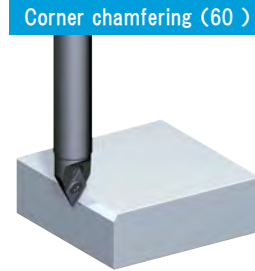
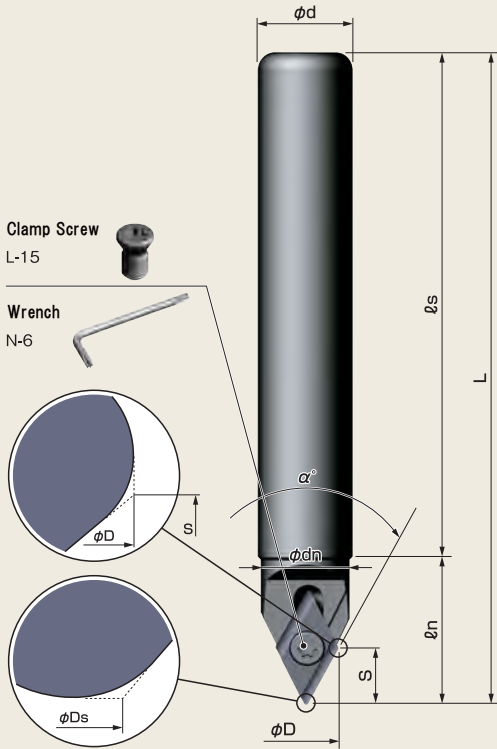


## This Tool !

- Throw-away type tool ensured no alignment work
- Center-drilling and chamfer process can be done by tool. You can reduce numbers of ATC tooling, and ensured high speed cutting and high productivity.
- Slim body (shank:  $\phi 16\text{mm}$  and  $\phi 12\text{mm}$  blade) is suitable for work at narrow area



※ This tool cannot be used with drilling machines

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

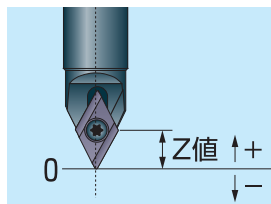
60°  
 $\phi 1.2\text{mm} \sim \phi 11.88\text{mm}$

### Body

Model. No.	Blades	Dimensions (mm)								$\alpha^\circ$
		$\phi D$	$\phi D_s$	$\phi d$	$\phi d_n$	L	$l_s$	$l_n$	S	
SC1660DS	1	11.88	0.97	16	15	110	85	25	9.4	60°
SC1660DSL	1	11.88	0.97	16	15	200	175	25	9.4	60°

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

※ Clamp screw wrench we have standard equipment.



### Z-value compensate standard

※ Please note that this value may be getting little errors

$\alpha^\circ = 60^\circ \rightarrow +0.82$

[Example]... Correct Z-value (-8.66) to -7.84 in case of  $\phi 10\text{mm}$  centering process

### Cutting Conditions

Centering				
Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.03~0.05	3,000~3,500	DCET11X304 AC15N	Yes
Alloy Steel	0.03~0.05	3,000~3,500	DCET11X304 AC15N	Yes
Stainless Steel	0.03~0.05	3,000~3,500	DCET11X304 AC15N	Yes
Aluminum, Resin, Brass	0.03~0.08	3,000~	DCET11X304 ZA10N	Yes
Castings	0.03~0.05	3,000~3,500	DCET11X304 AC15N	Yes

Chamfering				
Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.1~0.15	2,000~	DCET11X304 AC15N	Yes
Alloy Steel	0.1~0.15	2,000~	DCET11X304 AC15N	Yes
Stainless Steel	0.1~0.15	2,000~	DCET11X304 AC15N	Yes
Aluminum, Resin, Brass	0.1~0.2	3,000~	DCET11X304 ZA10N	Yes
Castings	0.1~0.15	2,000~	DCET11X304 AC15N	Yes

● 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 chamfer, please take reducing cutting condition

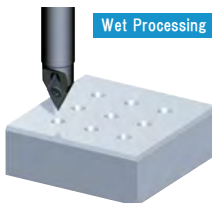
● In case of chamfering process of stainless steel, please take the down cutting

### Processing Example

[ $\phi 12$  of Centering, Perimetry chamfering]

- Body : SC1660DS
- Insert : DCET11X304 AC15N

- Material.....S45C
- Rotation Speed...3,500r.p.m
- Feed (Z-axis) ...100mm/min
- Cutting Depth...300mm/min
- 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
	DCET11X304 ZA10N	Carbide K10	Sharp edge	None	2	12
	DCET11X304 AC15N	Fine Particles Carbide	Sharp edge	AlCrN	2	12
	DCET11X304E AC16N	Fine Particles Carbide	Honing edge	AlCrN	2	12



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