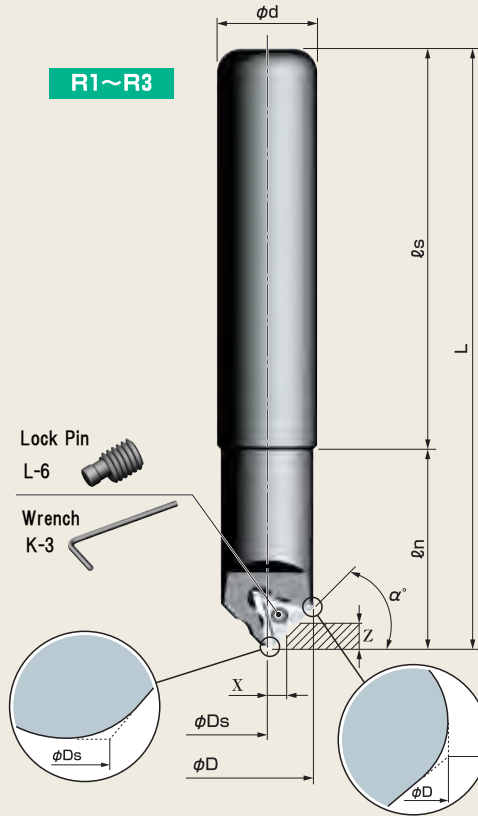


Easy Radius change !!

- Possible R-Chamfering And C-Chamfering process ensured by changing insert



Setting numerical values

Processing R	X-axis position (mm)	Z-axis position (mm)
R1	6.40	5.81
R2	5.90	6.30
R3	5.40	6.78

● numeric value might get some errors, please acknowledge.

R Chamfering



C-Chamfering



Insert

T32GSR		
Material	Feed Per Blade (fz)	Cutting speed (m / min)
General Steel	0.08~0.2	150~200
Alloy Steel	0.08~0.2	150~200
Stainless Steel	0.08~0.2	120~180
Aluminum, Resin, Brass	0.08~0.3	200~800
Castings	0.08~0.2	150~200

Processing Example

[Periphery R3 Chamfering process]

- Body : CR25-05T
- Insert : T32GSR-3R NK2020
- Table feed Bakelite
- Material 4,000r.p.m.
- Rotational speed ... 800mm/min



Dry cutting

Result

Good discharge of chips, surface accuracy also good Results came out.

Body

Model. No.	blades	Dimensions (mm)							α°
		φD	φDs	φd	L	ls	ln	S	
CR25-05T	1	25	3.8	25	150	100	50	10.6	45°

- ※ Insert is not included. Please Order Separately.
- ※ Lock pin Wrench we have Standard Equipment.



When mounting insert, please do not take reverse tightening.
Due to the eccentricity looking mechanism, poor accuracy or breakage of insert may be occurred
When replacing insert, please confirm whether you have been taking reserve tightening or not.

Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
〈T32GSR〉	T32GSR-1R NK2020	Carbide M20		None	3	3
	T32GSR-2R NK2020	Carbide M20		None	3	3
	T32GSR-3R NK2020	Carbide M20		None	3	3
〈T32MOR〉	T32MOR NK2001	Cermet	Honing edge	None	6	12
	T32MOR NK1010	Carbide K10	Sharp edge	None	6	12
	T32MOR NK2020	Carbide M20	Honing edge	None	6	12
	T32MOR NK3030	Carbide M20	Honing edge	TiN	6	12
	T32MOR AC16N	Fine particles Carbide	Honing edge	AlCrN	6	12
〈TT32GUR〉/〈TT32GURF〉	TT32GUR NK2001	Cermet	Honing edge	None	2	12
	TT32GUR NK1010	Carbide K10	Sharp edge	None	2	12
	TT32GUR NK2020	Carbide M20	Honing edge	None	2	12
	TT32GUR NK3030	Carbide M20	Honing edge	TiN	2	12
	TT32GUR NK5050	Carbide K10	Sharp edge	TiN	2	12
	TT32GUR NK8080	Carbide K10	Sharp edge	TiAlN	2	12
	TT32GUR AC15N	Fine particles Carbide	Honing edge	AlCrN	2	12
	TT32GURF TC16N	Fine particles Carbide	Sharp edge	TiSiN	2	12
	TT32GUR HSS	HSS	Sharp edge	None	2	12
〈TNEA160304〉	TT32GUR HSS TiN	HSS	Sharp edge	TiN	2	12
	TNEA160304 TC16N	Fine particles Carbide	Honing edge	TiSiN	6	12