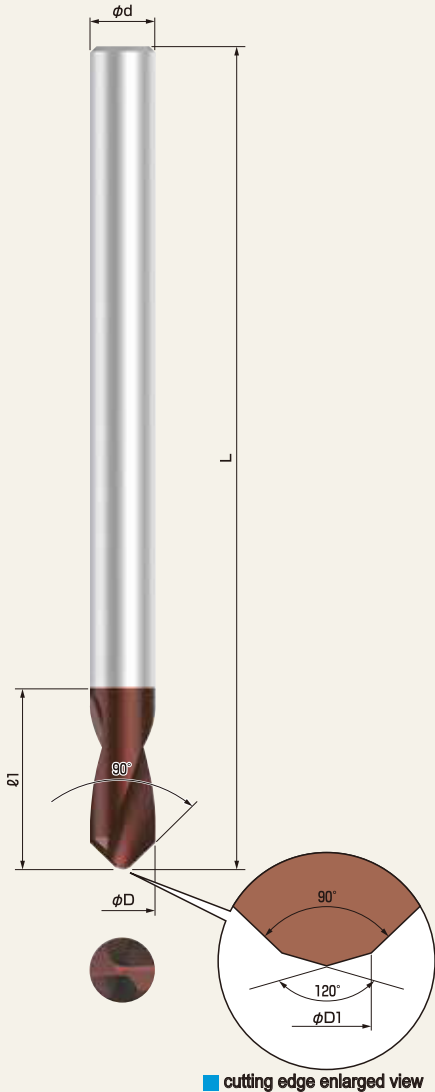
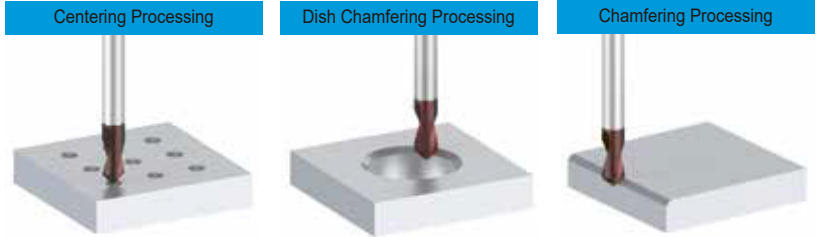


By PICO only !

- 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



※ Ncan't use for Bench Drilling Machines

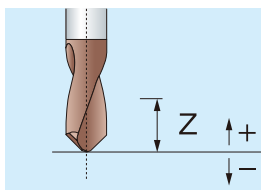
| Model. No. | Capacity | |
|--------------------|--|--|
| | Dish Chamfering Processing | |
| SCP0345F/SCP0345FL | φ0.75mm~φ3.0mm (For steel-based) | |
| SCP0445F/SCP0445FL | φ1.0mm~φ4.0mm (For steel-based) | |
| SCP0545F/SCP0545FL | φ1.25mm~φ5.0mm (For steel-based) | |
| SCP0645F/SCP0645FL | φ1.5mm~φ6.0mm (For steel-based) | |
| SCP0345S/SCP0345SL | φ0.75mm~φ3.0mm (For stainless steel-based) | |
| SCP0445S/SCP0445SL | φ1.0mm~φ4.0mm (For stainless steel-based) | |
| SCP0545S/SCP0545SL | φ1.25mm~φ5.0mm (For stainless steel-based) | |
| SCP0645S/SCP0645SL | φ1.5mm~φ6.0mm (For stainless steel-based) | |

Body

| Model. No. | Blades | Dimensions (mm) | | | | | Coating |
|---------------|--------|-----------------|-------|----|-----|----|---------|
| | | φD | φD1 | φd | L | ℓ1 | |
| NEW SCP0345F | 2 | 3 | φ0.75 | 3 | 50 | 8 | TiAlN |
| NEW SCP0445F | 2 | 4 | φ1.0 | 4 | 50 | 10 | TiAlN |
| NEW SCP0545F | 2 | 5 | φ1.25 | 5 | 50 | 13 | TiAlN |
| NEW SCP0645F | 2 | 6 | φ1.5 | 6 | 50 | 15 | TiAlN |
| NEW SCP0345FL | 2 | 3 | φ0.75 | 3 | 100 | 8 | TiAlN |
| NEW SCP0445FL | 2 | 4 | φ1.0 | 4 | 100 | 10 | TiAlN |
| NEW SCP0545FL | 2 | 5 | φ1.25 | 5 | 100 | 13 | TiAlN |
| NEW SCP0645FL | 2 | 6 | φ1.5 | 6 | 100 | 15 | TiAlN |
| NEW SCP0345S | 2 | 3 | φ0.75 | 3 | 50 | 8 | TiAlN |
| NEW SCP0445S | 2 | 4 | φ1.0 | 4 | 50 | 10 | TiAlN |
| NEW SCP0545S | 2 | 5 | φ1.25 | 5 | 50 | 13 | TiAlN |
| NEW SCP0645S | 2 | 6 | φ1.5 | 6 | 50 | 15 | TiAlN |
| NEW SCP0345SL | 2 | 3 | φ0.75 | 3 | 100 | 8 | TiAlN |
| NEW SCP0445SL | 2 | 4 | φ1.0 | 4 | 100 | 10 | TiAlN |
| NEW SCP0545SL | 2 | 5 | φ1.25 | 5 | 100 | 13 | TiAlN |
| NEW SCP0645SL | 2 | 6 | φ1.5 | 6 | 100 | 15 | TiAlN |

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

⚠ Can not regrinding !



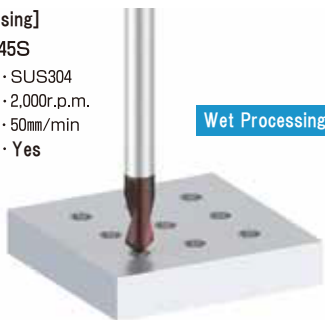
Estimated Z value correction during Cutting processing
※ (this value there is a case where slight error is out)

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 -1 to -0.84—Z value

Processing Example

[φ2 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 |
| | | SCP□45F/SCP□45FL | SCP□45S/SCP□45SL | |
| 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 |
| | | SCP□45F/SCP□45FL | SCP□45S/SCP□45SL | |
| 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.