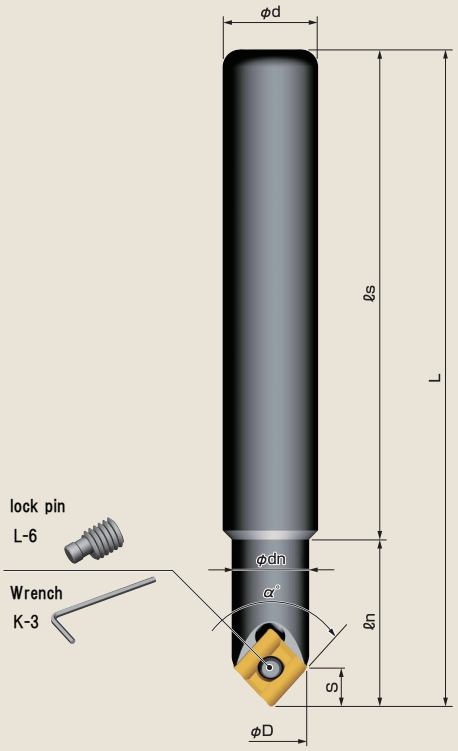
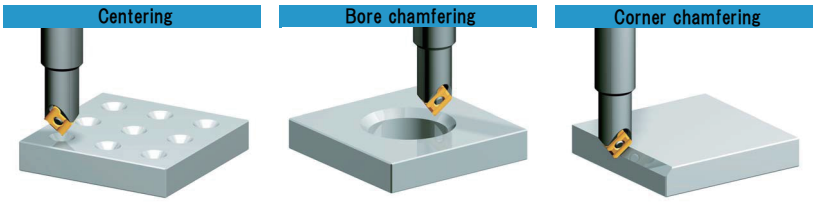
This Tool !

- 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





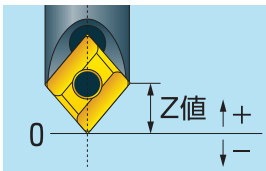
※ This tool cannot be used with drilling machines

Model. No.	Capacity	α°
	Bore chamfering	
SC1045C	φ2mm～φ13.5mm	90°
SC1245C	φ2mm～φ13.5mm	90°
SC1645C	φ2mm～φ13.5mm	90°
SC1645CL	φ2mm～φ13.5mm	90°
SC1630C	φ2mm～φ16.15mm	118°
SC1630CL	φ2mm～φ16.15mm	118°

Body

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

※ Inset 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

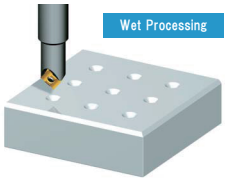
Momimen → + 0.45

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

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

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

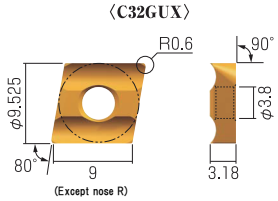
Chamfering

Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.1～0.2	2,000～	C32GUX NK2001	Yes
Alloy Steel	0.1～0.2	2,000～	C32GUX NK2001	Yes
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	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
〈C32GUX〉	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
	NEW 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 twhether you have been taking reserve tightening or not.