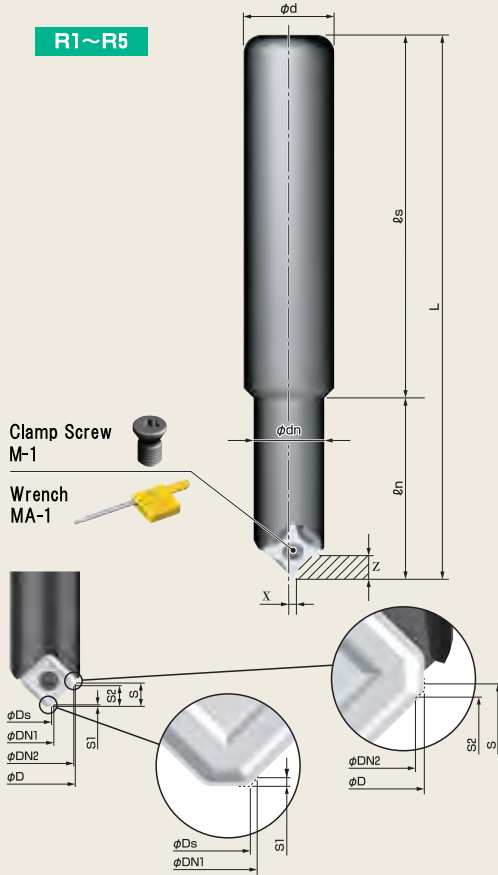


Possible R-Chamfering And C-Chamfering process !

- 8 corners of inserts can be usable.
- Possible R-Chamfering And C-Chamfering process ensured by changing insert

R1~R5

Clamp Screw
M-1Wrench
MA-1

Setting numerical values

Processing R	X-axis position (mm)	Z-axis position (mm)
R1	4.46	3.46
R2	3.99	3.94
R3	3.53	4.43
R4	3.09	4.91
R5	2.67	5.40

● numeric value might get some errors, please acknowledge.

R Chamfering



C-Chamfering



Cutting Conditions

SNEQ090308 / S32MOZ		
Material	Feed per blade (fz)	Cutting speed (m/min)
General Steel	0.05~0.2	100~150
Alloy Steel	0.05~0.2	100~150
Stainless Steel	0.05~0.2	80~120
Aluminum, Resin, Brass	0.08~0.25	150~400
Cast Steel	0.05~0.2	100~150

Body

Model. No.	blades	Dimensions (mm)				
		ϕd	ϕdn	L	ℓs	ℓn
MR20-16S	1	20	15.6	120	80	40

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

※ Clamp screw, screw, wrench and locator are supplied as standard accessories

Processing Example (Mini-R)

[Periphery R3 Chamfering process]

■ Body : MR20-16S

■ Insert : SNEQ090308-3RM ZA20N

- Material SUS304
- Rotational speed ... 3,000r.p.m.
- Table feed 150mm/min

Result

Surface Accuracy is good when the processing was made without rough cutting

Wet Processing



S32MOZ Insert Dimension Table

Model. No.	insert	blades	Dimensions (mm)								ability (mm)			
			ϕ d	ϕ dn	L	ℓ s	ℓ n	ϕ Ds	ϕ D	S	ϕ DN1	ϕ DN2	S1	S2
MR20-16S	S32M0Z	1	20	15.6	119.61	80	39.61	5.15	15.12	5.1	5.53	14.66	0.23	4.89

Insert ※XRM, you can not use

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
(SNEQ090308-□RM) (8 Corner)	SNEQ090308-1RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
	SNEQ090308-2RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
	SNEQ090308-3RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
	SNEQ090308-4RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
	SNEQ090308-5RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
(S32MOZ) (Except nose R)	S32MOZ NK2001	Cermet	Honing edge	None	8	12
	S32MOZ NK2050	Cermet	Honing edge	None	8	12
	S32MOZ AB01F	Cermet	Honing edge	AlCrN	8	12
	S32MOZ NK1010	Carbide K10	Sharp edge	None	8	12
	S32MOZ NK2020	Carbide M20	Honing edge	None	8	12
	S32MOZ NK3030	Carbide M20	Honing edge	TiN	8	12
	S32MOZ AC15T	Fine particles Carbide	Honing edge	AlCrN	8	12