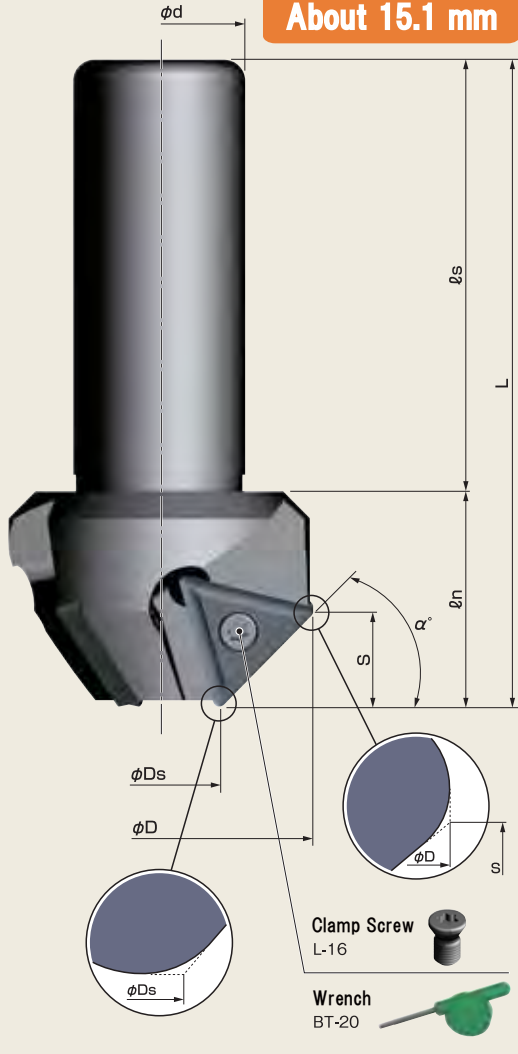


C15 Chamfering!

Economical and Heavy Cutting

Maximum blade length
About 15.1 mm



Corner Chamfering



Processing Example

[C15 Chamfering]

- Body : BNK4558T
- Insert : TNMX270412 AC15N
- Material.....SUS304
- Rotation Speed...800r.p.m
- Table feed.....100mm/min
- Cutting Depth...C15
- Cutting Oil.....None

Dry cutting



Result

Good!

By one pass process,C15 Chamfer has been successfully made without chattering

Body

Model. No.	Blades	Dimensions (mm)							α°
		ϕD	ϕD_s	ϕd	L	ℓs	ℓn	S	
BNK4546T-1	1	46.5	12	32	120	80	40	17.2	45°
BNK3062T	3	62.2	20	32	120	80	40	11.8	30°
BNK4558T	3	58.2	23.8	32	120	80	40	17.2	45°
BNK6058T	3	58.2	33.8	32	120	80	40	21.1	60°

※ Insert is not equipped as standard accessory

※ Clamp screw and wrench are supplied as standard accessory

Cutting Conditions

		TNEX270412	TNEQ270412	TNMX270412
Material Model		ZA10T	ZA10N	AC15N
Material	Feed per blade (fz)	Rotation speed (r.p.m.)		
General Steel	0.04~0.12			800~1500
Alloy Steel	0.04~0.12			800~1500
Stainless Steel	0.04~0.12			600~1200
Aluminum, Resin, Brass	0.06~0.18	2,500~4,000		
Cast Steel	0.04~0.12		800~1,500	

● According to the shape of work, clamp condition and large or small chamfering amount, the cutting condition will have to be adjusted.

● Yellow marked condition is recommended for the material listed

● In case of chamfering process of Stainless steel, kindly take down cutting

Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable Corner	Quantity per box
<p><TNEX270412></p>	TNEX270412 ZA10T	Carbide K10	Sharp edge	None	2	3
<p><TNEQ270412></p>	TNEQ270412 ZA10N	Carbide K10	Honing edge	None	6	3
<p><TNMX270412></p>	TNMX270412 AC15N	Fine particles Carbide	Honing edge	AlCrN	6	3