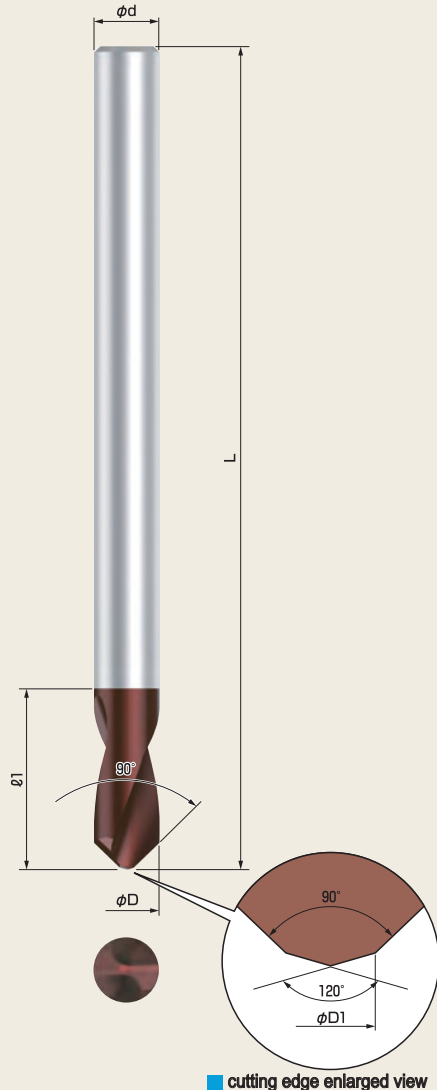


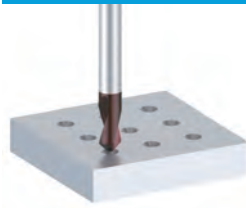
By PICO only !

- Succeeded the improvement of sharpness at the Pointing processing and eliminated the secondary Burrs !
- Can also be used to C-Chamfering, Dish Chamfering Processing that runs in the transverse!

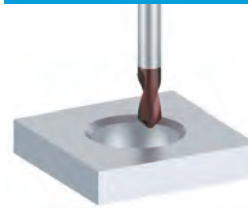


Material: Fine Particles Carbide

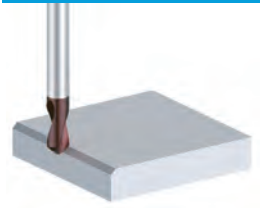
Centering Processing



Dish Chamfering Processing



Chamfering Processing



※ Ncan't use for Bench Drilling Machines

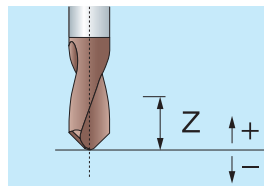
Model. No.	Capacity
	Dish Chamfering Processing
SCP0345F/SCP0345FL	$\phi 0.75\text{mm} \sim \phi 3.0\text{mm}$ (For steel-based)
SCP0445F/SCP0445FL	$\phi 1.0\text{mm} \sim \phi 4.0\text{mm}$ (For steel-based)
SCP0545F/SCP0545FL	$\phi 1.25\text{mm} \sim \phi 5.0\text{mm}$ (For steel-based)
SCP0645F/SCP0645FL	$\phi 1.5\text{mm} \sim \phi 6.0\text{mm}$ (For steel-based)
SCP0345S/SCP0345SL	$\phi 0.75\text{mm} \sim \phi 3.0\text{mm}$ (For stainless steel-based)
SCP0445S/SCP0445SL	$\phi 1.0\text{mm} \sim \phi 4.0\text{mm}$ (For stainless steel-based)
SCP0545S/SCP0545SL	$\phi 1.25\text{mm} \sim \phi 5.0\text{mm}$ (For stainless steel-based)
SCP0645S/SCP0645SL	$\phi 1.5\text{mm} \sim \phi 6.0\text{mm}$ (For stainless steel-based)

Body

Model. No.	Blades	Dimensions (mm)					Coating
		ϕD	$\phi D1$	ϕd	L	$\phi 1$	
NEW SCP0345F	2	3	$\phi 0.75$	3	50	8	TiAlN
NEW SCP0445F	2	4	$\phi 1.0$	4	50	10	TiAlN
NEW SCP0545F	2	5	$\phi 1.25$	5	50	13	TiAlN
NEW SCP0645F	2	6	$\phi 1.5$	6	50	15	TiAlN
NEW SCP0345FL	2	3	$\phi 0.75$	3	100	8	TiAlN
NEW SCP0445FL	2	4	$\phi 1.0$	4	100	10	TiAlN
NEW SCP0545FL	2	5	$\phi 1.25$	5	100	13	TiAlN
NEW SCP0645FL	2	6	$\phi 1.5$	6	100	15	TiAlN
NEW SCP0345S	2	3	$\phi 0.75$	3	50	8	TiAlN
NEW SCP0445S	2	4	$\phi 1.0$	4	50	10	TiAlN
NEW SCP0545S	2	5	$\phi 1.25$	5	50	13	TiAlN
NEW SCP0645S	2	6	$\phi 1.5$	6	50	15	TiAlN
NEW SCP0345SL	2	3	$\phi 0.75$	3	100	8	TiAlN
NEW SCP0445SL	2	4	$\phi 1.0$	4	100	10	TiAlN
NEW SCP0545SL	2	5	$\phi 1.25$	5	100	13	TiAlN
NEW SCP0645SL	2	6	$\phi 1.5$	6	100	15	TiAlN

⚠ Blade edge by centering processing could not be a perfect vertex angle

⚠ Can not regrinding !



Estimated Z value correction during Cutting processing
※ (this value there is a case where slight error is out)

SCP0345 → +0.16 SCP0545 → +0.26
SCP0445 → +0.21 SCP0645 → +0.32

[Example]In case of centering of 2 ϕ in SCP0345,
Z value is the place of -l to -0.84—Z value

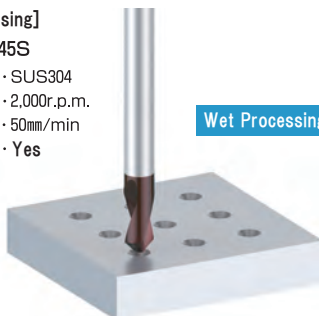
Processing Example

[$\Phi 2$ Centering Processing]

Holder : SCP0445S

- Material SUS304
- Rotation 2,000r.p.m.
- Z-Table Feed 50mm/min
- Use Cutting Oil Yes

Wet Processing



Result

Good!
No secondary burrs and no chattering process

Cutting Conditions

Centering				
Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)		Coolant
		SCP0345F/SCP0345FL	SCP0445S/SCP0445SL	
General Steel	0.05~0.1	4,000	×	Yes
Alloy Steel	0.05~0.1	3,000	×	Yes
Stainless Steel	0.02~0.03	×	2,000	Yes
Aluminum, Resin, Brass	×	×	×	Yes
Castings	0.05~0.1	4,000	×	×

Chamfering				
Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)		Coolant
		SCP0345F/SCP0345FL	SCP0445S/SCP0445SL	
General Steel	0.08~0.12	5,000~	×	Yes
Alloy Steel	0.08~0.12	4,000~	×	Yes
Stainless Steel	0.05~0.1	×	3,000~	Yes
Aluminum, Resin, Brass	×	×	×	Yes
Castings	0.08~0.12	5,000~	×	×

- Lower as much as possible the conditions in the case of finishing
- Work shape, Clamp condition, Amount of large and small, please adjust the conditions by cutting edge position
In case the amount is large, please lower cutting condition and process.
- In case Of Chamfering processing of Stainless Steel(SUS304etc) please process with Down-Cut.