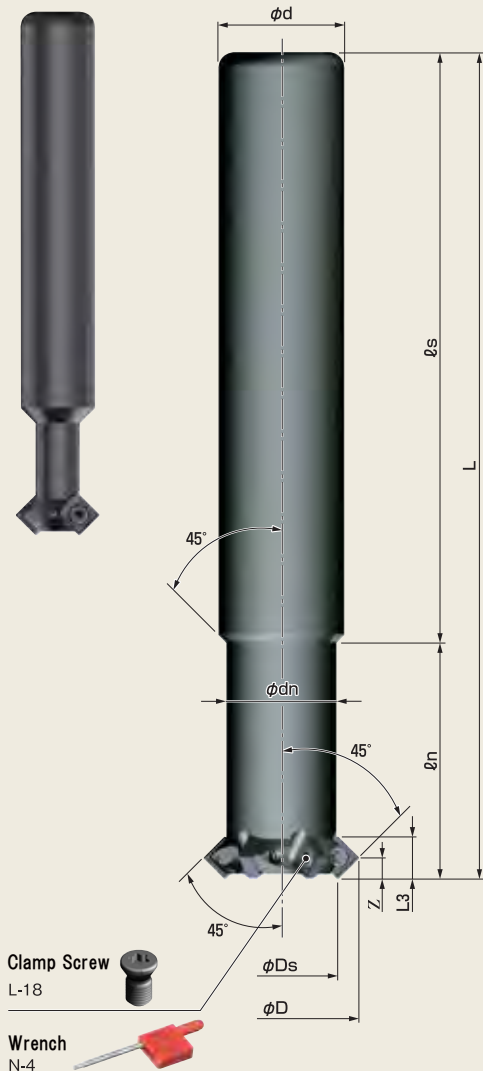


Smallest Multi-Blade Tools!

Enable front/reverse chamfering and V-grooving

TR10-12S

TR16-20S



| Model No. | Capacity |
|-----------|-----------------|
| | Bore chamfering |
| TR10-12S | φ6mm~φ11.24mm |
| TR16-20S | φ14.5mm~φ19.8mm |

※ Steel: C2 is maximum
 ※ Stainless Steel: C1 is maximum

Body

| Model No. | Blades | Dimensions (mm) | | | | | | | | |
|-----------|--------|-----------------|------|-----|----|-----|----|----|------|------|
| | | φD | φDs | φdn | φd | L | Ls | Ln | L3 | Z |
| TR10-12S | 2 | 11.24 | 6 | 6 | 10 | 70 | 55 | 15 | 5.45 | 2.72 |
| TR16-20S | 6 | 19.8 | 14.5 | 14 | 16 | 105 | 75 | 30 | 5.45 | 2.72 |

※ Inset is not supplied as standard accessory. Please order separately.
 ※ Clamp screw wrench are supplied as standard accessory

Cutting Conditions

| | | SPEW030102 | SPMT030102 | |
|------------------------|---------------------|-------------------------|------------|---------|
| material Model | | ZA10N | ZA20N | AC16N |
| Material | Feed per blade (fz) | Cutting speed (m / min) | | |
| General Steel | 0.08~0.2 | | 100~200 | 100~200 |
| Alloy Steel | 0.08~0.2 | | 100~200 | 100~200 |
| Stainless Steel | 0.08~0.2 | | 100~200 | 100~200 |
| Aluminum, Resin, Brass | 0.08~0.3 | 250~800 | | |
| Cast Steel | 0.08~0.3 | | 100~200 | 100~200 |

- According to the shape of work, clamp condition and large or small chamfering amount and position of blade, the cutting condition will have to be adjusted.
- In case of large amount chamfering process, please reduce the condition
- In case of chamfering process of Stainless steel, kindly take down cutting

Processing Example

[Corner Chamfering]

- Body : TR16-20S
- Inset : SPMT030102 AC16N

- Material : S50C
- Rotation Speed : 7,000r.p.m.
- Table feed : 4,000mm/min
- Cutting Depth : 1mm
- Cutting Oil : None



Result

Good!
 Without secondary burrs and chattering

Insert

| Figure | Model.No. | Material | Blade Shape | Coating | Usable corner | Quantity per box |
|---------------------|--------------------------------|------------------------|-------------|---------|---------------|------------------|
| <p>(SPEW030102)</p> | SPEW030102 ZA10N | Carbide K10 | Sharp edge | None | 4 | 12 |
| <p>(SPMT030102)</p> | SPMT030102 ZA20N | Carbide M20 | Sharp edge | None | 4 | 12 |
| | NEW SPMT030102 AC16N | Fine particles Carbide | Sharp edge | AlCrN | 4 | 12 |