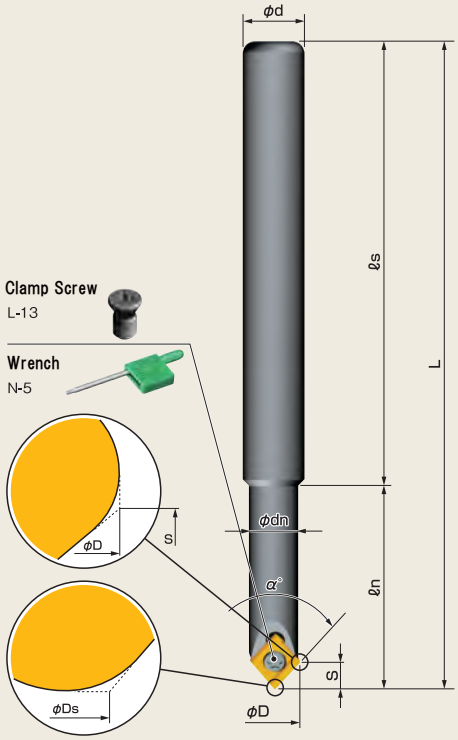
Chibimomi

1Blade

This Tool !

- Center-drilling and chamfer process can be done by this Tool. You can reduce numbers of ATC tooling by using this tool and make high productivity!
- Original insert shape desined by us solved risk of Chattering and breakage



- Carbide made shank increased rigidity and limit of spotting has been much improved with the standard long shank, Protruding limit is now high.
- This tool have (φ10) Shank and (φ9) Blade, and can be used at narrow area also

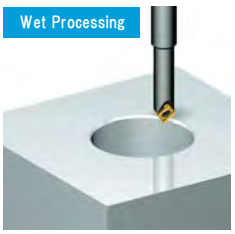
Processing Example

[φ100 Bore Chamfering]

- Body : SCM1045C
- Insert : C22GUX NK5050

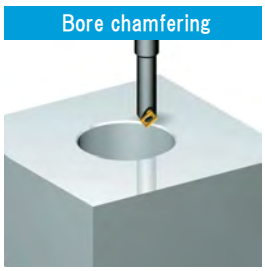
- Material ····· SUS304
- Rotation Speed ··· 5,000r.p.m.
- Feed (Z-axis) ···· 500mm/min
- Cutting Depth ···· C1
- Cutting Oil ····· Yes

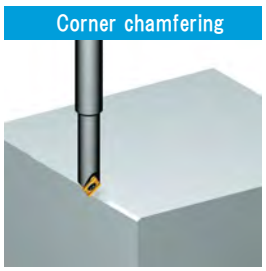
Wet Processing



Result

Good!
800pcs process has successfully done without size change, secondary burrs and alternant sound during processing





※ This tool cannot be used with drilling machines

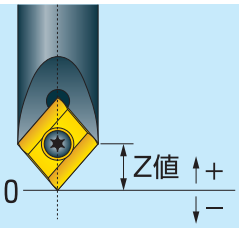
Dish Chamfering Processing (Min. Blade Diameter～Max. Blade Diameter)

90°
φ0.6mm～φ9mm

Body

Model. No.	Blades	Dimensions (mm) φD	φDs	φd	φdn	L	ℓs	ℓn	S	α°	Carbide Shank
SCM1045C	1	9	0.5	10	8	105	72	33	4.4	90°	
SCM1045CL	1	9	0.5	10	8	165	132	33	4.4	90°	
SCM1045CL-CB	1	9	0.5	10	8	165	145	20	4.4	90°	●

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



Z-value compensate standard
※ Please note that this value may be getting little errors

α°= 90° → +0.2

[Example]
Correct Z-value(-4.0)to -3.8in case of φ8mm spot drilling process

Cutting Conditions

Centering

Material	Feed Per Blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.05～0.08	2,000～3,500	C22GUX NK2020	Yes
Alloy Steel	0.05～0.08	2,000～3,500	C22GUX NK3030	Yes
Stainless Steel	0.05～0.08	2,000～3,500	C22GUXT AC16N	Yes
Aluminum,Resin,Brass	0.05～0.1	3,000～	C22GUX NK1010	Yes
Castings	0.05～0.08	2,000～3,500	C22GUX NK3030	Yes

Chamfering

Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.1～0.15	2,000～	C22GUX NK2020	Yes
Alloy Steel	0.1～0.15	2,000～	C22GUX NK3030	Yes
Stainless Steel	0.1～0.15	2,000～	C22GUXT AC16N	Yes
Aluminum,Resin,Brass	0.1～0.15	3,000～	C22GUX NK1010	Yes
Castings	0.1～0.15	2,000～	C22GUX NK3030	Yes

- In case of bore chamfering prosess 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 process with large amount chamfer, please take reducing cutting condition
- In case of chamfering process of stainless steel,please take the down cutting

Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
〈C22GUX〉 R0.2 7° φ6.35 φ2.8 80° 6 2.38 (Except nose R)	C22GUX NK1010	Carbide K10	Sharp edge	None	2	12
	C22GUX NK2020	Carbide M20	Honing edge	None	2	12
	C22GUX NK3030	Carbide M20	Honing edge	TiN	2	12
	C22GUX NK5050	Carbide K10	Sharp edge	TiN	2	12
	C22GUX NK6060	Carbide M20	Honing edge	TiAℓN	2	12
	C22GUX NK8080	Carbide K10	Sharp edge	TiAℓN	2	12
	C22GUXF AC16N	Fine particles Carbide	Sharp edge	AlCrN	2	12
	C22GUXT AC16N	Fine particles Carbide	Honing edge	AlCrN	2	12

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