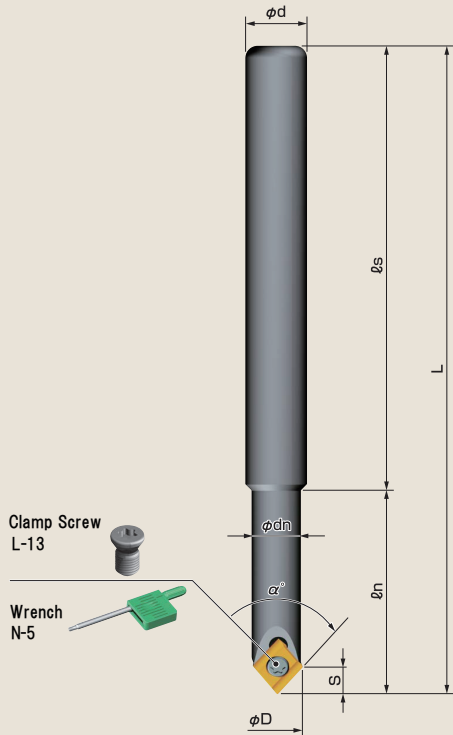## This Tool !

● 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


Clamp Screw
L-13

Wrench
N-5

● 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]   Wet Processing

■ Body : SCM1045C
■ Insert : C22GUX NK3030

● Material·········SCr415
● Rotation Speed···2,200r.p.m
● Feed (Z-axis)····150mm/min
● Cutting Depth····0.5mm
● Cutting Oil·······Yes
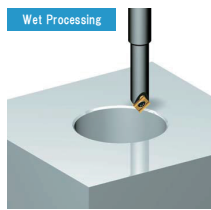
Result

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

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Centering	Bore chamfering	Corner chamfering
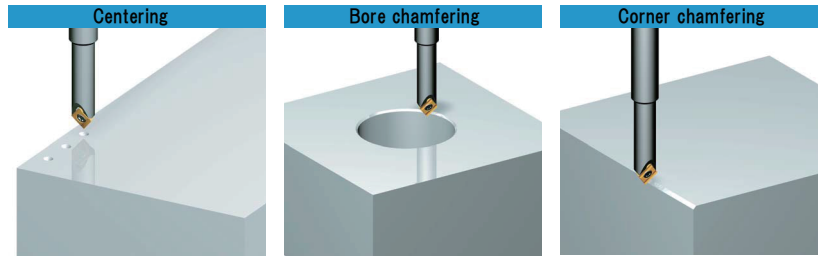
※ This tool cannot be used with drilling machines

Model. No.	Capacity Bore chamfering	α°
SCM1045C	φ0.6mm～φ9mm	90°
SCM1045CL	φ0.6mm～φ9mm	90°
SCM1045CL-CB	φ0.6mm～φ9mm	90°

■ Body

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

※ Inset is not equipped as standard accessory. Please purchase it spearately.

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

Chibimomi ➡ +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	C22GUX NK6060	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～	C22GUX NK6060	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

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■ Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
⟨C22GUX⟩	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

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