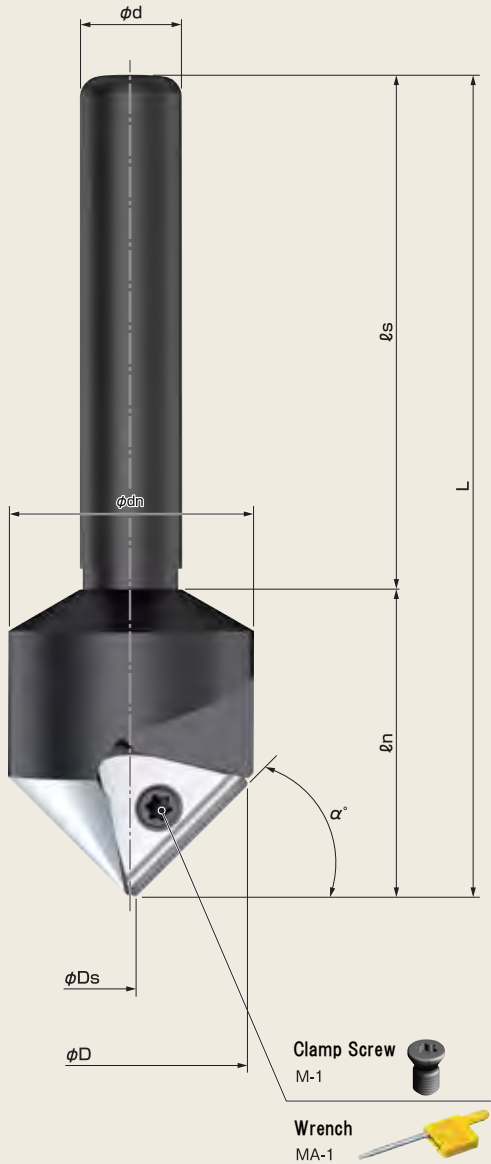


For Drilling Machine

- Ideal for small hole chamfering
- High Heiss steel durable to a main body material



Bore chamfering



Capacity Bore chamfering

$\phi 1\text{mm} \sim \phi 22\text{mm}$

Body

Model No.	Blades	Dimensions (mm)							α°
		ϕD	ϕD_s	ϕd	ϕd_n	L	ℓ_s	ℓ_n	
TBM4522T	1	22.9	1	10	24	80	50	30	45°

- ※ 1 piece TNEGXR160304XR HSS Insert is supplied as standard accessory
- ※ Clamp Screw, lock pin and wrench are supplied as standard accessory

Cutting Conditions

Material	Rotation Speed (r.p.m.)	
	TNEG160304XR HSS TNXT160304FR	TNEG160304ER HSS TNXT160304ER HSS TNXT160304ER HSS AICrN
General Steel	160~320	200~500
Alloy Steel		
Aluminum, Resin, Brass		
Castings		

- Depending on the Machine's rigidity, above conditions may not be Suitable.
In case of soft material like Aluminum, Copper etc ,reduce rotation speed accordingly
In case the chattering is occurred, rotation speed will have to be reduced and use cutting oil
Please use our original Insert for our tool
- According to the shape, clamp condition and volume of chamfering amount the above cutting condition have to be adjusted. For large amount chamfering, the rate will have to be reduced

Processing Example

[$\phi 2\text{mm}$ Bore mouth chamfering]

- Body : TBM4522T
- Insert : TNEG160304ER HSS
- Material..... S50C
- Rotation Speed... 320r.p.m.
- Use machine..... Bench type Drilling Machine

Result
Good finish



Insert

Figure	Model.No.					
<p><TNEG160304></p>	TNEG160304XR HSS	HSS	Sharp edge	None	2	3
	TNEG160304ER HSS	HSS	Honing edge	None	2	3
<p><TNXT160304ER-TNXT160304FR></p>	NEW TNXT160304FR HSS	HSS	Sharp edge	None	3	3
	NEW TNXT160304ER HSS	HSS	Honing edge	None	3	3
	NEW TNXT160304ER HSS AICrN	HSS	Honing edge	AICrN	3	3