# Dodekaeco

## Reduced Processing Cost!

- Reduced Processing Cost by by Tip with 3-corners
- Improved machinability and cutting chip disposability
- Achieved a long life by original tip(Ultrafine Particle Carbide+New coating



#### Processing Example



No secondary burrs and no chattering process Good Finish



※ can't use for Bench Drilling Machines



#### Body

Model. No.	blades	Dimensions (mm)							
		φD	<i></i> øDs	ød	L	ls	٤n	S	α°
NEW EMD2545T	1	37.1	1.2	25	150	110	40	18	90°
EMD3245T	1	37.1	1.2	32	150	110	40	18	90°
NEW EMD3230T	1	45.0	0.9	32	150	110	40	12.6	120°

Inset is not equipped as standard accessory. Please purchase it spearately.
Clamp screw wrench we have standard equipment.



### Cutting Conditions

Centering								
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant	Air blow			
General Steel	0.02~0.08	1,000~2,000	TXMT270506 AC16N	Yes	-			
Alloy Steel	0.02~0.08	1,000~2,000	TXMT270506 AC16N	Yes	-			
Stainless Steel	0.01~0.05	1,000~2,000	TXMT270506 AC16N	Yes	-			
Aluminum,Resin,Brass	0.02~0.08	1,500~3,800	TXMT270506 ZA10N	Yes	-			
Castings	0.02~0.08	1,000~2,000	TXMT270506 AC16N	-	Yes			

Chamfering									
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant	Air blow				
General Steel	0.03~0.15	1,000~2,000	TXMT270506 AC16N	None (%)	-				
Alloy Steel	0.03~0.15	1,000~2,000	TXMT270506 AC16N	None (%)	-				
Stainless Steel	0.03~0.15	1,000~2,000	TXMT270506 AC16N	Yes	-				
Aluminum,Resin,Brass	0.03~0.15	1,500~3,000	TXMT270506 ZA10N	Yes	-				
Castings	0.03~0.15	1,000~2,000	TXMT270506 AC16N	-	Yes				

ℜ Please used as needed.

Lower as much as possible the conditions in the case of finishing

• Work shape, Clamp condition, Amount of large and small, please adjust the conditions by cutting edge position In case the amount is large, please lower cutting condition and process.

In case Of Chamfering processing of Stainless Steel(SUS304etc) please process with Down-Cut.

🛕 Z value is -4.5mm becomes the upper limit when pefforming the processing

#### Model No. Material Blade Shape Usable corner Quantity per box Figure Coating **(TXMT270506)** 60° TXMT270506 ZA10N Carbide K10 Sharp edge None З 3 **5**.5 R0.6 TXMT270506 AC16N Fine particles Carbide Honing edge AICrN З 3 φ15.875

🔥 Blade edge by centering processing could not be a perfect vertex angle

Insert