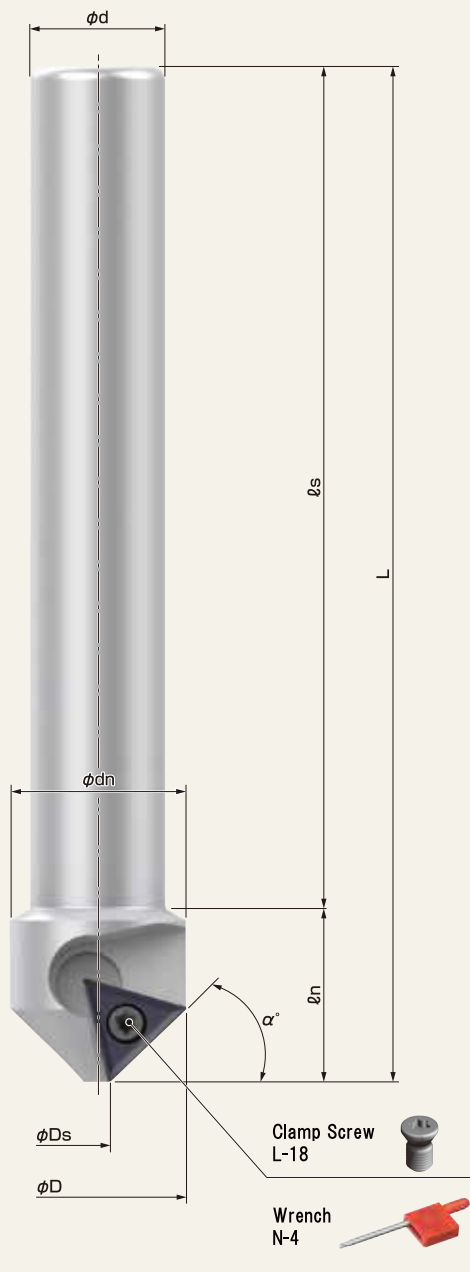


OK for Drilling Machine, also Electric Drill !

- Optimal Tool for small hole chamfering!
- Using Durable High-Speed Steel body
- Achieved a super long life by using Ultrafine particle Carbide + New Coating Tips !
- Positive type with 3-coner Fine Carbide Tip can be used !



Dish Chamfering Processing



Dish Chamfering Processing



Dish Chamfering Processing

$\phi 2.5\text{mm} \sim \phi 11\text{mm}$

Body

Model No.	Blades	Dimensions (mm)							α°
		ϕD	ϕDs	ϕd	ϕdn	L	ℓs	ℓn	
NEW MBM4513T	1	13.08	2.41	10	13	75	62	13	45°
NEW MBM4513TL	1	13.08	2.41	10	13	143	130	13	45°

※ 1-pce of TCXT080102E AC16N insert is equipped as standard accessory
 ※ Clamp Screw·Wrench are standard accessory

Cutting Conditions

Work Material	TCXT080102F ZC16N	TCXT080102E AC16N
	Spindle Speed(r.p.m.)	
General Steel etc.		150~800
Alloy Steel, SKD/SCM etc.		150~800
Stainless Steel, SUS etc.		150~800
Aluminum, Resin, Brass	150~800	150~800
Cast/Steel, FC/FCD etc.	150~800	150~800

- There is that above condition is not the case due to the difference of various machine's rigidity. Hard-to-cut materials(A5052, Copper etc.) should be increasing the rotation than the above mentioned conditions.
- If the chattering or the like occurs in the cutting plane, please lower the rotation and use cutting oil
- Please use a dedicated Tips listed below.
- Please adjust the cutting condition due to the work shape, clamp condition, chamfering amount(small or large) and position of cutting edge etc.
- If processing diameter and the chamfering amount is large to process by lowering the cutting conditions.

Processing Example

【 $\phi 3$ C2 Chamfering of the hole in the mouth】

- Holder : MBM4513T
- Tips : TCXT080102E AC16N

- Material.....SUS304
- Rotation.....450r.p.m.
- Machine.....Bench Drilling Machines

Result

No Bali and No Burr
Good Finish



Tips

Drawing	Model Number	Material	Edge Shape	Coating	Usable Corner	Quantity per box
	NEW TCXT080102F ZC16N	Fine particles Carbide	Sharp edge	None	3	3
	NEW TCXT080102E AC16N	Fine particles Carbide	Honing edge	AlCrN	3	3