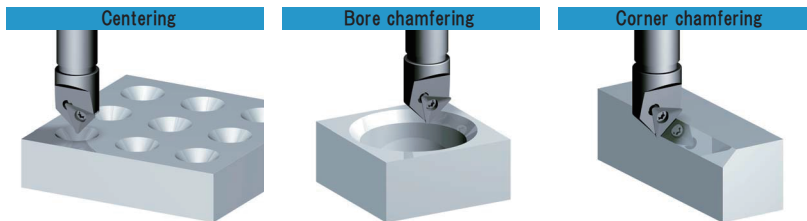


Cost Reduction !

- 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

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°
	EMM1230T	$\phi 1.0\text{mm} \sim \phi 16.5\text{mm}$	120°
Ecomen	EMM1230TL	$\phi 1.0\text{mm} \sim \phi 16.5\text{mm}$	120°
	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

Cutting Conditions

Centering				
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.02~0.08	2,000~	TXMT16T306 AC15N	Yes
Alloy Steel	0.02~0.08	2,000~	TXMT16T306 AC15N	Yes
Stainless Steel	0.01~0.05	2,000~	TXMT16T306 AC15N	Yes
Aluminum, Resin, Brass	0.02~0.08	5,000~	TXMT16T306 ZA10N	Yes
Castings	0.02~0.08	2,000~	TXMT16T306 AC15N	Yes

Chamfering				
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.03~0.15	3,000~	TXMT16T306 AC15N	None (※)
Alloy Steel	0.03~0.15	3,000~	TXMT16T306 AC15N	None (※)
Stainless Steel	0.03~0.15	3,000~	TXMT16T306 AC15N	Yes
Aluminum, Resin, Brass	0.03~0.15	5,000~	TXMT16T306 ZA10N	Yes
Castings	0.03~0.15	3,000~	TXMT16T306 AC15N	None (※)

※ 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

Body

Product name	Model. No.	blades	Dimensions (mm)							α°	Inserts	Accessories	
			ϕD	ϕD_s	ϕd	L	ℓ_s	ℓ_n	S			Clamp Screw	Wrench
Chibieco	EMS1045T	1	10.3	0.88	10	95	80	15	4.7	90°	TXMT080206	L-18	N-4
	EMS1045TL	1	10.3	0.88	10	155	140	15	4.7	90°	TXMT080206	L-18	N-4
	EMS1030T	1	12.3	0.71	10	95	80	15	3.3	120°	TXMT080206	L-18	N-4
	EMS1030TL	1	12.3	0.71	10	155	140	15	3.3	120°	TXMT080206	L-18	N-4
Momieco	EMM1245T	1	14.2	0.88	12	100	80	20	6.7	90°	TXMT110306	L-13	N-5
	EMM1245TL	1	14.2	0.88	12	160	140	20	6.7	90°	TXMT110306	L-13	N-5
	EMM1230T	1	17.1	0.71	12	100	80	20	4.7	120°	TXMT110306	L-13	N-5
	EMM1230TL	1	17.1	0.71	12	160	140	20	4.7	120°	TXMT110306	L-13	N-5
Ecomen	EML2045T	1	22	0.88	20	110	80	30	10.5	90°	TXMT16T306	L-15	N-7
	EML2045TL	1	22	0.88	20	170	140	30	10.5	90°	TXMT16T306	L-15	N-7
	EML2545TL	1	22	0.88	25	170	140	30	10.5	90°	TXMT16T306	L-15	N-7
	EML2045TH	1	22	0.88	20	110	80	30	10.5	90°	TXMT16T306	L-15	N-7
	EML2030T	1	26.6	0.71	20	110	80	30	7.5	120°	TXMT16T306	L-15	N-7
	EML2030TL	1	26.6	0.71	20	170	140	30	7.5	120°	TXMT16T306	L-15	N-7

※ 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

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



Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
● Chibienco 	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