	132	4.3
						4.3

RYMX-20

Cutter Dia.	Straight Ramp Down			Helical Ramp Down		
	Max. Ramp (A°)	Max. ap (mm)	Min. Length (L)	Min. Dia.	Max. Dia.	Max. Pitch/Rev.
Ø50	8	10	71	62	100	4.5
						8.5
Ø63	12.5	10	45	88	126	8.5
						8.5
Ø80	8.5	10	67	122	160	8.5
						8.5
Ø100	6.5	10	88	162	200	8.5
						8.5
Ø125	4.5	10	127	212	250	8.5
						8.5
Ø160	4	10	143	282	320	8.5
						8.5

RYMX-12

Cutter Dia.	Straight Ramp Down			Helical Ramp Down		
	Max. Ramp (A°)	Max. ap (mm)	Min. Length (L)	Min. Dia.	Max. Dia.	Max. Pitch/Rev.
Ø25	6	6	57	28	50	0.8
Ø32	12	6	28	42	64	5.1
Ø35	12	6	28	48	70	5.1
Ø40	10	6	34	58	80	5.1
Ø42	12	6	28	62	84	5.1
Ø50	9	6	38	78	100	5.1
Ø52	8	6	43	82	104	5.1
Ø55	8	6	43	88	110	5.1
Ø63	7	6	49	104	126	5.1
Ø66	6.5	6	53	110	132	5.1
Ø80	4.5	6	76	138	160	5.1
Ø100	3.5	6	98	178	200	5.1
Ø125	2.5	6	137	228	250	5.1

RYMX-16

Cutter Dia.	Straight Ramp Down			Helical Ramp Down		
	Max. Ramp (A°)	Max. ap (mm)	Min. Length (L)	Min. Dia.	Max. Dia.	Max. Pitch/Rev.
Ø32	8	8	57	34	64	0.7
Ø40	9.5	8	48	50	80	6.8
Ø42	9	8	51	54	84	4.5
Ø50	9	8	51	70	100	6.8
Ø52	9	8	51	74	104	6.8
Ø66	8.5	8	54	102	132	6.8
Ø80	6	8	76	130	160	6.8
Ø100	5	8	91	170	200	6.8
Ø125	3.5	8	131	220	250	6.8

Maximum depth when using 8 corners

10 mm: Max. 1.46mm
 12 mm: Max. 1.75mm
 16 mm: Max. 2.34mm
 20 mm: Max. 2.92mm

Operating guidelines for CHASEMOLD series RYMX, RYHX inserts

Material	Brinell	Speed (m/min)	Best grades	Feed (mm/tooth)				
				RY 08	RY 10	RY 12	RY 16	RY 20
Low Carbon Steel	85-175	220-300	TT7080, TT9080	0.09 - 0.26	0.12 - 0.44	0.13 - 0.57	0.16 - 0.60	0.16 - 0.80
High Carbon Steel	175-225	150-250	TT9080, TT7080	0.09 - 0.26	0.12 - 0.40	0.13 - 0.52	0.16 - 0.60	0.14 - 0.70
Alloyed Steel	275-325	100-180	TT9080, TT7080	0.09 - 0.23	0.12 - 0.34	0.13 - 0.45	0.14 - 0.55	0.14 - 0.60
Tool Steel	200-250	85-150	TT9080, TT7080	0.09 - 0.19	0.12 - 0.34	0.13 - 0.45	0.14 - 0.55	0.14 - 0.60
Stainless 300 Series		110-180	TT8080, TT8020, TT9080	0.09 - 0.24	0.12 - 0.40	0.13 - 0.52	0.14 - 0.55	0.14 - 0.60
Stainless 400 Series		110-220	DX40RP, DX40RC, TT8080	0.09 - 0.24	0.12 - 0.40	0.13 - 0.52	0.14 - 0.55	0.14 - 0.60
Inconel HastelloyWaspalloy		25-45	DX40RP, DX40RC, TT8080	0.05 - 0.18	0.09 - 0.28	0.10 - 0.37	0.11 - 0.42	0.10 - 0.50
Titanium 6AL-4V		35-60	TT9080, TT8080	0.05 - 0.18	0.09 - 0.28	0.10 - 0.37	0.11 - 0.42	0.10 - 0.50
Gray Cast Iron	190-220	110-210	TT6080, TT9080	0.09 - 0.23	0.12 - 0.34	0.13 - 0.45	0.14 - 0.55	0.14 - 0.70
Nodular Cast Iron	140-200	120-210	TT6080, TT9080	0.09 - 0.23	0.12 - 0.34	0.13 - 0.45	0.14 - 0.55	0.14 - 0.70
Aluminum		400-500+	K10	-	0.2 - 1.0	0.2 - 1.0	0.2 - 1.2	-