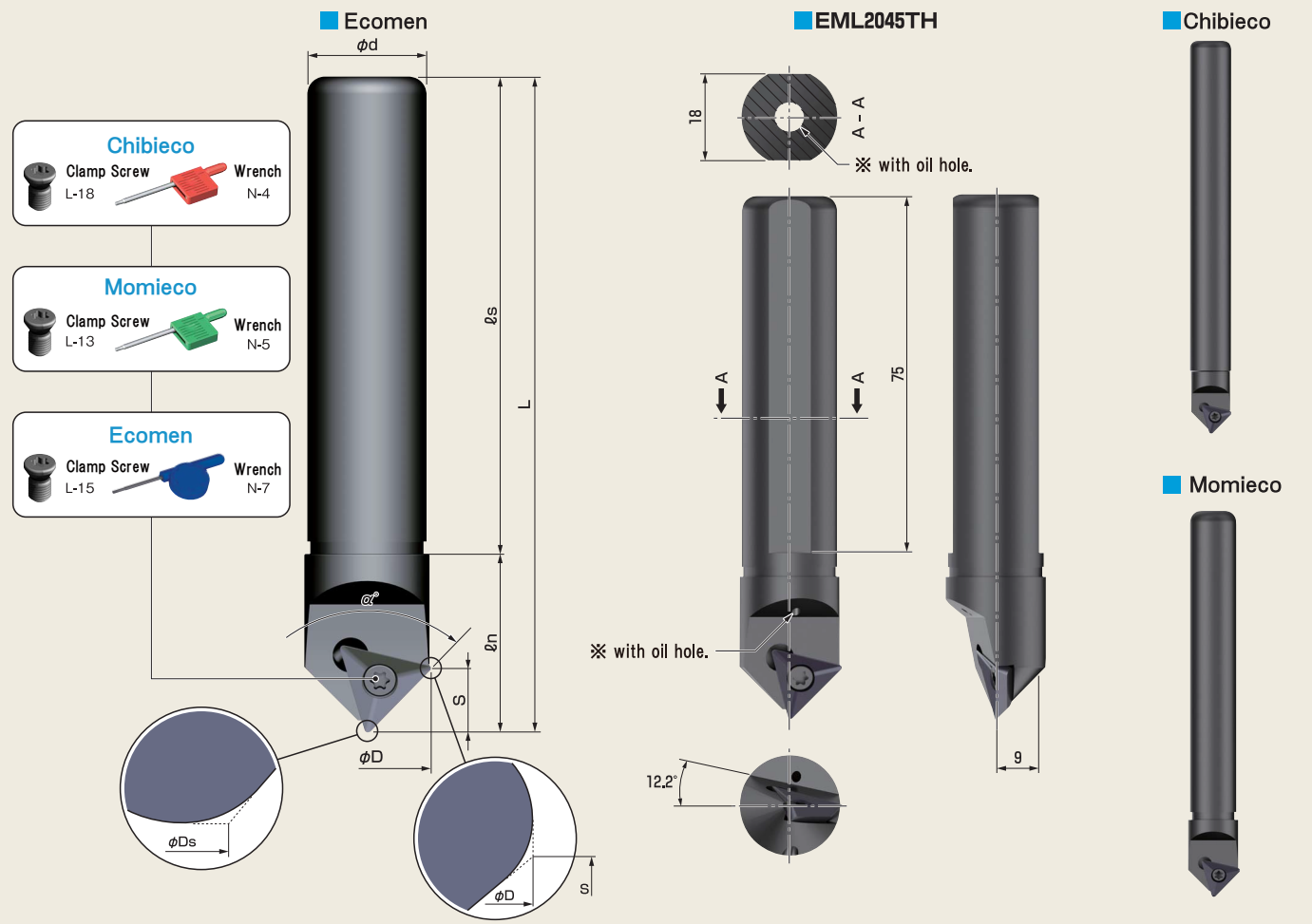


Cost Reduction !

- Original insert have 3 usable corners and decrease the production cost widely
- Due to the improvement of blade shape and new coating, it is machinable more than any other insert, and chip(cuttings) release has been drastically improving
- Micro-grained Carbide with new coating made longer life of insert



※ This tool cannot be used with drilling machines



Body

Product name	Model. No.	blades	Dimensions (mm)							α°	Inserts
			ϕD	ϕD_s	ϕd	L	l_s	l_n	S		
Chibieco	EMS1045T	1	10.3	0.88	10	95	80	15	4.7	90°	TXMT080206
	EMS1045TL	1	10.3	0.88	10	155	140	15	4.7	90°	TXMT080206
	EMS1030T	1	12.3	0.71	10	95	80	15	3.3	120°	TXMT080206
	EMS1030TL	1	12.3	0.71	10	155	140	15	3.3	120°	TXMT080206
Momieco	EMM1245T	1	14.2	0.88	12	100	80	20	6.7	90°	TXMT110306
	EMM1245TL	1	14.2	0.88	12	160	140	20	6.7	90°	TXMT110306
	EMM1645T	1	14.2	0.88	16	100	80	20	6.7	90°	TXMT110306
	EMM1645TL	1	14.2	0.88	16	160	140	20	6.7	90°	TXMT110306
	EMM1230T	1	17.1	0.71	12	100	80	20	4.7	120°	TXMT110306
	EMM1230TL	1	17.1	0.71	12	160	140	20	4.7	120°	TXMT110306
Ecomen	EML2045T	1	22	0.88	20	110	80	30	10.5	90°	TXMT16T306
	EML2045TL	1	22	0.88	20	170	140	30	10.5	90°	TXMT16T306
	EML2545TL	1	22	0.88	25	170	140	30	10.5	90°	TXMT16T306
	EML2045TH	1	22	0.88	20	110	80	30	10.5	90°	TXMT16T306
	EML2030T	1	26.6	0.71	20	110	80	30	7.5	120°	TXMT16T306
	EML2030TL	1	26.6	0.71	20	170	140	30	7.5	120°	TXMT16T306

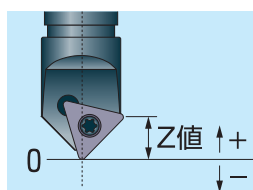
※ Insert is not equipped as standard accessory. Please purchase it separately ※ Clamp screw is equipped as standard accessory



Blade edge by V-grooving and centering processing could not be a perfect vertex angle

Product Name	Model. No.	Capacity	α°
		Bore chamfering	
Chibieco	EMS1045T	$\phi 1.2\text{mm} \sim \phi 9.7\text{mm}$	90°
	EMS1045TL	$\phi 1.2\text{mm} \sim \phi 9.7\text{mm}$	90°
	EMS1030T	$\phi 1.0\text{mm} \sim \phi 11.7\text{mm}$	120°
	EMS1030TL	$\phi 1.0\text{mm} \sim \phi 11.7\text{mm}$	120°
Momieco	EMM1245T	$\phi 1.2\text{mm} \sim \phi 13.6\text{mm}$	90°
	EMM1245TL	$\phi 1.2\text{mm} \sim \phi 13.6\text{mm}$	90°
	EMM1645T	$\phi 1.2\text{mm} \sim \phi 13.6\text{mm}$	90°
	EMM1645TL	$\phi 1.2\text{mm} \sim \phi 13.6\text{mm}$	90°
	EMM1230T	$\phi 1.0\text{mm} \sim \phi 16.5\text{mm}$	120°
	EMM1230TL	$\phi 1.0\text{mm} \sim \phi 16.5\text{mm}$	120°
Ecomen	EML2045T	$\phi 1.2\text{mm} \sim \phi 21.6\text{mm}$	90°
	EML2045TL	$\phi 1.2\text{mm} \sim \phi 21.6\text{mm}$	90°
	EML2545TL	$\phi 1.2\text{mm} \sim \phi 21.6\text{mm}$	90°
	※ EML2045TH	$\phi 1.2\text{mm} \sim \phi 21.6\text{mm}$	90°
	EML2030T	$\phi 1.0\text{mm} \sim \phi 26.0\text{mm}$	120°
	EML2030TL	$\phi 1.0\text{mm} \sim \phi 26.0\text{mm}$	120°

※ with oil hole.



Z-value compensate standard

※ Please note that this value may be getting little errors

$\alpha^\circ=90^\circ \rightarrow +0.44$ (Common to all models)

$\alpha^\circ=120^\circ \rightarrow +0.20$ (Common to all models)

[Example] ... Correct Z-value (-2.5) to -2.06 in case of 8mm centering process

Processing Example

[Φ5mm Center-drilling]

- Body : EML2045T
- Insert : TXMT16T306 AC15N

- Material..... SUS304
- Rotation Speed... 2,000r.p.m
- Feed (Z-axis) 40mm/min
- Cutting Oil..... Yes

Result

No cutting vibration or secondary burr after centering



Cutting Conditions

Centering					
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant	Air blow
General Steel	0.02~0.08	2,000~	TXMT□□□□□ AC15N	Yes	—
Alloy Steel	0.02~0.08	2,000~	TXMT□□□□□ AC15N	Yes	—
Stainless Steel	0.01~0.05	2,000~	TXMT□□□□□ AC15N	Yes	—
Aluminum, Resin, Brass	0.02~0.08	5,000~	TXMT□□□□□ ZA10N	Yes	—
Castings	0.02~0.08	2,000~	TXMT□□□□□ AC15N	—	Yes

Chamfering					
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant	Air blow
General Steel	0.03~0.15	3,000~	TXMT□□□□□ AC15N	None (※)	—
Alloy Steel	0.03~0.15	3,000~	TXMT□□□□□ AC15N	None (※)	—
Stainless Steel	0.03~0.15	3,000~	TXMT□□□□□ AC15N	Yes	—
Aluminum, Resin, Brass	0.03~0.15	5,000~	TXMT□□□□□ ZA10N	Yes	—
Castings	0.03~0.15	3,000~	TXMT□□□□□ AC15N	—	Yes

※ Please used as needed.

● 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 take reducing cutting condition

● In case of chamfering process of stainless steel, please take the down cutting

Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
● Chibieco 	TXMT080206 ZA10N	Carbide K10	Sharp edge	None	3	12
	TXMT080206 AC15N	Fine particles Carbide	Honing edge	AlCrN	3	12
● Momieco 	TXMT110306 ZA10N	Carbide K10	Sharp edge	None	3	12
	TXMT110306 AC15N	Fine particles Carbide	Honing edge	AlCrN	3	12
● Ecomen 	TXMT16T306 ZA10N	Carbide K10	Sharp edge	None	3	12
	TXMT16T306 AC15N	Fine particles Carbide	Honing edge	AlCrN	3	12