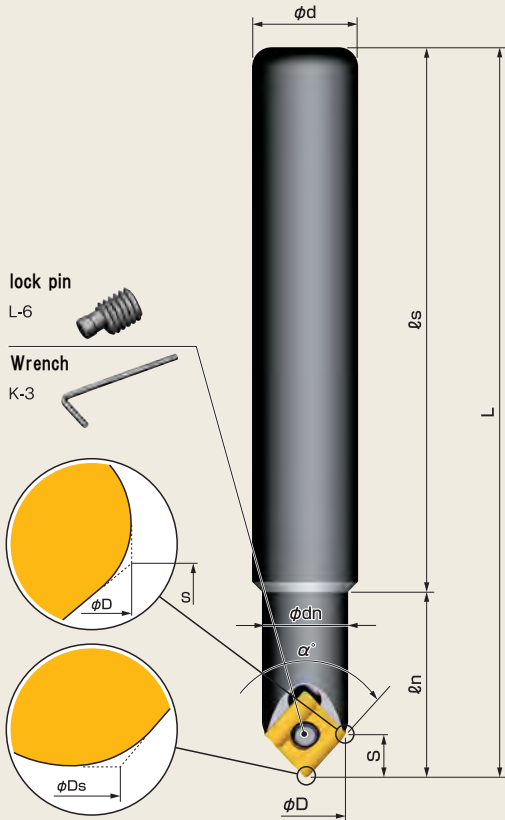


This Tool !

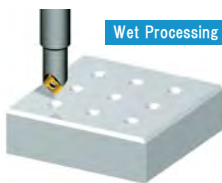
- Center-drilling and chamfer process can be done by this Tool. You can reduce numbers of ATC tooling by using this tool and make high productivity!
- Original insert shape designed by us solved risk of Chattering and breakage



Processing Example

[Φ8 of Centering Processing, Circumference C3 Chamfering]

- Body : SC1645C
- Insert : C32GUX NK3030
- Material : S45C
- Rotation Speed : 3,500r.p.m
- Feed (Z-axis) : 100mm/min
- Feed (X-axis) : 300mm
- Cutting Oil : Yes



Result

Good! No secondary burrs and no chattering process

Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
	C32GUX NK2001	Cermet	Honing edge	None	2	12
	C32GUX NK1010	Carbide K10	Sharp edge	None	2	12
	C32GUX NK2020	Carbide M20	Honing edge	None	2	12
	C32GUX NK3030	Carbide M20	Honing edge	TiN	2	12
	C32GUX NK5050	Carbide K10	Sharp edge	TiN	2	12
	C32GUX NK6060	Carbide M20	Honing edge	TiAlN	2	12
	C32GUX NK8080	Carbide K10	Sharp edge	TiAlN	2	12
	C32GUX AC15D	Fine particles Carbide	Honing edge	AlCrN	2	12
	C32GUX AC25D	Fine particles Carbide	Sharp edge	AlCrN	2	12
	C32GUX HSS	HSS	Sharp edge	None	2	12
	C32GUX HSS TiN	HSS	Sharp edge	TiN	2	12

Blade edge by centering processing could not be a perfect vertex angle
When mounting insert, please do not take reverse tightening.

Due to the eccentricity looking mechanism, poor accuracy or breakage of insert may be occurred
When replacing insert, please confirm whether you have been taking reserve tightening or not.

...P.114

Centering



Dish chamfering



Corner chamfering



※ This tool cannot be used with drilling machines

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

90°
φ2mm ~ φ13.5mm

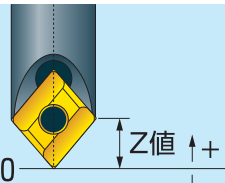
118°
φ2mm ~ φ16.15mm

Body

Model. No.	Blades	Dimensions (mm)								α°
		φD	φDs	φd	φdn	L	ls	ln	S	
SC1045C	1	13.5	1.0	10	13	110	82	28	6.3	90°
SC1245C	1	13.5	1.0	12	13	110	82	28	6.3	90°
SC1645C	1	13.5	1.0	16	13	110	82	28	6.3	90°
SC1645CL	1	13.5	1.0	16	13	200	172	28	6.3	90°
SC1630C	1	16.15	0.39	16	16.5	110	82	28	4.6	118°
SC1630CL	1	16.15	0.39	16	16.5	200	172	28	4.6	118°

※ Insert is not equipped as standard accessory. Please purchase it separately.

※ Lock Pin is supplied as standard accessory



Z-value compensate standard

※ Please note that this value may be getting little errors

α° = 90° → +0.45

α° = 118° → +0.2

[Example]

Correct Z-value(-6.0) to -5.55in case of φ12mm spot drilling process

Cutting Conditions

Centering				
Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.05~0.1	1,500~3,000	C32GUX NK2020	Yes
Alloy Steel	0.05~0.1	1,500~3,000	C32GUX NK3030	Yes
Stainless Steel	0.05~0.1	1,500~3,000	C32GUX AC15D	Yes
Aluminum, Resin, Brass	0.05~0.2	3,000~	C32GUX NK1010	Yes
Castings	0.05~0.1	1,500~3,000	C32GUX NK3030	Yes

Chamfering				
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.1~0.2	2,000~	C32GUX NK2001	None
Alloy Steel	0.1~0.2	2,000~	C32GUX NK2001	None
Stainless Steel	0.1~0.2	2,000~	C32GUX AC15D	Yes
Aluminum, Resin, Brass	0.1~0.2	3,000~	C32GUX NK1010	Yes
Castings	0.1~0.2	2,000~	C32GUX NK2001	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 process with large amount chamfer, please take reducing cutting condition

● In case of chamfering process of stainless steel, please take the down cutting