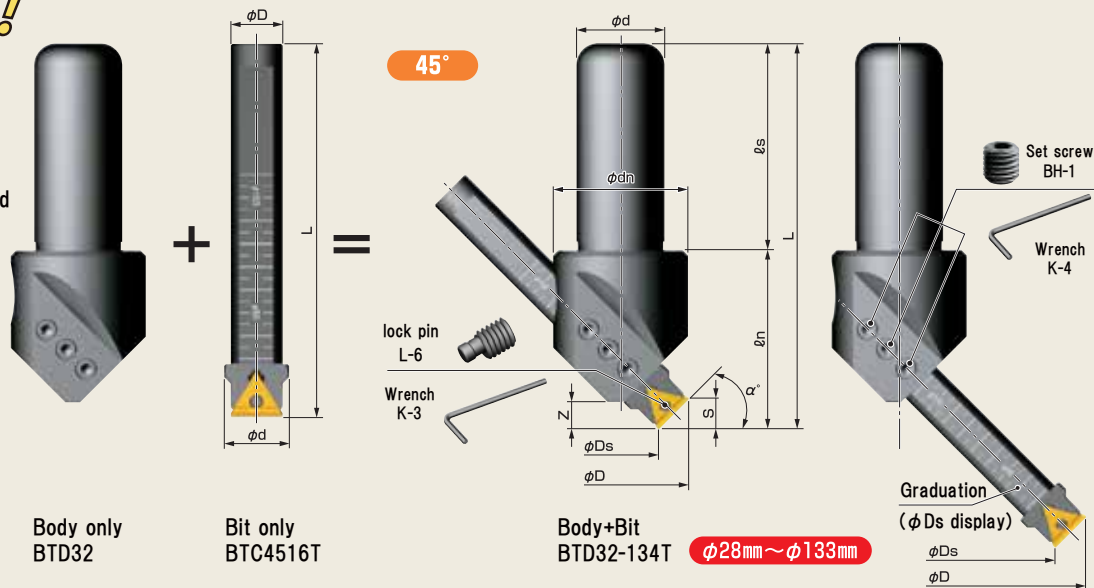


Bit Type!

- Expansion Bit type for wide range chamfering !
- Bore Chamfering Capacity: $\phi 28 \sim \phi 133$
- T32-type insert can be used

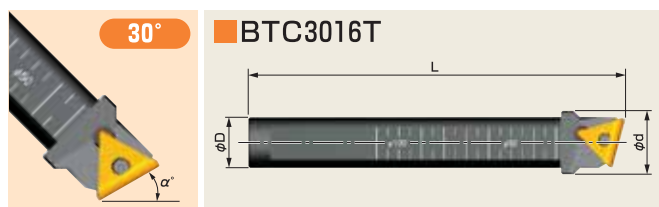


Model. No.	Blades	Dimensions (mm)									α°
		ϕD	ϕD_s	ϕd_n	ϕd	L	ℓ_s	ℓ_n	Z	S	
BTD32-134T	1	49.85 134.6	28 112.8	49	32	190 232.8	125	65 107.8	9.8 52.6	10.9	45°
BTD32				49	32	180.2	125	55.2			

Option Bit 45°

Model. No.	Dimensions (mm)		
	ϕD	ϕd	L
BTC4516T	16	20	115

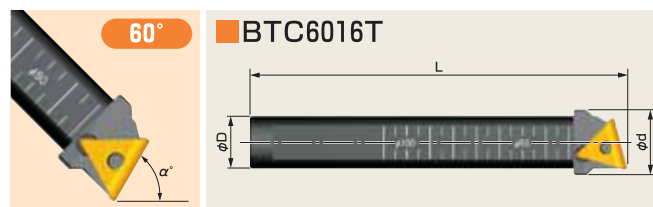
※ Inset is not supplied as standard accessory. Please order separately.
 ※ Lock Pin, set screw and wrench supplied as standard accessory

Option Bit

Model. No.	Dimensions (mm)		
	ϕD	ϕd	L
BTC3016T	16	20	119

BTC3016T(Optional) is mounted $\phi 28 \sim \phi 138 \text{ mm}$

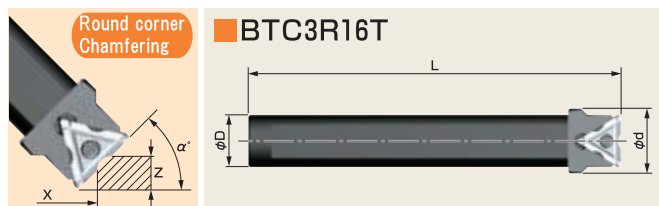
Blades	Dimensions (mm)									α°
	ϕD	ϕD_s	ϕd_n	ϕd	L	ℓ_s	ℓ_n	Z	S	
1	54.82 139.6	28 112.8	49	32	190 232.4	125	65 107.4	9.8 52.6	7.7	30°



Model. No.	Dimensions (mm)		
	ϕD	ϕd	L
BTC6016T	16	20	115

BTC6016T(Optional) is mounted $\phi 28 \sim \phi 126 \text{ mm}$

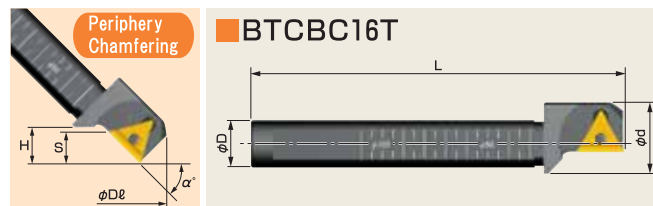
Blades	Dimensions (mm)									α°
	ϕD	ϕD_s	ϕd_n	ϕd	L	ℓ_s	ℓ_n	Z	S	
1	43.37 128.2	28 112.8	49	32	190 232.5	125	65 107.5	9.8 52.5	13.3	60°



Model. No.	Dimensions (mm)		
	ϕD	ϕd	L
BTC3R16T	16	20	115

BTC3R16T(Optional) is mounted R1~R3

Blades	Dimensions (mm)									α°
	ϕD	ϕD_s	ϕd_n	ϕd	L	ℓ_s	ℓ_n	Z	S	
1	49.9 134.6	28 112.8	49	32	190 232.4	125	65 107.4	9.8 52.6	10.9	45°



Model. No.	Dimensions (mm)		
	ϕD	ϕd	L
BTCBC16T	16	24	126

BTCBC16T(Optional) is mounted $\phi 28 \sim \phi 133 \text{ mm}$

Blades	Dimensions (mm)											α°
	ϕD	ϕD_s	ϕD_ℓ	ϕd_n	ϕd	L	ℓ_s	ℓ_n	Z	H	S	
1	50.6 134.7	28 112.8	71.5 155.2	49	32	194 236.5	125	69 111.5	13.9 56.4	(12.9)	10.9	~45°

※ Inset is not supplied as standard accessory. Please order separately.
 ※ Lock Pin, set screw and wrench supplied as standard accessory

Corner chamfering



Round corner Chamfering



Bore Chamfering



Periphery Chamfering



Processing Example

[$\phi 50$ Bore chamfering (C5)]

Dry cutting

- Body : BTD32-134T
- Insert : TT32GUR NK2001
- Material : S45C
- Rotation Speed : 400r.p.m
- Table feed : 24/min
- Cutting Depth : C5
- Cutting Oil : None



Result

Good! No secondary burrs and No chatter after processing

Cutting Conditions

T32MOR						
Material	Material Model	NK2001	NK1010	NK2020	NK3030	AC16N
Material	Feed per blade (fz)	Cutting speed (m / min)				
General Steel	0.08~0.2	200~250		150~200	150~200	
Alloy Steel	0.08~0.2	200~250		150~200	150~200	
Stainless Steel	0.08~0.2			100~150	100~150	100~150
Aluminum, Resin, Brass						
Castings	0.08~0.2	200~250 *FCD	100~150			

TT32GUR										
Material	Material Model	NK2001	NK1010	NK2020	NK3030	NK5050	NK8080	AC15N	HSS	HSS TiN
Material	Feed per blade (fz)	Cutting speed (m / min)								
General Steel	0.08~0.2	200~250		150~200	150~200			150~200	13~23	15~25
Alloy Steel	0.08~0.2	200~250		150~200	150~200			150~200	10~20	13~22
Stainless Steel	0.08~0.2			120~180	150~200		150~200 *SUS316	150~200	10~15	11~17
Aluminum, Resin, Brass	0.08~0.3		250~800			250~800	300~1,000		31~40	31~47
Castings	0.08~0.3	200~250 *FCD								

● 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 reduce cutting condition

● Yellow marked condition is recommended for the material listed

● In case of chamfering process of Stainless steel, kindly take down cutting

● For Bore Chamfering, please reduce the cutting condition to 1/3

Insert

Figure	Model, No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
	T32MOR NK2001	Cermet	Honing edge	None	6	12
	T32MOR NK1010	Carbide K10	Sharp edge	None	6	12
	T32MOR NK2020	Carbide M20	Honing edge	None	6	12
	T32MOR NK3030	Carbide M20	Honing edge	TiN	6	12
	T32MOR AC16N	Fine particles Carbide	Honing edge	AlCrN	6	12
	TT32GUR NK2001	Cermet	Honing edge	None	2	12
	TT32GUR NK1010	Carbide K10	Sharp edge	None	2	12
	TT32GUR NK2020	Carbide M20	Honing edge	None	2	12
	TT32GUR NK3030	Carbide M20	Honing edge	TiN	2	12
	TT32GUR NK5050	Carbide K10	Sharp edge	TiN	2	12
	TT32GUR NK8080	Carbide K10	Honing edge	TiAlN	2	12
	TT32GUR AC15N	Fine particles Carbide	Sharp edge	AlCrN	2	12
	TT32GURF TC16N	Fine particles Carbide	Honing edge	TiSiN	2	12
	TT32GUR HSS	HSS	Sharp edge	None	2	12
	TT32GUR HSS TiN	HSS	Sharp edge	TiN	2	12
	TNEA160304 TC16N	Fine particles Carbide	Honing edge	TiSiN	6	12
	T32GSR-1R NK2020	Carbide M20		None	3	3
	T32GSR-2R NK2020	Carbide M20		None	3	3
	T32GSR-3R NK2020	Carbide M20		None	3	3



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 whether you have been taking reserve tightening or not.

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