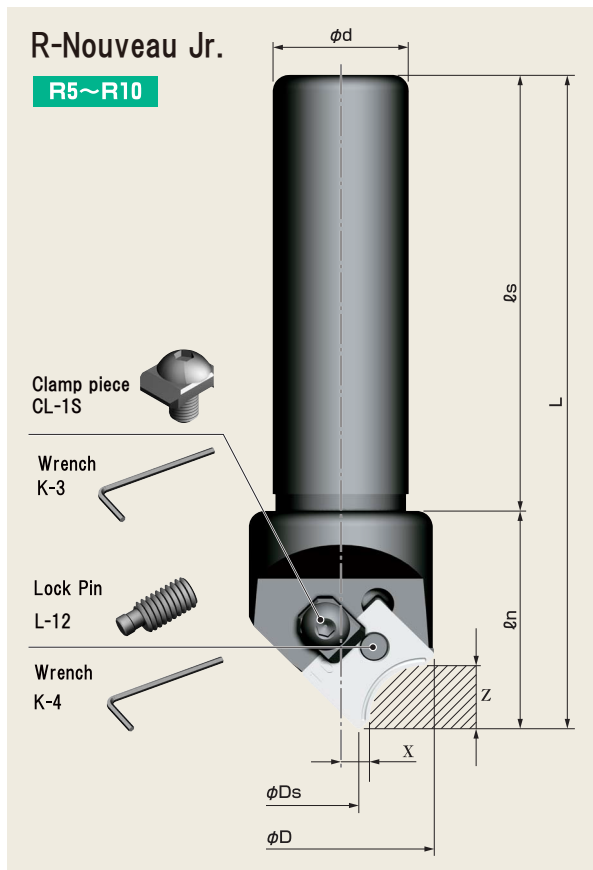


R-Nouveau Jr./R-Nouveau



Easy Radius change !!

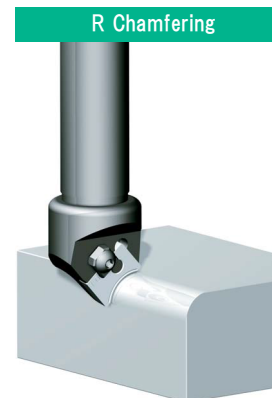
● Various Radius chamfering can be made by just exchanging Inserts

Setting numerical values

Processing R	X-axis position	Z-axis position
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

(mm)

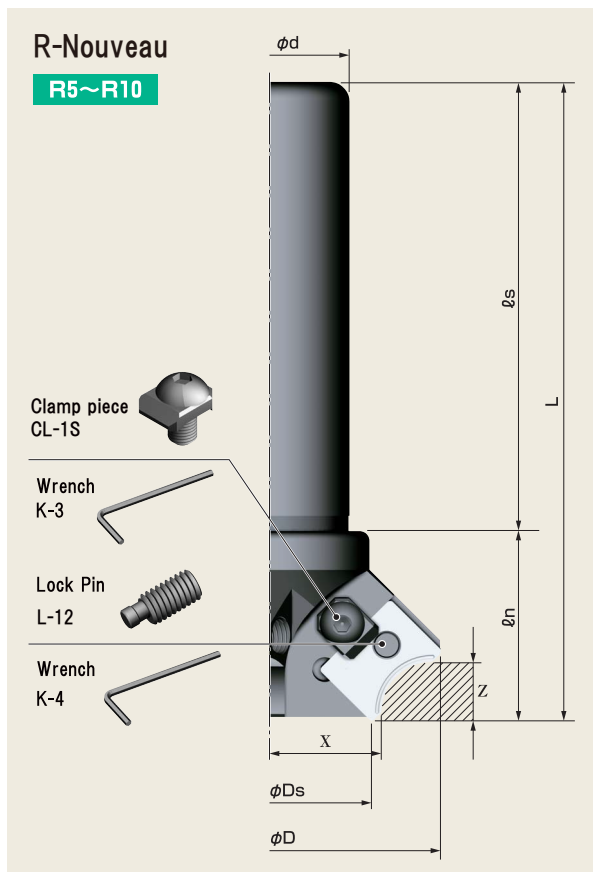
● numeric value might get some errors, please acknowledge.



Body

Model. No.	Blades	Dimensions (mm)					
		ϕD	ϕD_s	ϕd	L	ℓs	ℓn
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.



Easy Radius change !!

● Various Radius chamfering can be made by just exchanging Inserts

Setting numerical values

Processing R	X-axis position	Z-axis position
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

(mm)

● numeric value might get some errors, please acknowledge.



Body

Model. No.	Blades	Dimensions (mm)					
		ϕD	ϕD_s	ϕd	L	ℓs	ℓn
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.

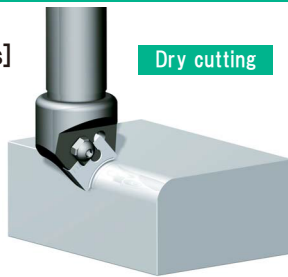


When mounting insert, please do not take reverse tightening.
Due to the eccentricity looking mechanism, poor accuracy or breakage of insert may be occurred
When replacing insert, please confirm whether you have been taking reserve tightening or not.

Processing Example (R-Nouveau Jr.)

[Periphery R10 Chamfering process]

- Body: NK25-10R
- Insert: N54GCR-10R NK2020
- Material A5052
- Rotational speed 4,000r.p.m.
- Table feed 800/min



Dry cutting

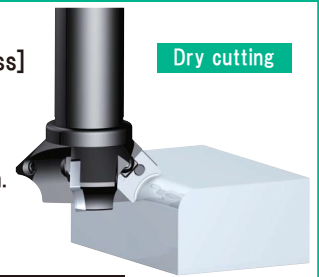
Result

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

Processing Example (R-Nouveau)

[Periphery R10 Chamfering process]

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



Dry cutting

Result

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

Cutting Conditions

N54GCR			
Material	Material Model	NK2020	NK6060
	Feed Per Blade (fz)	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	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
<p>Figure 5: N54GCR (15x20mm, R0.8, 4.76mm height, 90° chamfer)</p> <p>Figure 6: N54GCR Semistandard Insert (15x20mm, R0.8, 4.5mm height, 90° chamfer)</p> <p>※ Semi standard Insert have no breaker</p>	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
	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