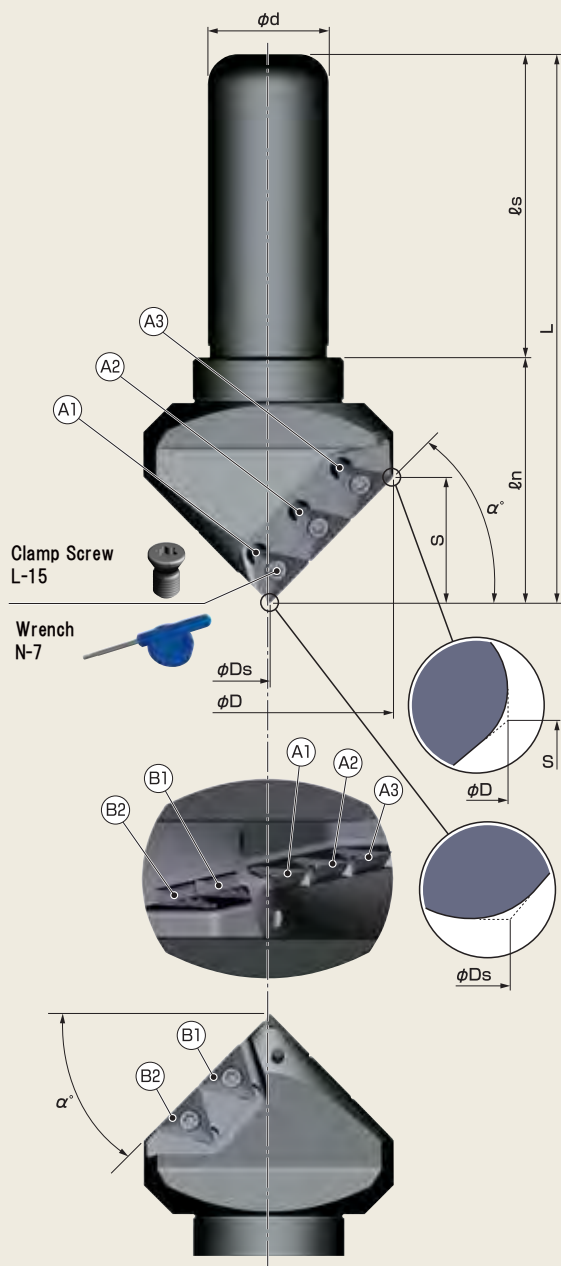


Various sizes

Bore Chamfering process from $\phi 1.0\text{mm} \sim \phi 81.4\text{mm}$ is possible !



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

Bore Chamfering



Model. No.	Capacity
	Bore chamfering
TYOU3082T	$\phi 1.0\text{mm} \sim \phi 81.4\text{mm}$
TYOU4567T	$\phi 1.2\text{mm} \sim \phi 66.6\text{mm}$
TYOU6066T	$\phi 20.4\text{mm} \sim \phi 66.8\text{mm}$

※ we recommend the 10C below for chamfering amount.

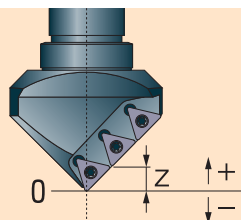
Model. No.	Remaining stage(step) Range
TYOU3082T	($\phi 26.59\text{mm} \sim \phi 28.46\text{mm}$) and ($\phi 54.33\text{mm} \sim \phi 56.20\text{mm}$)
TYOU4567T	($\phi 21.63\text{mm} \sim \phi 23.76\text{mm}$) and ($\phi 44.15\text{mm} \sim \phi 46.27\text{mm}$)
TYOU6066T	($\phi 34.93\text{mm} \sim \phi 36.02\text{mm}$) and ($\phi 50.95\text{mm} \sim \phi 52.04\text{mm}$)

Body

Model. No.	Blades	Dimensions (mm)							α°
		ϕD	ϕDs	ϕd	L	ℓs	ℓn	S	
TYOU3082T	5	82.1	0.71	32	145	80	65	23.5	30°
TYOU4567T	5	67.0	0.88	32	145	80	65	33.1	45°
TYOU6066T	5	67.0	20.0	32	155	80	75	40.7	60°

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

※ Clamp screw is equipped as standard accessory



Z-value compensate standard

※ Please note that this value may be getting little errors

$\alpha^\circ = 30^\circ \rightarrow +0.20$

$\alpha^\circ = 45^\circ \rightarrow +0.44$

$\alpha^\circ = 60^\circ \rightarrow +17.32$

[Example]

In case of $\phi 5\text{mm}$ Centering process at $\alpha^\circ = 45^\circ$
Correct Z-value (-2.5) to -2.06

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

[$\phi 25$ C10 Bore Chamfering]

- Body : TYOU4567T
- Insert : TXMT16T306
- Material.....SUS304
- Rotation Speed...320r.p.m.
- Feed (Z-axis)19.2/min
- Cutting Depth....C10
- Cutting Oil.....Yes

Result

Good! No secondary burrs and
No chattering after processing

Wet 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	AlCrN	3	12