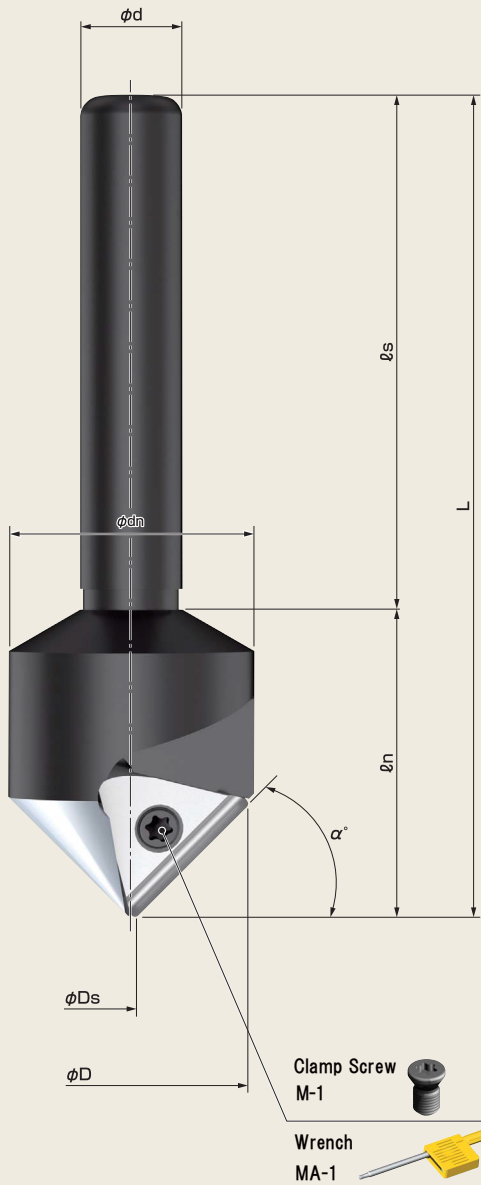


## For Drilling Machine

- 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)							$\alpha^\circ$
		$\phi D$	$\phi Ds$	$\phi d$	$\phi dn$	L	$\ell s$	$\ell n$	
<b>NEW</b> TBM4522T	1	22.9	1	10	24	80	50	30	45°

- ※ 1 piece TNEGXR160304ER HSS Insert is supplied as standard accessory
- ※ Clamp Screw, lock pin and wrench are supplied as standard accessory

#### Cutting Conditions

Material	TNEG160304XR HSS	<b>NEW</b> TNEG160304ER HSS
	Rotation Speed (r.p.m.)	
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



#### Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable Corner	Quantity per box
	TNEG160304XR HSS	HSS	Sharp edge	None	2	3
	<b>NEW</b> TNEG160304ER HSS	HSS	Honing edge	None	2	3