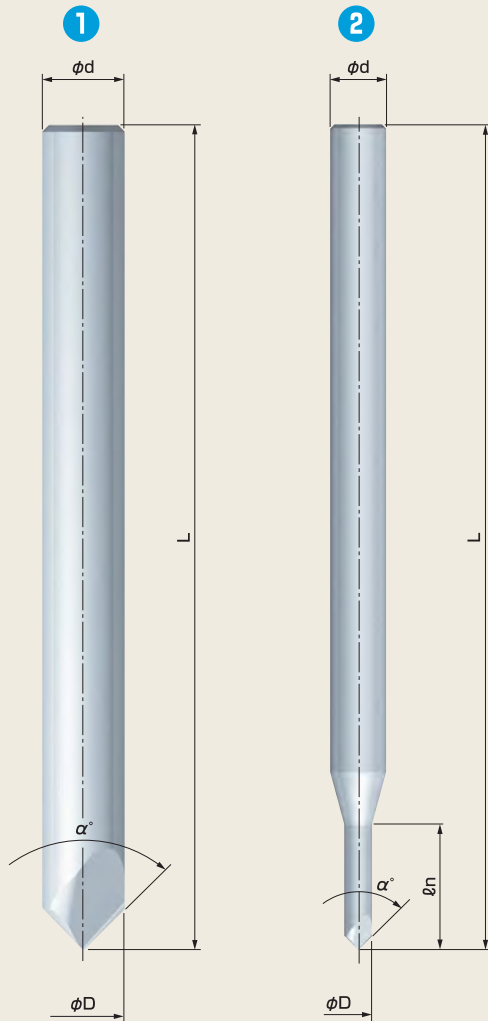


## Micro Processing !

- Sharp edge design provides very fine Engraving
- Runout Accuracy is less than 0.005mm !
- $\phi 0.01\text{mm}$  thread chamfering is possible

(※ not for coating material)



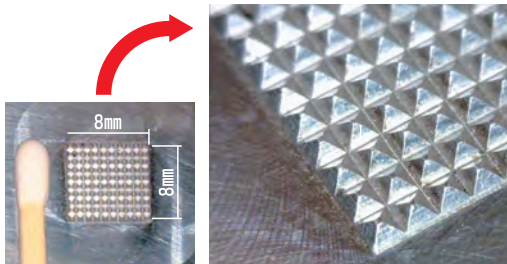
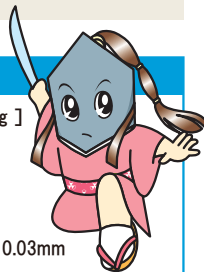
■ Material : Fine Particles Carbide

### Processing Example

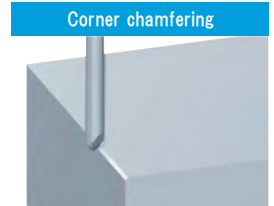
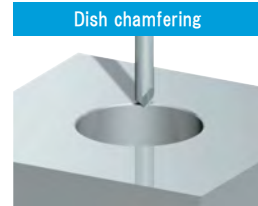
[0.8mm height of the pyramid 100 processing]

■ Body : PKP0645

- Material..... A5052
- Rotation Speed..... 10,000r.p.m.
- Table feed..... 150/min
- Cutting Depth ..... Rough 0.185mm finish 0.03mm



※ aluminum only



※ This tool cannot be used with Drilling Machines

Model. No.	Capacity	$\alpha^\circ$
	Bore chamfering	
PKP0145	$\phi 0.01\text{mm} \sim \phi 1\text{mm}$	90°
PKP0245	$\phi 0.01\text{mm} \sim \phi 2\text{mm}$	90°
PKP0345	$\phi 0.01\text{mm} \sim \phi 3\text{mm}$	90°
PKP0445	$\phi 0.01\text{mm} \sim \phi 4\text{mm}$	90°
PKP0545	$\phi 0.01\text{mm} \sim \phi 5\text{mm}$	90°
PKP0645	$\phi 0.01\text{mm} \sim \phi 6\text{mm}$	90°
PKP0145C	$\phi 0.01\text{mm} \sim \phi 1\text{mm}$	90°
PKP0245C	$\phi 0.01\text{mm} \sim \phi 2\text{mm}$	90°
PKP0345C	$\phi 0.01\text{mm} \sim \phi 3\text{mm}$	90°
PKP0445C	$\phi 0.01\text{mm} \sim \phi 4\text{mm}$	90°
PKP0545C	$\phi 0.01\text{mm} \sim \phi 5\text{mm}$	90°
PKP0645C	$\phi 0.01\text{mm} \sim \phi 6\text{mm}$	90°
PKP0145DLC	$\phi 0.01\text{mm} \sim \phi 1\text{mm}$	90°
PKP0245DLC	$\phi 0.01\text{mm} \sim \phi 2\text{mm}$	90°
PKP0345DLC	$\phi 0.01\text{mm} \sim \phi 3\text{mm}$	90°
PKP0445DLC	$\phi 0.01\text{mm} \sim \phi 4\text{mm}$	90°
PKP0545DLC	$\phi 0.01\text{mm} \sim \phi 5\text{mm}$	90°
PKP0645DLC	$\phi 0.01\text{mm} \sim \phi 6\text{mm}$	90°

### Body

Model. No.	Figure	Blades	Dimensions (mm)				$\alpha^\circ$	Coating
			$\phi D$	$\phi d$	L	$\ell n$		
PKP0145	②	1	1	4	55	9	90°	None
PKP0245	②	1	2	4	55	9	90°	None
PKP0345	①	1	3	3	55	—	90°	None
PKP0445	①	1	4	4	55	—	90°	None
PKP0545	①	1	5	5	60	—	90°	None
PKP0645	①	1	6	6	60	—	90°	None
PKP0145C	②	1	1	4	55	9	90°	AlCrN
PKP0245C	②	1	2	4	55	9	90°	AlCrN
PKP0345C	①	1	3	3	55	—	90°	AlCrN
PKP0445C	①	1	4	4	55	—	90°	AlCrN
PKP0545C	①	1	5	5	60	—	90°	AlCrN
PKP0645C	①	1	6	6	60	—	90°	AlCrN
PKP0145DLC	②	1	1	4	55	9	90°	DLC
PKP0245DLC	②	1	2	4	55	9	90°	DLC
PKP0345DLC	①	1	3	3	55	—	90°	DLC
PKP0445DLC	①	1	4	4	55	—	90°	DLC
PKP0545DLC	①	1	5	5	60	—	90°	DLC
PKP0645DLC	①	1	6	6	60	—	90°	DLC

### Cutting Conditions

Centering			
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Coolant
General Steel	x	x	x
Alloy Steel	x	x	x
Stainless Steel	x	x	x
Aluminum, Resin, Brass	0.05~0.08	10,000	YES
Cast Steel	x	x	x

V-groove processing			
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Coolant
General Steel	0.05~0.07	8,000	YES
Alloy Steel	0.05~0.07	8,000	YES
Stainless Steel	0.03~0.05	8,000	YES
Aluminum, Resin, Brass	0.05~0.08	10,000	YES
Cast Steel	0.04~0.06	8,000	YES

Chamfering			
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Coolant
General Steel	0.07~0.1	8,000	YES
Alloy Steel	0.07~0.1	8,000	YES
Stainless Steel	0.05~0.07	8,000	YES
Aluminum, Resin, Brass	0.1~0.15	10,000	YES
Cast Steel	0.07~0.12	8,000	YES

- For finish application, the cutting condition will have to be reduced
- Not possible for processing more than C1 chamfer processing
- 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 chamfering process of stainless steel, reduce the cutting conditions