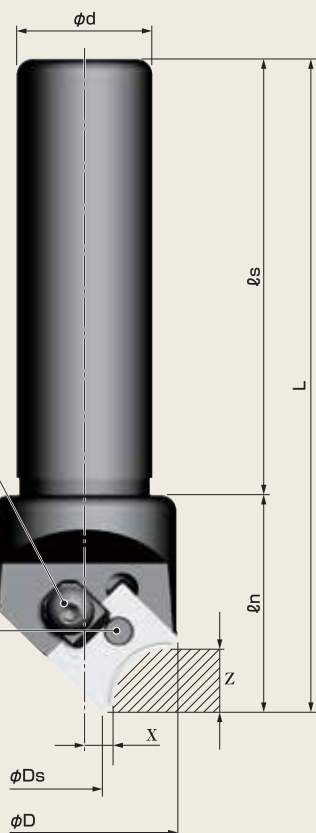


## R-Nouveau Jr.

R5~R10

1Blade

Clamp piece  
CL-1SWrench  
K-3Lock Pin  
L-12Wrench  
K-4

## Easy Radius change !!

● Various Radius chamfering can be made by just exchanging Inserts

## Setting numerical values

Processing R	X-axis position (mm)	Z-axis position (mm)
R5	6.00	6.70
R6	5.41	7.21
R7	5.64	8.42
R8	6.00	9.65
R9	5.41	10.16
R10	6.00	11.62

● numeric value might get some errors, please acknowledge.

## R Chamfering



## Body

Model. No.	Blades	Dimensions (mm)					
		$\phi D$	$\phi D_s$	$\phi d$	L	$\ell_s$	$\ell_n$
NK20-10R	1	35.4	8.9	20	120	80	40
NK25-10R	1	35.4	8.9	25	120	80	40

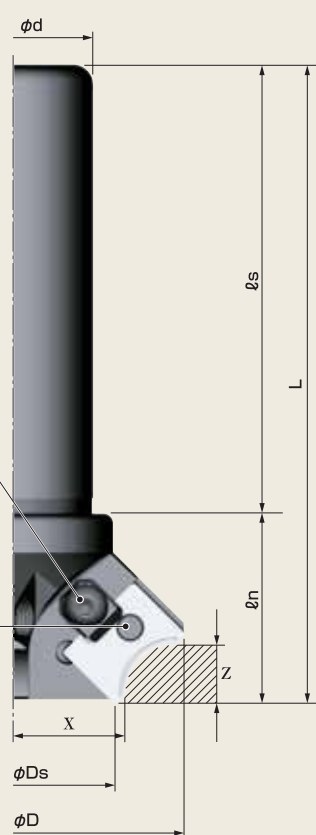
※ Inset is not supplied as standard accessory. Please order separately.

※ look pin and wrench are supplied as standard accessory.

## R-Nouveau

R5~R10

3Blade

Clamp piece  
CL-1SWrench  
K-3Lock Pin  
L-12Wrench  
K-4

## Easy Radius change !!

● Various Radius chamfering can be made by just exchanging Inserts

## Setting numerical values

Processing R	X-axis position (mm)	Z-axis position (mm)
R5	22.80	6.80
R6	22.25	7.32
R7	22.49	8.56
R8	22.80	9.80
R9	22.25	10.32
R10	22.80	11.80

● numeric value might get some errors, please acknowledge.

## R Chamfering



## Body

Model. No.	Blades	Dimensions (mm)					
		$\phi D$	$\phi D_s$	$\phi d$	L	$\ell_s$	$\ell_n$
NK25-70R	3	69.2	42.3	25	130	90	40
NK32-70R	3	69.2	42.3	32	130	90	40
NK32-70RL	3	69.2	42.3	32	200	150	50

※ Inset is not supplied as standard accessory. Please order separately.

※ look pin and wrench are supplied as standard accessory.



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.

## Processing Example (R-Nouveau Jr.)

### [Periphery R10 Chamfering process]

- Body : NK25-10R
- Insert : N54GCR-10R NK2020
- Material : Aluminum
- Rotational speed : 4,000r.p.m.
- Table feed : 800mm/min



### Result

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

## Processing Example (R-Nouveau)

- Body : NK32-70R
- Insert : N54GCR-10R NK2020
- Material : S50C
- Rotational speed : 1,300r.p.m.
- Table feed : 700mm/min



### Result

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

## Insert

N54GCR			
Material	Feed PerBlade (fz)	NK2020	NK6060
		Cutting speed(m / min)	
General Steel	0.1~0.3	100~250	
Alloy Steel	0.1~0.3	100~250	150~250
Stainless Steel	0.1~0.25	80~160	150~250
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

## Insert

Figure	ModelNo.	Material	Blade Shape	Coating	Usable corner	Quantity per box
<b>&lt;N54GCR&gt;</b> 	N54GCR-5R NK2020	Carbide M20		None	1	3
	N54GCR-8R NK2020	Carbide M20		None	1	3
	N54GCR-10R NK2020	Carbide M20		None	1	3
	N54GCR-5R NK6060	Carbide M20		TiAlN	1	3
<b>&lt;N54GCR Semistandard Insert&gt;</b> 	N54GCR-8R NK6060	Carbide M20		TiAlN	1	3
	N54GCR-10R NK6060	Carbide M20		TiAlN	1	3
	N54GCR-6R NK2020	Carbide M20		None	1	3
	N54GCR-7R NK2020	Carbide M20		None	1	3
	N54GCR-9R NK2020	Carbide M20		None	1	3

※ Semi standard Insert have no breaker