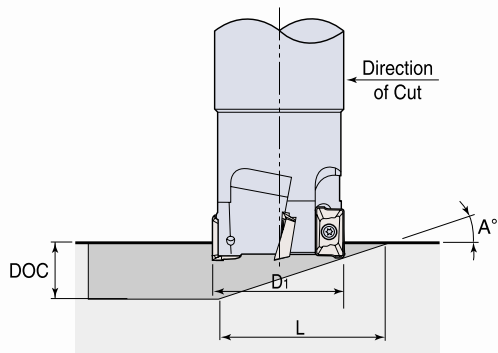


Technical Information



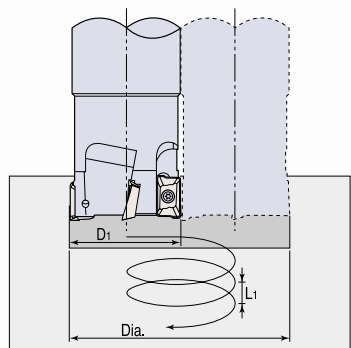
ChaseMill

Straight Ramping



Designation	Dimension (0° or inch)		
	Ramp Angle, A°	L	DOC
TE90AP-D.75	11.0	3.2	.635
TE90AP-D1.00	5.8	6.2	.635
TE90AP-D1.25	3.5	10.4	.635
TE90AP-D1.50	2.3	15.9	.635
TE90AP-D1.75	1.8	19.8	.635
TE90AP-D2.00	1.6	23.5	.635
TE90AX-D.38	7.0	2.8	.350
TE90AX-D.44	7.0	2.8	.350
TE90AX-D.50	6.8	2.9	.350
TE90AX-D.56	6.1	3.2	.350
TE90AX-D.62	5.1	3.9	.350
TE90AX-D.70	4.3	4.6	.350
TE90AX-D.75	4.1	4.8	.350
TE90AX-D.88	3.4	5.8	.350
TE90AX-D1.00	3.1	6.4	.350
TE90AX-D1.12	2.7	7.4	.350
TE90AX-D1.25	2.2	9.1	.350
TE90AX-D1.50	1.6	12.5	.350
TE90AX-D2.00	1.0	20.0	.350

Helical Ramping



Designation	Ramp Data (inch)			Helical Pitch
	Min. Dia.	Max. Dia.	L1	
TE90AP-D.75	1.00	1.5	.13	7.7
TE90AP-D1.00	1.25	2.0	.07	14.3
TE90AP-D1.25	1.65	2.5	.06	16.7
TE90AP-D1.50	2.15	3.0	.07	14.3
TE90AP-D1.75	2.65	3.5	.08	12.5
TE90AP-D2.00	3.15	4.0	.08	12.5
TE90AX-D.38	.50	.75	.04	25
TE90AX-D.44	.58	.88	.12	8.3
TE90AX-D.50	.62	1.00	.14	7.1
TE90AX-D.56	.65	1.12	.16	6.2
TE90AX-D.62	.72	1.25	.02	50.0
TE90AX-D.70	.88	1.40	.15	6.6
TE90AX-D.75	.98	1.50	.03	33.3
TE90AX-D.88	1.24	1.75	.04	25
TE90AX-D1.00	1.48	2.00	.14	7.1
TE90AX-D1.12	1.73	2.25	.07	14.2
TE90AX-D1.25	1.98	2.50	.14	7.1
TE90AX-D1.50	2.48	3.00	.07	14.2
TE90AX-D2.00	3.48	4.00	.11	9.0
			.06	16.1
			.09	11.1

• Calculation is based on APKT 1705 PER-EM & AXMT 0903 PER-EML insert.

Operating Guidelines for ChaseMill & ChaseQuad SEMT13 Inserts

Material	Brinell	D.O.C.	SFM	Best Grades	FPT** APKT17 & SEMT13	FPT** AXMT09 & ADKT09
1117 1020 (MS) 1018	85	.040	1300	7030, 8020, P30	.004 - .006	.002 - .005
	to	.150	1150		.004 - .006	.002 - .004
	175	.300	1000		.004 - .006	.002 - .004
1045 4620 1095 8620 1060 9310 4140 52100 L1 W2 L6	175	.040	900	7030, 8020, P30	.004 - .006	.002 - .005
	to	.150	800		.004 - .006	.002 - .004
	225	.300	600		.004 - .006	.002 - .004
4150 4140HT 9260 S7 4340	275	.040	800	7030, 8020, P30	.004 - .006	.002 - .005
	to	.150	650	8020, 7030, P30	.004 - .006	.002 - .004
	325	.300	500	8020, 7030, P30	.004 - .005	.002 - .004
TOOL STEEL D2	200	.040	400	7030, 8020, P30	.004 - .006	.002 - .005
	to	.150	350		.004 - .006	.002 - .004
	250	.300	300		.004 - .005	.002 - .004
TOOL STEEL A2 A6 P20	200	.040	915	7030, 8020, P30	.004 - .006	.002 - .005
	to	.150	700		.004 - .006	.002 - .004
	250	.300	600		.004 - .005	.002 - .004
STAINLESS STEEL 303, 316 15-5PH	135	.040	800	8020, 7030, DX2	.004 - .006	.002 - .005
	to	.150	700		.004 - .006	.002 - .004
	185	.300	500		.004 - .005	.002 - .004
STAINLESS STEEL 416 17-4PH	135	.040	1000	8020, 7030, DX2	.004 - .006	.002 - .005
	to	.150	850		.004 - .006	.002 - .004
	185	.300	700		.004 - .005	.002 - .004
STAINLESS STEEL 13-8PH		.040	400	8020, 7030, DX2	.004 - .005	.002 - .005
		.150	300		.004 - .005	.002 - .004
		.300	200		.004 - .005	.002 - .004
INCONEL, HASTELLOY WASPALLOY		.040	150	8020, DX2, 7030	.004 - .005	.002 - .005
		.150	100		.004 - .005	.002 - .004
		.300	75		.004 - .005	.002 - .004
TITANIUM 6AL-4V		.040	180	8020, DX2, 7030	.004 - .005	.002 - .005
		.150	150		.004 - .005	.002 - .004
		.300	120		.004 - .005	.002 - .004
GRAY CAST IRON-CLASS 40-45-50	190	.040	1200	6030, 8020, K10	.004 - .006	.003 - .005
	to	.150	1000		.004 - .006	.003 - .005
	220	.300	800		.004 - .006	.003 - .005
DUCTILE CAST IRON-GRADE 65-45-12	140	.040	1000	6030, 8020, K10	.004 - .006	.003 - .005
	to	.150	850		.004 - .006	.003 - .005
	190	.300	700		.004 - .006	.003 - .005
DUCTILE CAST IRON-GRADE 80-55-06	190	.040	800	6030, 8020, K10	.004 - .006	.003 - .005
	to	.150	700		.004 - .006	.003 - .005
	225	.300	500		.004 - .006	.003 - .005
ALUMINUM 6061 T-6 7075 T-6		.040	max	K10, 8020, DX2	.006 - .020	.005 - .020
		.150	max		.006 - .015	.005 - .015
		.300	1200 min		.006 - .015	.005 - .015
72 BRASS 360 18 AMPCO 660 BRONZE	60RB	.040	1600	K10, 6030, 8020	.006 - .020	.005 - .020
	to	.150	1400		.006 - .015	.005 - .015
	100RB	.300	1200		.006 - .015	.005 - .015

- Reduce chip load by 28% for End Mills .750 dia. and under at D.O.C.>.150
- Reduce sfm by 20% for Face Mills when channel milling
- **FPT(Feed per tooth) shown at lower limit can be increased up to 2 times depending upon application



Operating Guidelines for ChaseOcto & Round Inserts

Material	Brinell	D.O.C.	Max sfm	Best Grades***	FPT** OF-- 05 OF-- 07	FPT** RFMT 14 RFMR 19
1117 1020 (MS) 1018	85	.040	1200	7030, 8020, P30	.004 - .007	.008 - .014
	to 175	.100 .250 +	1000 900		.004 - .006 .004 - .006	.005 - .008 .004 - .006
	175	.040	850		.004 - .007	.008 - .014
1045 4620 1095 8620 1060 9310 4140 52100 L1 W2 L6	to 225	.100 .250 +	750 600	7030, 8020, P30	.004 - .006 .004 - .006	.005 - .008 .004 - .006
	275	.040	700		.004 - .007	.008 - .014
	to 325	.100 .250 +	600 450		.003 - .005 .003 - .004	.006 - .010 .003 - .004
4150 4140HT 9260 S7 4340	200	.040	400	7030, 8020, P30 8020, 7030, P30 8020, 7030, P30	.003 - .005	.006 - .010
	to 250	.100 .250 +	350 300		.003 - .004 .003 - .004	.004 - .007 .003 - .004
	200	.040	800		.003 - .007	.006 - .014
TOOL STEEL D2	to 250	.100 .250 +	650 550	7030, 8020, P30	.003 - .005 .003 - .005	.004 - .007 .003 - .005
	200	.040	800		.003 - .007	.006 - .014
	to 250	.100 .250 +	650 550		.003 - .005 .003 - .005	.004 - .007 .003 - .005
STAINLESS STEEL 303, 316 15-5PH	135	.040	800	8020, 7030, DX2	.003 - .007	.006 - .014
	to 185	.100 .250 +	700 500		.003 - .005 .003 - .005	.004 - .007 .003 - .005
	135	.040	1100		.003 - .007	.006 - .014
STAINLESS STEEL 416 17-4PH	to 185	.100 .250 +	900 700	8020, 7030, DX2	.003 - .005 .003 - .005	.004 - .007 .003 - .005
	135	.040	400		.003 - .007	.006 - .014
	to 185	.100 .250 +	300 200		.003 - .005 .003 - .005	.004 - .007 .003 - .005
STAINLESS STEEL 13-8PH		.040	150	8020, 7030, DX2	.003 - .007	.006 - .014
		.100	100		.003 - .005	.004 - .007
		.250 +	80		.003 - .005	.003 - .005
INCONEL, HASTELLOY WASPALLOY		.040	250	8020, DX2, 7030	.003 - .007	.006 - .014
		.100	175		.003 - .005	.004 - .007
		.250 +	120		.003 - .005	.003 - .005
TITANIUM 6AL-4V		.040	1000	8020, DX2, 7030	.003 - .007	.006 - .014
		.100	850		.003 - .005	.004 - .007
		.250 +	700		.003 - .005	.003 - .005
GRAY CAST IRON-CLASS 40-45-50	190	.040	900	6030, 8020, K10	.003 - .007	.006 - .014
	to 220	.100 .250 +	750 700		.003 - .005 .003 - .005	.004 - .007 .003 - .005
	140	.040	900		.003 - .007	.006 - .014
DUCTILE CAST IRON-GRADE 65-45-12	to 190	.100 .250 +	750 600	6030, 8020, K10	.003 - .005 .003 - .005	.004 - .007 .003 - .005
	190	.040	800		.003 - .007	.006 - .014
	to 225	.100 .250 +	700 500		.003 - .005 .003 - .005	.004 - .007 .003 - .005
DUCTILE CAST IRON-GRADE 80-55-06		.040	max	K10, 8020, DX2	.006 - .020	.012 - .040
		.100	max		.006 - .015	.008 - .020
		.250 +	1200 min		.006 - .015	.006 - .015
ALUMINUM 6061 T-6 7075 T-6		.040	1600	K10, 6030, 8020	.006 - .020	.012 - .040
		.100	1400		.006 - .015	.008 - .020
		.250 +	1200		.006 - .015	.006 - .015
72 BRASS 360 18 AMPCO 660 BRONZE	60RB	.040	1600	K10, 6030, 8020	.006 - .020	.012 - .040
	to 100RB	.100 .250 +	1400 1200		.006 - .015 .006 - .015	.008 - .020 .006 - .015

- Reduce sfm by 20% for Face Mills when channel milling
- **FPT(Feed per tooth) shown at lower limit can be increased up to 2 times depending upon application
- FPT reflects 40% increase to compensate for 45 degree chip thinning
- ***In order of preference, uncoated carbide reduce sfm 20%

Operating guidelines for ChaseQuad TSF and TDM End mill using Inserts: XOMT 06, SPMT 09, SPMG 09, SPMT 11, SPMG 11, SPMT 14, SPMG 14

Material	BRINELL	D.O.C.	SFM	BEST GRADES BY PREFERENCE	FPT XOMT 06	FPT SPM-09	FPT SPM-11	FPT SPM-14
1117 1020 (MS) 1018	80	.040	1300	8020, 7030, P30	.003 - .007	.004 - .008	.004 - .008	.005 - .010
	to 175	.150	1150		.003 - .006	.004 - .008	.004 - .008	.005 - .010
		.250	1000		.003 - .005	.004 - .008	.004 - .008	.005 - .010
1045 4620 1095 8620 1060 9310 4140 52100 L1 W2 L6	175	.040	900	8020, 7030, P30	.003 - .007	.004 - .007	.004 - .007	.005 - .010
	to 225	.150	800		.003 - .006	.004 - .007	.004 - .007	.005 - .010
		.250	600		.003 - .005	.004 - .007	.004 - .007	.005 - .010
4150 4140HT 9260 S7 4340	275	.040	600	8020, 7030, DX2	.003 - .007	.004 - .006	.004 - .006	.004 - .008
	to 325	.150	500		.003 - .006	.004 - .006	.004 - .006	.004 - .008
		.250	400		.003 - .005	.004 - .005	.004 - .005	.004 - .008
TOOL STEEL D2	200	.040	400	8020, 7030, P30	.002 - .005	.004 - .006	.004 - .006	.004 - .008
	to 250	.150	350		.002 - .004	.004 - .006	.004 - .006	.004 - .008
		.250	300		.002 - .004	.004 - .005	.004 - .005	.004 - .008
TOOL STEEL A2 A6 P20	200	.040	915	8020, 7030, P30	.002 - .005	.004 - .006	.004 - .006	.004 - .007
	to 250	.150	700		.002 - .004	.004 - .006	.004 - .006	.004 - .007
		.250	600		.002 - .004	.004 - .005	.004 - .005	.004 - .007
STAINLESS STEEL 303, 316 15-5PH	135	.040	800	8020, DX2, 7030	.003 - .006	.004 - .007	.004 - .007	.004 - .007
	to 185	.150	700		.003 - .005	.004 - .006	.004 - .006	.004 - .007
		.250	500		.003 - .005	.004 - .005	.004 - .005	.004 - .007
STAINLESS STEEL 416 17-4PH	135	.040	1000	8020, P30, 7030	.002 - .005	.004 - .007	.004 - .007	.004 - .008
	to 185	.150	850		.002 - .004	.004 - .006	.004 - .006	.004 - .008
		.250	700		.002 - .004	.004 - .005	.004 - .005	.004 - .008
STAINLESS STEEL 13-8PH		.040	400	8020, DX2, 7030	.002 - .005	.003 - .005	.003 - .005	.004 - .007
		.150	300		.002 - .004	.003 - .005	.003 - .005	.004 - .007
		.250	200		.002 - .004	.003 - .005	.003 - .005	.004 - .007
INCONEL, HASTELLOY WASPALLOY		.040	150	8020, DX2, 7030	.002 - .005	.003 - .005	.003 - .005	.004 - .007
		.150	100		.002 - .004	.003 - .005	.003 - .005	.004 - .007
		.250	75		.002 - .004	.003 - .005	.003 - .005	.004 - .007
TITANIUM 6AL-4V		.040	180	8020, DX2, 7300	.002 - .005	.003 - .005	.003 - .005	.004 - .007
		.150	150		.002 - .004	.003 - .005	.003 - .005	.004 - .007
		.250	120		.002 - .004	.003 - .005	.003 - .005	.004 - .007
GRAY CAST IRON-CLASS 40-45-50	190	.040	1200	6030, 8020, K10	.003 - .005	.004 - .006	.004 - .006	.004 - .008
	to 220	.150	1000		.003 - .005	.004 - .006	.004 - .006	.004 - .008
		.250	800		.003 - .005	.004 - .006	.004 - .006	.004 - .008
DUCTILE CAST IRON-GRADE 65-45-12	140	.040	1000	6030, 8020, K10	.003 - .005	.004 - .006	.004 - .006	.004 - .008
	to 190	.150	850		.003 - .005	.004 - .006	.004 - .006	.004 - .008
		.250	700		.003 - .005	.004 - .006	.004 - .006	.004 - .008
DUCTILE CAST IRON-GRADE 80-55-06	190	.040	800	6030, 8020, P30	.003 - .005	.004 - .006	.004 - .006	.004 - .008
	to 225	.150	700		.003 - .005	.004 - .006	.004 - .006	.004 - .008
		.250	500		.003 - .005	.004 - .006	.004 - .006	.004 - .008
ALUMINUM 6061 T-6 7075 T-6		.040	max	K10, 8020, DX2	.005 - .020	.006 - .020	.006 - .020	.006 - .020
		.150	max		.005 - .015	.006 - .015	.006 - .015	.006 - .015
		.250	1200 min		.005 - .015	.006 - .015	.006 - .015	.006 - .015
72 BRASS 360 18 AMPCO 660 BRONZE	60RB	.040	1600	K10, 6030, 8020	.005 - .020	.006 - .020	.006 - .020	.006 - .020
	to 100RB	.150	1400		.005 - .015	.006 - .015	.006 - .015	.006 - .015
		.250	1200		.005 - .015	.006 - .015	.006 - .015	.006 - .015

- Reduce chip load by 28% for End Mills .750 dia and under at D.O.C.>.150



Operating guidelines for Ext. Flute Mills Overcut Shell Mills Series- TEF, TES Using Inserts SPMT09, SPMT11, SPMT14 & APKT17

(Feed per Effective flute by Cutter Diameter**)

Material	BHN	RADIAL WOC	MAX SFM	BEST GRADES	1.250 DIA	1.500 DIA	2.000 DIA	2.500 DIA	3.000 DIA	4.000 DIA
1117 1020 (MS) 1018	80 to 175	0.02**	1000	7030, 8020, P30	.024	.030	.035	.048	.056	.064
		DIA/8**	900		.008	.009	.009	.011	.011	.011
		DIA/4**	800		.006	.007	.007	.008	.008	.008
		DIA/2	700		.005	.006	.006	.006	.006	.006
1045 4620 1095 8620 1060 9310 ACD 4140 W2 L6 52100 L1	175 to 225	0.02**	700	7030, 8020, P30	.024	.030	.035	.048	.056	.064
		DIA/8**	600		.008	.009	.009	.011	.011	.011
		DIA/4**	500		.006	.007	.007	.008	.008	.008
		DIA/2	400		.005	.006	.006	.006	.006	.005
4150 4140HT 4340 9260 S7	275 to 325	0.02**	600	8020, 7030, P30	.016	.022	.030	.042	.049	.056
		DIA/8**	500		.006	.008	.008	.009	.009	.009
		DIA/4**	400		.005	.006	.006	.007	.007	.007
		DIA/2	300		.004	.005	.005	.005	.005	.005
TOOL STEEL A2 A6 D2 P20	200 to 250	0.02**	450	8020, 7030, P30	.016	.022	.030	.042	.049	.056
		DIA/8**	450		.006	.008	.008	.009	.009	.009
		DIA/4**	350		.005	.006	.006	.007	.007	.007
		DIA/2	250		.004	.005	.005	.005	.005	.005
STAINLESS STEEL 303, 316 15-5PH	135 to 185	0.02**	600	8020, 7030, P30	.016	.022	.030	.042	.049	.056
		DIA/8**	600		.006	.008	.008	.009	.009	.009
		DIA/4**	500		.005	.006	.006	.007	.007	.007
		DIA/2	400		.004	.005	.005	.005	.005	.005
STAINLESS STEEL 416 17-4PH	135 to 185	0.02**	700	8020, 7030, P30	.024	.030	.035	.048	.056	.064
		DIA/8**	600		.008	.009	.009	.011	.011	.011
		DIA/4**	500		.006	.007	.007	.008	.008	.008
		DIA/2	400		.005	.006	.006	.006	.006	.006
STAINLESS STEEL 13-8PH		0.02**	400	8020, 7030, DX2	.016	.022	.030	.042	.049	.056
		DIA/8**	300		.006	.008	.008	.009	.009	.009
		DIA/4**	200		.005	.006	.006	.007	.007	.007
		DIA/2	150		.004	.005	.005	.005	.005	.005
INCONEL, HASTELLOY WASPAL- LOY		0.02**	150	8020, 7030, DX2	.016	.022	.030	.042	.049	.056
		DIA/8**	120		.006	.008	.008	.009	.009	.009
		DIA/4**	100		.005	.006	.006	.007	.007	.007
		DIA/2	75		.004	.005	.005	.005	.005	.005
TITANIUM 6AL-4V		0.02**	180	8020, 7300, DX2	.016	.022	.030	.042	.049	.056
		DIA/8**	170		.006	.008	.008	.009	.009	.009
		DIA/4**	150		.005	.006	.006	.007	.007	.007
		DIA/2	120		.004	.005	.005	.005	.005	.005
GRAY CAST IRON-CLASS 40-45-50	190 to 220	0.02**	700	6030, K10, 8020	.024	.030	.035	.048	.056	.064
		DIA/8**	500		.008	.009	.009	.011	.011	.011
		DIA/4**	400		.006	.007	.007	.008	.008	.008
		DIA/2	400		.005	.006	.006	.006	.006	.006
DUCTILE / NODULAT CAST IRON-GRADE 65-45-12	140 to 190	0.02**	700	6030, K10, P30	.024	.030	.035	.048	.056	.064
		DIA/8**	500		.008	.009	.009	.011	.011	.011
		DIA/4**	400		.006	.007	.007	.008	.008	.008
		DIA/2	400		.005	.006	.006	.006	.006	.006
DUCTILE / NODULAT CAST IRON-GRADE 80-55-06	190 to 225	0.02**	700	6030, K10, P30	.024	.030	.035	.048	.056	.064
		DIA/8**	500		.008	.009	.009	.011	.011	.011
		DIA/4**	400		.006	.007	.007	.008	.008	.008
		DIA/2	400		.005	.006	.006	.006	.006	.006
ALUMINUM BRASS BRONZE		0.02**	1500+	K10, 8020, DX2	.040	.044	.050	.060	.070	.080
		DIA/8**	1500+		.015	.015	.015	.015	.015	.015
		DIA/4**	1500+		.012	.012	.012	.012	.012	.012
		DIA/2	1500+		.010	.010	.010	.010	.010	.010

- ** FPT Adjusted to compensate for radial chip thinning FPT Above can be increased as Much as 50% depending upon application
- Decrease SFM 20% when width of cut(WOC) Exceeds DIA/1.3 (3/4 of cutter DIA) or consider using single stage end mills or face Mills-TE90AP, TFM90AP; Insert APKT1705 in Multiple passes to desired depth

Operating guidelines for Z-Mill, Face Mills series TFM55HN
using HNCF100510-MR, -ML, -EM Inserts

Material	BRINELL HARDNESS	D.O.C. (Depth Of Cut)	MAX SFM	BEST GRADES*** BY PREFERENCE	FPT** HNCF 100510
GRAY CAST IRON-CLASS 40-45-50	190 TO 220	.040	1000	6030, K10	.006 ~ .017
		.100	850		.006 ~ .014
	220	.310	700	KB90	.006 ~ .014
		max .040	2950		.003 ~ .006
DUCTILE/NODULAR CAST IRON-GRADE 65-45-12	140 TO 190	.040	900	6030, K10	.006 ~ .017
		.100	750		.006 ~ .014
	190	.310	600	KB90	.006 ~ .014
		max .040	2300		.003 ~ .006
DUCTILE/NODULAR CAST IRON-GRADE 80-55-06	190 TO 225	.040	700	6030, K10	.006 ~ .017
		.100	600		.006 ~ .014
	225	.310	450	KB90	.006 ~ .014
		max .040	1950		.003 ~ .006

- Reduce SFM by 20% when channel milling
- **Higher FPT reflects increase to compensate for 35 degree lead angle chip thinning.
- ***In order of preference, uncoated carbide reduce SFM 20%



Grades

Grade Chart

TaeguTec Grade	ISO Rating	Coating	HrA	Grain Size	Workpiece material	Feature
K10	K10 - K20 N10 - N20	Uncoated	92.8	Fine	Malleable & Gray Cast Iron over 220HB, Aluminum, Non-ferrous alloys, Copper, Plastics, High-temp alloys	High Wear resistance Dry Milling
P30	P25 - P35	Uncoated	91.7	Medium	Steels	High Shock Resistance, High Wear & Crater resistance
DX2	M30 - M40 K30 - K40	Uncoated	90.2	Fine	Stainless steels, Alloy steels, Cast Iron, High-temp alloys	Wet or Dry Milling, High Mechanical Shock & Wear resistance
NEW CT5000	P10 - P30 K10 - K20 M15 - M30 N10 - N25 H10 - H25	Cermet	92.5	Fine	Steels, Mold Steels, Stainless steels, Cast iron & Aluminum	High Wear & Shock Resistance for finishing to medium machining
NEW CT3000	P05 - P25 K05 - K15 M05 - M20 N05 - N20 H05 - H20	Cermet	93.0	Fine	Steels, Mold Steels, Cast iron, Stainless steels & Aluminum alloy	High Wear Resistance for finishing application
KT7300	P20 - P40	CVD TiCN-TiN	89.9	Coarse	Steels	Dry Milling at high Speeds & Lower FPT
TT6030	K05 - K20 N05 - N20 H05 - H20	PVD TiAlN	92.8	Fine	Malleable & Gray Cast Iron over 220HB, Aluminum, Non-ferrous alloys, Copper, Plastics, High-temp alloys	Dry & Wet Milling, High Wear Resistance
TT7030	P15 - P40	PVD TiAlN	91.7	Medium	Steels	Dry Milling, High wear & Crater resistance
NEW TT7070	P20 - P40	PVD TiAlN	92.0	Medium	Alloy Steels, Mold Steels, Cast Iron	Dry Milling High wear resistance
TT8020	M30 - M40 P30 - P45 K20 - K40 N15 - N30 S20 - S30	PVD TiCN	90.2	Fine	Stainless steels, Alloy steels, High-temp alloys, Cast Iron	All purpose Grade, High Mechanical & Shock resistance
NEW TT8030	M20 - M40 P25 - P45 K15 - K40 S15 - S30	PVD TiAlN	90.2	Fine	Alloy Steels, Stainless steels, High-temp alloys, Cast Iron	All purpose Grade, High Mechanical & Shock resistance
NEW TT9030	M10 - M30 P15 - P35 K10 - K30 S10 - S25	PVD TiAlN	92.8	Micro	Stainless steels, Alloy steels, High-temp alloys, Cast Iron	All purpose Grade, Dry & Wet milling
KT8600	P05 - P20 K05 - K20 H05 - H25	PVD TiAlN	92.8	Micro	Mold Steels, Cast Iron, Stainless steels	Wet or Dry Milling, High Mechanical Wear and Thermal Shock resistance

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