

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

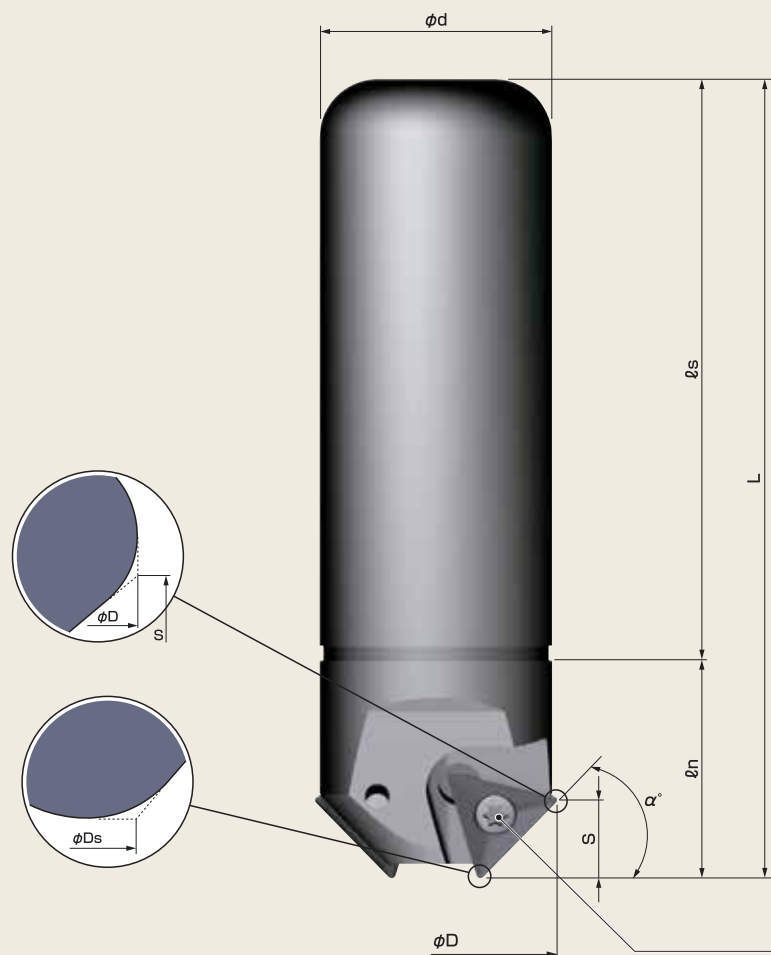
Corner chamfering



Bore chamfering



※ This tool cannot be used with drilling machines



Clamp Screw



L-18

Wrench



N-4

Clamp Screw



L-13

Wrench



N-5

Clamp Screw



L-15

Wrench



N-7

Body

Product name	Model. No.	blades	Dimensions (mm)							α°	Inserts
			ϕD	ϕD_s	ϕd	L	ℓ_s	ℓ_n	S		
Chibieco2	NKS3018T	2	18.6	7	16	95	80	15	3.3	30°	TXMT080206
	NKS4516T	2	16.5	7	16	95	80	15	4.7	45°	TXMT080206
	NKS6017T	2	17.7	11	16	95	80	15	5.8	60°	TXMT080206
Momieco2	NKM3025T	2	25.3	9	20	100	80	20	4.7	30°	TXMT110306
	NKM4522T	2	22.3	9	20	100	80	20	6.7	45°	TXMT110306
	NKM6023T	2	23.4	14	20	100	80	20	8.2	60°	TXMT110306
Ecomen2	NKL3036T	2	36.9	11	32	110	80	30	7.5	30°	TXMT16T306
	NKL4534T	2	34.1	13	32	110	80	30	10.5	45°	TXMT16T306
	NKL6034T	2	34.9	20	32	110	80	30	12.9	60°	TXMT16T306

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

※ Clamp screw is equipped as standard accessory

Product Name	Model. No.	Capacity	α°
		Bore chamfering	
Chibieco2	NKS3018T	$\phi 7.3\text{mm} \sim \phi 18.0\text{mm}$	30°
	NKS4516T	$\phi 7.3\text{mm} \sim \phi 15.9\text{mm}$	45°
	NKS6017T	$\phi 11.3\text{mm} \sim \phi 17.1\text{mm}$	60°
Momieco2	NKM3025T	$\phi 9.3\text{mm} \sim \phi 24.7\text{mm}$	30°
	NKM4522T	$\phi 9.3\text{mm} \sim \phi 21.7\text{mm}$	45°
	NKM6023T	$\phi 14.3\text{mm} \sim \phi 22.8\text{mm}$	60°
Ecomen2	NKL3036T	$\phi 11.3\text{mm} \sim \phi 36.3\text{mm}$	30°
	NKL4534T	$\phi 13.4\text{mm} \sim \phi 33.8\text{mm}$	45°
	NKL6034T	$\phi 20.4\text{mm} \sim \phi 34.8\text{mm}$	60°

Processing Example

[$\phi 15$ C5 Bore Chamfering]

- Body : NKL4534T
- Insert : TXMT16T306 AC15N

- Material :SUS304
- Rotation Speed :4,500r.p.m.
- Feed (Z-axis) :150/min
- Cutting Depth :C5
- Cutting Oil :Yes

Result

Good!
No secondary burrs and
No chattering after processing



Cutting Conditions

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
Chibieco2 	TXMT080206 ZA10N	Carbide K10	Sharp edge	None	3	12
	TXMT080206 AC15N	Fine particles Carbide	Honing edge	AlCrN	3	12
Momieco2 	TXMT110306 ZA10N	Carbide K10	Sharp edge	None	3	12
	TXMT110306 AC15N	Fine particles Carbide	Honing edge	AlCrN	3	12
Ecomen2 	TXMT16T306 ZA10N	Carbide K10	Sharp edge	None	3	12
	TXMT16T306 AC15N	Fine particles Carbide	Honing edge	AlCrN	3	12