

NEW PRODUCT NEWS

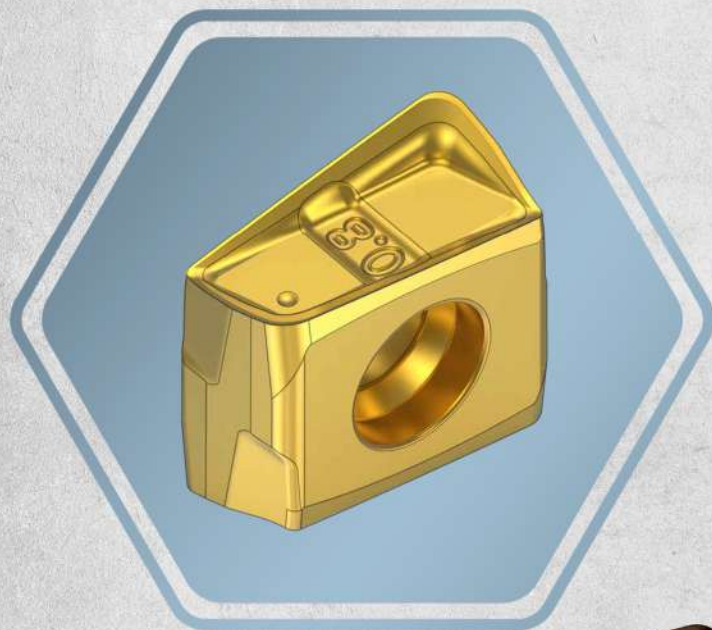
mgt
MEGA TECH
METALWORK

Taegutec Milling Line

TANGSPEED

TANGENTIAL MILL

LPKU Insert Corner R size Expansion



ADVANCE
TaeguTec **CUTTING**

TaeguTec
Member IMC Group

KEY POINT

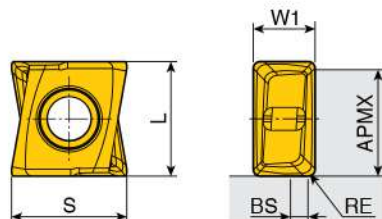
TaeguTec expands the TANG-SFEED LPKU insert corner R size range.

The high-rigidity TANG-SFEED line, capable of smooth cutting due to its optimal edge design, ensures excellent performance across a wide range of applications. To meet the growing demand for the tangential product line, TaeguTec has expanded the corner R sizes.

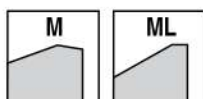
Insert size	Corner R size (mm)						
	0.0	0.2	0.4	0.8	1.2	1.6	2.4
LPK(H)U 05	●	●	●	●			
LPK(H)U 09			●	●	●	●	
LPKU 14				●		●	●

LPK(H)U

Inserts



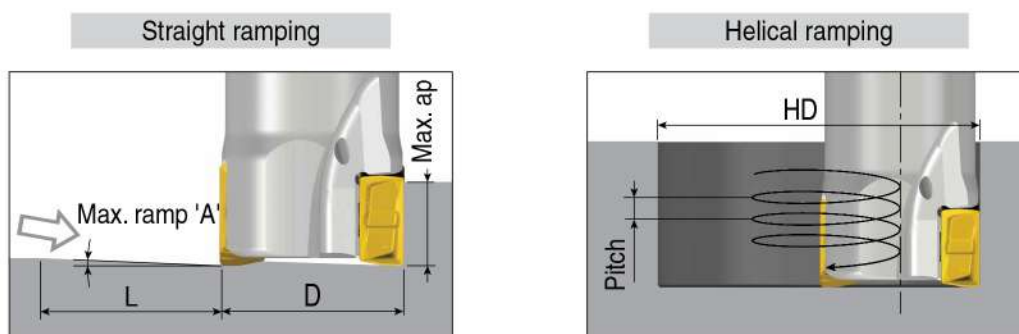
Size	Dimension (mm)					
	L	W1	S	APMX	BS	RE
05	5.0	2.7	4.9-5.2	4.6	-	0-0.8
09	9.0	4.5	8.3-8.6	8.3	0-0.6	0.4-1.6
14	13.5	6.7	13.1-13.5	12.5	0-0.9	0.8-2.4



Insert	Designation	Recommended machining conditions		Coated								Uncoated		
		ap (mm)	Feed (mm/tooth)	TT9080	TT9030	TT8080	TT8020	TT8525B	TT7080	TT7515	TT6080	TT5525	K10	
	LPKU 050204 PNR-M	1.0-3.5	0.08-0.04	●		●					●			
	050208 PNR-M new	1.0-3.5	0.08-0.04	●							●			
	090404 PNR-M	2.5-6.0	0.15-0.06	●		●		●			●			
	090408 PNR-M	2.5-6.0	0.15-0.06	●		●		●			●			
	090412 PNR-M new	2.5-6.0	0.15-0.06	●				●			●			
	090416 PNR-M	2.5-6.0	0.15-0.06	●		●		●			●			
	140708 PNR-M	3.5-10.0	0.20-0.10	●		●		●			●			
	140716 PNR-M new	3.5-10.0	0.20-0.10	●				●			●			
	140724 PNR-M new	3.5-10.0	0.20-0.10	●				●			●			
	LPHU 050200 PNR-ML	0.1-3.5	0.08-0.03									●		
	050202 PNR-ML	0.2-3.5	0.10-0.03									●		
	050204 PNR-ML	0.3-3.5	0.10-0.03	●		●					●	●		
	LPHU 090404 PNR-M	2.5-6.0	0.15-0.06			●					●			

●: Standard items

Ramping Data



LPK(H)U 05

(unit: mm)

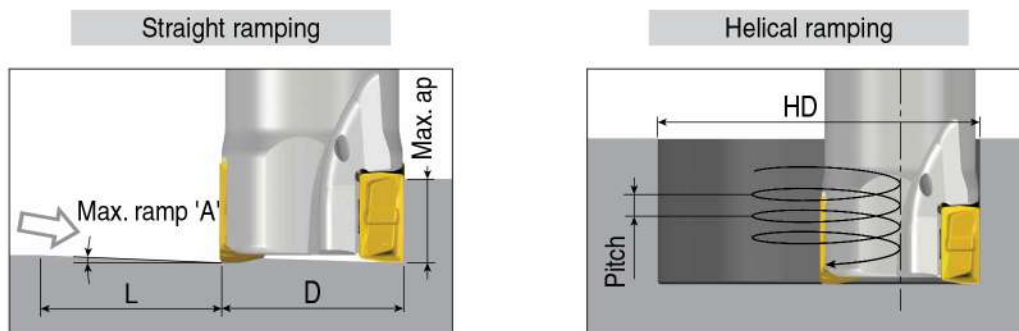
Cutter dia.(D)	Straight ramp down			Helical ramp down		
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.
Ø10	1.8	4.6	142	16.8	20	0.6
Ø11	1.6	4.6	160	18.8	22	0.6
Ø12	1.5	4.6	176	20.8	24	0.6
Ø13	1.3	4.6	195	22.8	26	0.6
Ø16	1.0	4.6	251	28.8	32	0.6
Ø20	0.8	4.6	330	36.8	40	0.6
Ø25	0.6	4.6	439	46.8	50	0.6
Ø32	0.4	4.6	586	60.8	64	0.6

LPK(H)U 09

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down		
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.
Ø20	1.4	8.3	328	33	40	1.0
Ø25	1.1	8.3	432	43	50	1.0
Ø32	0.8	8.3	594	57	64	1.1
Ø40	0.6	8.3	793	73	80	1.0
Ø50	0.4	8.3	1057	93	100	1.0
Ø63	0.3	8.3	1359	119	126	1.0

Ramping Data



LPKU 14

(unit: mm)

Cutter dia.(D)	Straight ramp down			Helical ramp down		
	Max. ramp (A°)	Max. ap	Min. length (L)	Min. dia.(HD)	Max. dia.(HD)	Max. pitch/rev.
Ø40	0.9	12.5	754	69	80	1.5
Ø50	0.7	12.5	1023	89	100	1.5
Ø63	0.5	12.5	1302	115	126	1.5
Ø80	0.4	12.5	1790	149	160	1.5
Ø100	0.3	12.5	2387	189	200	1.4
Ø125	0.2	12.5	2865	239	250	1.5
Ø160	0.2	12.5	3581	309	320	1.6
Ø200	0.1	12.5	4775	389	400	1.5

CONTACT US

mgt

MEGA TECH
METALWORK



MEGA TECH METALWORK CO.,LTD (Headquarter)



Tel : 02-943-1591



Fax : 02-943-1592



Line ID : @mgt_metalwork



Email : sales.m@mgtg.co.th



Web : <https://www.mgtg.co.th/>



17/4 Soi Ramintra 89
Ramintra Khannayao
Bangkok 10230



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