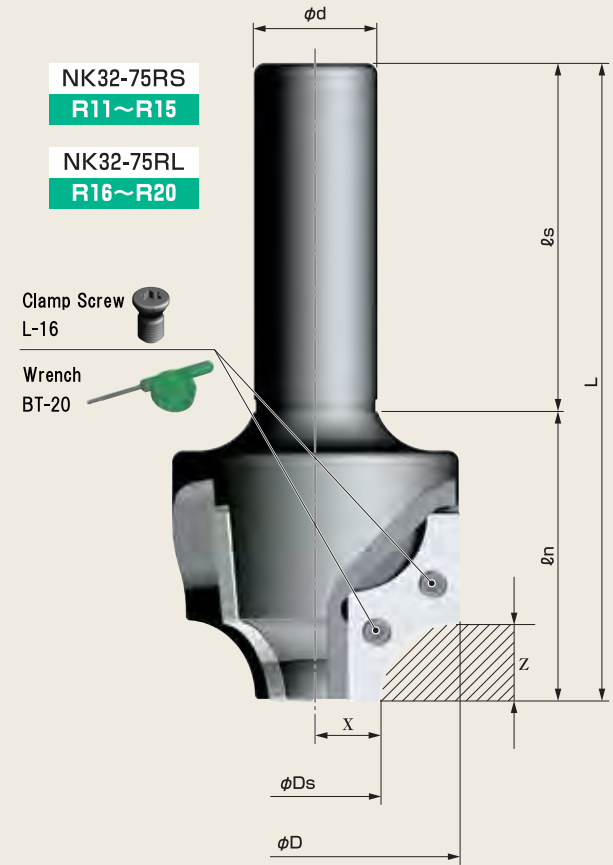


### Easy Radius change !!

● Various Radius chamfering can be made by just exchanging Inserts



NK32-75RS  
R11~R15

NK32-75RL  
R16~R20

This is not standard production model.  
Please check the delivery time when ordering

### Setting numerical values

Processing R	X-axis position (mm)	Z-axis position (mm)
R11	17.50	11.77
R12	17.50	12.70
R13	17.50	13.63
R14	17.50	14.56
R15	17.50	15.48
R16	17.50	16.41
R17	17.50	17.34
R18	17.50	18.27
R19	17.50	19.20
R20	17.50	20.12

● numeric value might get some errors, please acknowledge.



### Cutting Conditions

Material	Material model number	NK2020
General Steel	0.1~0.3	100~250
Alloy Steel	0.1~0.3	100~250
Stainless Steel	0.1~0.25	80~160
Aluminum,Resin,Brass	0.1~0.3	150~400
Castings	0.1~0.3	80~200

- According to the shape of work, clamp condition and large or small chamfering amount, the cutting condition will have to be adjusted.
- Yellow marked condition is recommended for the material listed
- In case of chamfering process of Stainless steel, kindly take down cutting

### Processing Example

[Periphery R20 Chamfering process]

- Body : NK32-75RL
- Insert : XNEW3004-20R NK2020
- Material ..... S50C
- Rotational speed ... 750r.p.m.
- Table feed ..... 225mm/min



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

### Body

Model. No.	Blades	Dimensions (mm)					
		φD	φDs	φd	L	ℓs	ℓn
NK32-75RS	R11~R15	75.5	35	32	165	90	75
NK32-75RL	R16~R20	75.5	35	32	165	90	75

※ Insert is not equipped as standard accessory. Please purchase it separately  
 ※ Clamp screw, screw,wrench and locator are supplied as standard accessories

### Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
	XNEW3004-11R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-12R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-13R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-14R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-15R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-16R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-17R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-18R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-19R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-20R NK2020	Carbide M20	Honing edge	None	2	3

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