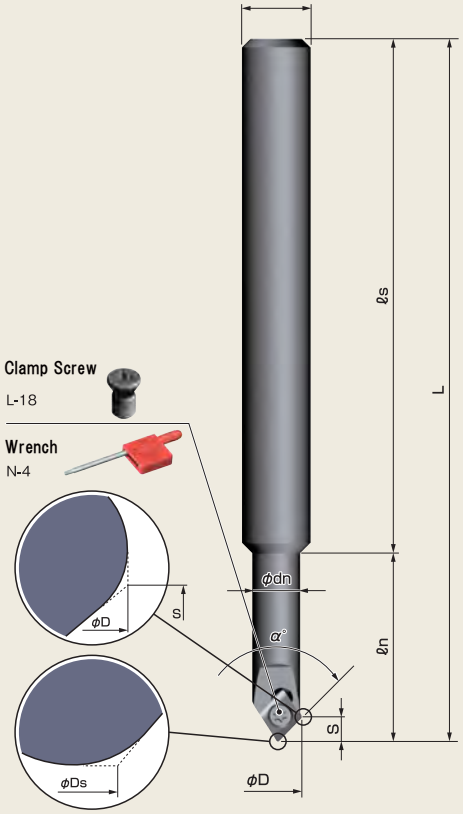
Momimen nano

1Blade

Smallest Indexable Tools !

- Developed screw-on type smallest Insert (under-neck diameter φ6mm) This will be smallest insert in the existing market.
- Small diameter long neck prevents tool interference when processing in the deep area
- You can use this tool for engraving process




Centering


Corner chamfering


Bore chamfering


V-Grooving

※ This tool cannot be used with drilling machines

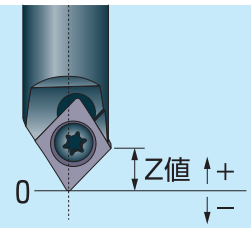
Dish Chamfering Processing (Min. Blade Diameter～Max. Blade Diameter)

90°	120°
φ0.6mm～φ6mm	φ0.6mm～φ7.4mm

Body

Model. No.	Blades	Dimensions (mm)								α°
		φD	φDs	φd	φdn	L	ℓs	ℓn	S	
SCN0845E	1	6	0.58	8	5.6	82	60	22	2.8	90°
SCN0830E	1	7.4	0.52	8	7	82	60	22	2.0	120°

※ Insert is not equipped as standard accessory.Please purchase it separately
※ Clamp screw wrench we have standard equipment.



Z-value compensate standard

※ Please note that this value may be getting some errors

α°= 90° → +0.3

α°= 120° → +0.15

[Example]
Correct Z-value (-2.5)to -2.2 in case of φ5mm spot drilling process

Cutting Conditions

Centering

Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.02～0.03	4,000～	ENGX040102 AC15N	Yes
Alloy Steel	0.02～0.03	4,000～	ENGX040102 AC15N	Yes
Stainless Steel	0.01～0.02	4,000～	ENGX040102 AC15N	Yes
Aluminum,Resin,Brass	0.05～0.08	4,000～	ENGX040102F ZC16N	Yes
Castings	0.04～0.06	4,000～	ENGX040102 AC15N	None

Chamfering

Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.07～0.1	4,000～	ENGX040102 AC15N	Yes
Alloy Steel	0.07～0.1	4,000～	ENGX040102 AC15N	Yes
Stainless Steel	0.05～0.1	4,000～	ENGX040102 AC15N	Yes
Aluminum,Resin,Brass	0.1～0.15	4,000～	ENGX040102F ZC16N	Yes
Castings	0.07～0.12	4,000～	ENGX040102 AC15N	None

V-groove processing

Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.05～0.07	4,000～	ENGX040102 AC15N	Yes
Alloy Steel	0.05～0.07	4,000～	ENGX040102 AC15N	Yes
Stainless Steel	0.03～0.05	4,000～	ENGX040102 AC15N	Yes
Aluminum,Resin,Brass	0.05～0.08	4,000～	ENGX040102F ZC16N	Yes
Castings	0.04～0.06	4,000～	ENGX040102 AC15N	None

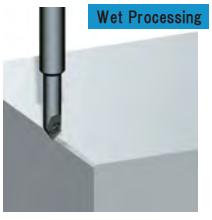
- In case of bore chamfering process by Z-axis only,please take same cutting condition of centering process
- According to the shape of work, large or small chamfering amount and position of blade, the cutting condition will have to be adjusted . In case of processing with large amount chamfer,please take reducing cutting condition
- In case of chanfering process of Stainless Steel, please take the down cutting

Processing Example

[Perimetery C2 Chamfering]

- Body : SCN0845E
- Insert : ENGX040102 AC15N

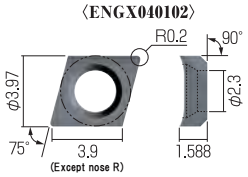
- Material・・・・・・・・・ SUS304
- Rotation Speed・・・ 5,000r.p.m.
- Feed (Z-axis) ・・・・ 350mm/min
- Cutting Depth・・・・・ C2
- Cutting Oil・・・・・・・ Yes


Wet Processing

Result

Good!
No secondary burrs and No chattering after processing

Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
〈ENGX040102〉 	NEW ENGX040102F ZC16N	Fine particles Carbide	Sharp edge	None	2	12
	ENGX040102 AC15N	Fine particles Carbide	Honing edge	AlCrN	2	12

⚠ Blade edge by V-grooving and centering processing could not be a perfect vertex angle