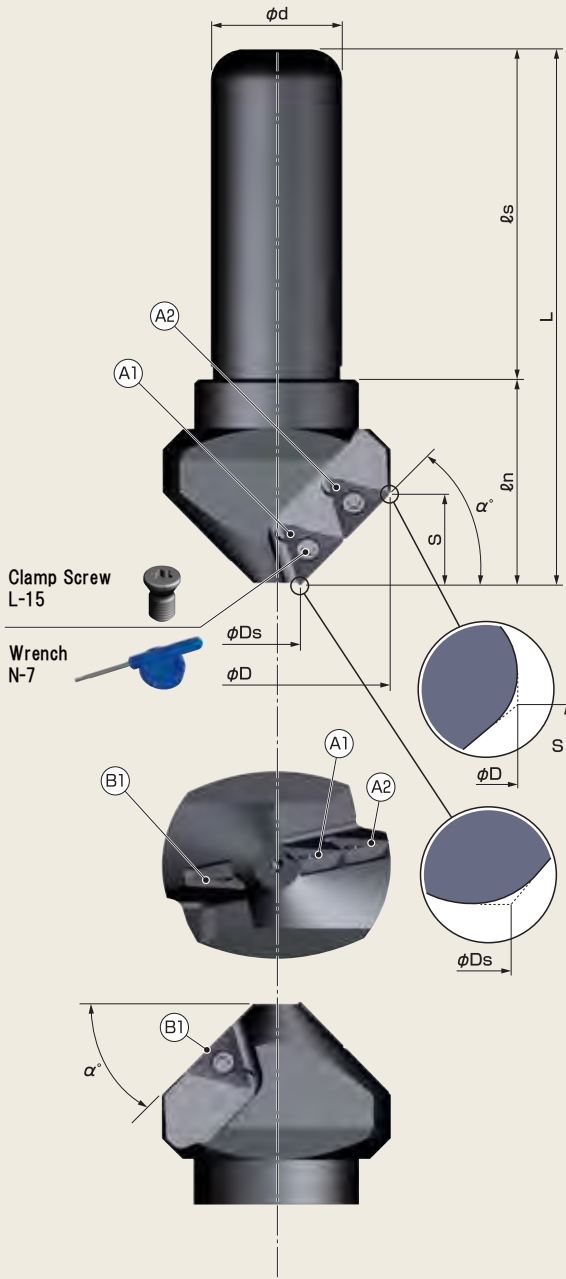


Various sizes

Bore Chamfering Various large and small !



! B1 * B2 is an auxiliary blade.
Cutting conditions, please be calculated with a single blade.

Bore Chamfering



| Model. No. | Capacity |
|------------|------------------|
| | Bore chamfering |
| TYOU3068TB | φ14.87mm~φ67.6mm |
| TYOU4555TB | φ12.5mm~φ55.4mm |
| TYOU6058TB | φ28.36mm~φ58.8mm |

※ we recommend the 10C below for chamfering amount.

| Model. No. | ! Remaining stage(step) Range |
|------------|--------------------------------------|
| TYOU3068TB | φ40.46mm~φ42.33mm |
| TYOU4555TB | φ33.25mm~φ34.65mm |
| TYOU6058TB | φ42.94mm~φ44.03mm |

Body

| Model. No. | Blades | Dimensions (mm) | | | | | | | α° |
|------------|--------|-----------------|------|----|-----|----|----|------|-----|
| | | φD | φDs | φd | L | ℓs | ℓn | S | |
| TYOU3068TB | 3 | 68.2 | 14.6 | 32 | 125 | 80 | 45 | 15.5 | 30° |
| TYOU4555TB | 3 | 55.8 | 12.1 | 32 | 130 | 80 | 50 | 21.8 | 45° |
| TYOU6058TB | 3 | 59.0 | 28.0 | 32 | 130 | 80 | 50 | 26.8 | 60° |

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

Cutting Conditions

| Material | Material Model | ZA10N | AC15N |
|------------------------|---------------------|-------------------------|-------|
| | Feed per blade (fz) | Cutting speed (m / min) | |
| General Steel | 0.05~0.1 | | 20~50 |
| Alloy Steel | 0.05~0.1 | | 20~50 |
| Stainless Steel | 0.05~0.1 | | 20~50 |
| Aluminum, Resin, Brass | 0.05~0.1 | 40~100 | |
| Castings | 0.05~0.1 | | 20~50 |

- According to the shape of work, clamp condition and large or small chamfering amount, the cutting condition will have to be adjusted.
- Yellow marked condition is recommended for the material listed
- In case of chamfering process of Stainless steel, kindly take down cutting

Processing Example

[φ21 C10 Bore Chamfering]

- Body : TYOU4555TB
- Inset : TXMT16T306 AC15N
- Material.....SUS304
- Rotation Speed...400r.p.m.
- Feed (Z-axis)Manual feed
- Cutting Depth...C5mm
- Cutting Oil.....none



Result
Good! No secondary burrs and No chattering after processing

Insert

| Figure | Model.No. | Material | Blade Shape | Coating | Usable corner | Quantity per box |
|--------|------------------|------------------------|-------------|---------|---------------|------------------|
| | TXMT16T306 ZA10N | Carbide K10 | Sharp edge | None | 3 | 12 |
| | TXMT16T306 AC15N | Fine particles Carbide | Honing edge | AICrN | 3 | 12 |