NEW PRODUCT NEWS

MEGA TECH
METAL WORK CO.,LTD

Taegutec Parting & Grooving Line

QUADRUSH
PARTING & GROOVING

TQJ 20 Insert Line Expansion

Speed to Feed

ADVANCE CUTTING
TaeguTec

TaeguTec
Member IMC Group

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KEY POINT

TaeguTec extends TQJ 20 insert cutting width up to 3.0 mm and adds the TT9080 grade.

To meet diverse market demands, the TQJ 20 insert line now includes a wider cutting width and the TT9080 grade. Going forward, this expansion means TaeguTec provides excellent machining solutions to wider markets, including not only small parts machining but also diverse machining such as CNC machines and the automotive parts industry.

Please see the previous NPN for further information on the QUAD-RUSH's TQJ/S 20 inserts.

QUADRUSH PARTING & GROOVING

NPN Download

TQJ 20 Inserts Features

- Expanded cutting width: 1.0-3.0 mm
- Excellent chip breaking and outstanding surface finish due to the J-type positive chip breaker
- Addition of the TT9080 grade following the TT4430 grade for small parts

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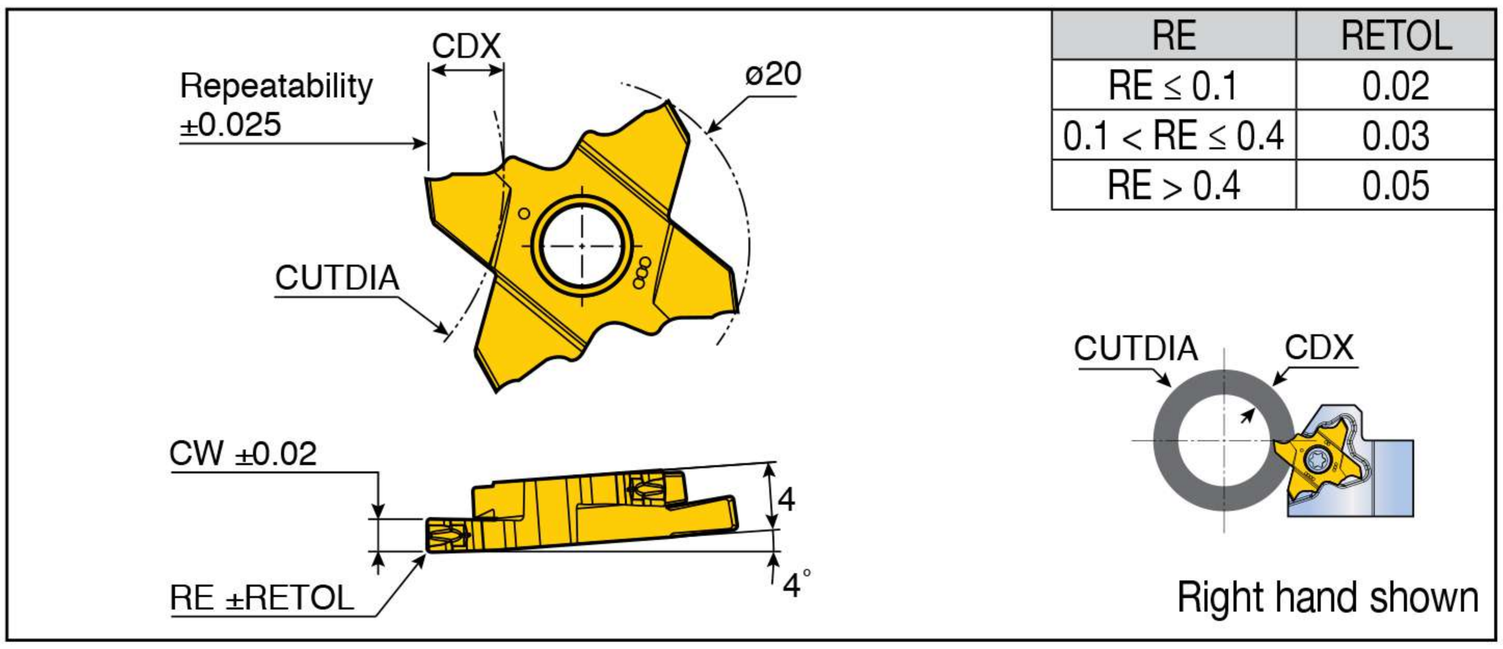
TQJ 20

QUADRUSH PARTING & GROOVING

Precision grooving and parting inserts with J-type chip breaker



RE	RETOL
RE ≤ 0.1	0.02
0.1 < RE ≤ 0.4	0.03
RE > 0.4	0.05

Right hand shown

Designation		Feed (mm/rev)	CW	RE	CDX	CUTDIA					Grade	
						CDX ≤ 2.7	≤ 3.0	≤ 3.5	≤ 4.0	≤ 5.0	TT9080	TT4430
TQJ	20-1.00-0.10-R/L	0.03-0.07	1.00	0.10	2.7	N.L.	-	-	-	-	●	●
	20-1.25-0.10-R/L new	0.03-0.07	1.25	0.10	3.0	N.L.	170	-	-	-	●	●
	20-1.50-0.20-R/L	0.03-0.08	1.50	0.20	5.0	N.L.	170	70	50	16	●	●
	20-1.75-0.20-R/L new	0.03-0.08	1.75	0.20	5.0	N.L.	170	70	50	16	●	●
	20-2.00-0.20-R/L	0.04-0.10	2.00	0.20	5.0	N.L.	170	70	50	16	●	●
	20-2.50-0.20-R/L new	0.04-0.10	2.50	0.20	5.0	N.L.	170	70	50	16	●	●
	20-3.00-0.20-R/L new	0.05-0.12	3.00	0.20	5.0	N.L.	170	70	50	16	●	●

▸ N.L.: No limit

●: Standard items

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Recommended Cutting Conditions

Grooving and Turning

ISO	Material		Condition	Tensile Strength (N/mm^2)	Hardness HB	Material No.	Cutting speed Vc(m/min)	
							TT9080	TT4430
P	Non-alloy steel and cast steel, free cutting steel	<0.25%C	Annealed	420	125	1	100-200	90-180
		>=0.25%C	Annealed	650	190	2	100-180	90-160
		<0.55%C	Quenched and tempered	850	250	3	80-160	80-140
		>=0.55%C	Annealed	750	220	4	80-160	80-140
			Quenched and tempered	1000	300	5	70-130	70-110
	Low alloy steel and cast steel (less than 5% of alloying elements)		Annealed	600	200	6	100-160	90-140
			Quenched and tempered	930	275	7	80-160	80-150
				1000	300	8	80-150	80-130
				1200	350	9	80-130	80-120
	High alloy steel, cast steel and tool steel		Annealed	680	200	10	90-130	90-120
			Quenched and tempered	1100	325	11	50-80	50-70
M	Stainless steel and cast steel		Ferritic / martensitic	680	200	12	80-170	80-150
			Martensitic	820	240	13	80-150	80-130
			Austenitic	600	180	14	80-170	80-150
K	Grey cast iron (GG)		Ferritic / pearlitic		160	15		
			Pearlitic		250	16		
	Cast iron nodular (GGG)		Ferritic		180	17		
			Pearlitic		260	18		
	Malleable cast iron		Ferritic		130	19		
			Pearlitic		230	20		
N	Aluminum-wrought alloy		Not cureable		60	21		
			Cured		100	22		
	Aluminum-cast, alloyed	<=12% Si	Not cureable		75	23		
			Cured		90	24		
		>12% Si	High temperature		130	25		
	Copper alloys	>1% Pb	Free cutting		110	26		
			Brass		90	27		
			Electrolitic copper		100	28		
	Non-metallic		Duroplastics, fiber plastics			29		
			Hard rubber			30		
S	High temp. alloys	Fe based	Annealed		200	31	30-50	30-40
			Cured		280	32	20-40	20-30
		Ni or Co based	Annealed		250	33	20-30	15-25
			Cured		350	34	15-20	15-20
			Cast		320	35	15-20	15-20
	Titanium and Ti alloys		Pure	Rm 400		36	130-170	100-150
			Alpa+bata alloys cured	Rm 1050		37	40-70	40-60
H	Hardened steel		Hardened		55HRC	38		
			Hardened		60HRC	39		
	Chilled cast iron		Cast		400	40		
	Cast iron nodular (GGG)		Hardened		55HRC	41		

Steel Stainless steel Cast iron Nonferrous High temp. alloys Hardened steel

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Information

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