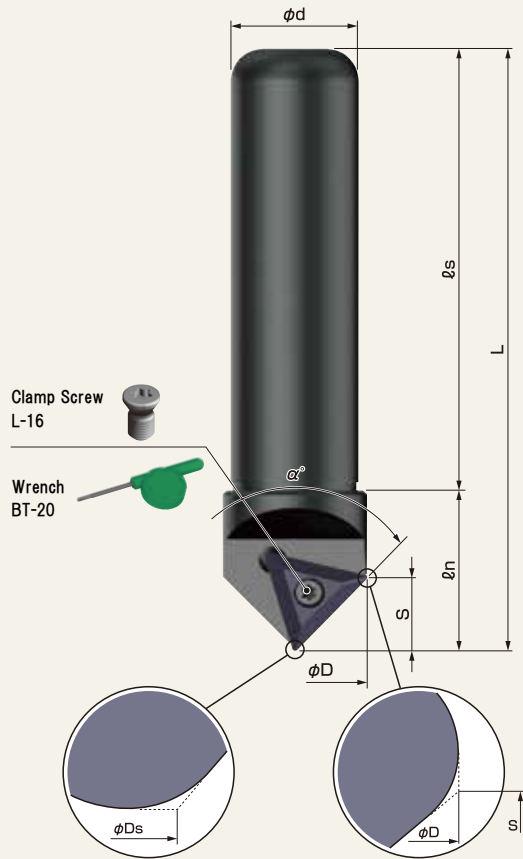


Reduced Processing Cost!

- Reduced Processing Cost 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

【 ϕ 30mm Centering Processing】

- Body : EMD3245T
- Insert : TXMT270506 AC16N

- Material..... SKD11
- Rotation Speed.... 1,500r.p.m
- Feed (Z-axis).....45mm/min
- Cutting Oil..... Yes



Result

No secondary burrs and no chattering process
Good Finish



※ can't use for Bench Drilling Machines

Dish Chamfering Processing
(Min. Blade Diameter-Max. Blade Diameter)

90°
 ϕ 1.5mm ~ ϕ 36.8mm

Body

Model. No.	Blades	Dimensions (mm)							α°
		ϕD	ϕDs	ϕd	L	ℓs	ℓn	S	
NEW EMD3245T	1	37.1	1.2	32	150	110	40	18	90°

※Tip is not equipped as standard. Please order it separately
※Clamp Screw/Wrench is supplied as standard acc.

Estimated Z value correction during Cutting processing
(this value the \square is a case where all ght errors out)

$\alpha = 90^\circ \rightarrow +0.5$

[Example]... In case of centering of 5 ϕ in EMD3245T, Z value is the place of -2.5 to -2 Zvalue

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

※ 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 performing the processing

Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
<p>〈TXMT270506〉</p>	NEW TXMT270506 ZA10N	Carbide K10	Sharp edge	None	3	3
	NEW TXMT270506 AC16N	Fine particles Carbide	Honing edge	AlCrN	3	3

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