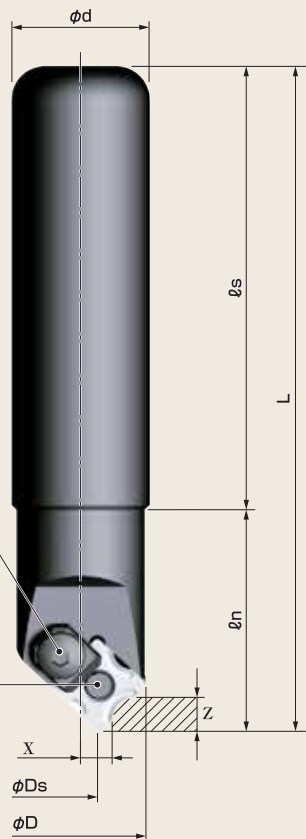


R-Special Jr. / R-Special

R-Special Jr.

R0.5~R5

1 Blade

Clamp piece
CL-1SWrench
K-3Lock Pin
L-14Wrench
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)
R0.5	8.05	4.42
R0.75	7.93	4.55
R1	7.80	4.67
R1.5	7.55	4.92
R2	7.30	5.17
R2.5	7.06	5.42
R3	6.81	5.67
R3.5	6.56	5.91
R4	6.31	6.16
R4.5	6.06	6.41
R5	5.82	6.66

● numeric value might get some errors, please acknowledge.

R Chamfering



Body

Model. No.	Blades	Dimensions (mm)					
		φD	φDs	φd	L	ℓs	ℓn
NK20-05R	1	25	8.4	20	120	80	40
NK25-05R	1	25	8.4	25	120	80	40

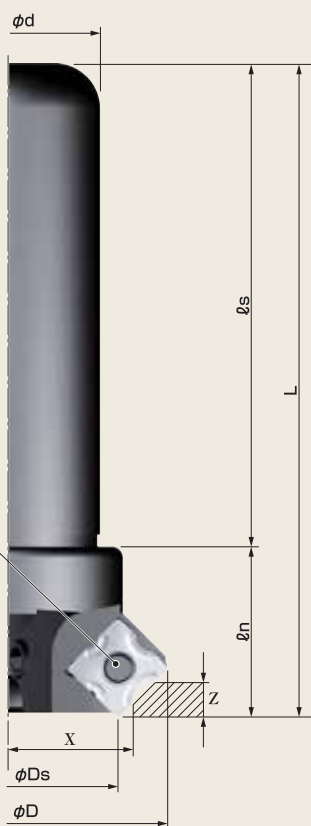
※ Inset is not supplied as standard accessory. Please order separately.

※ look pin and wrench are supplied as standard accessory.

R-Special

R0.5~R5

3 Blade

Lock 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)
R0.5	23.54	4.42
R0.75	23.42	4.54
R1	23.29	4.66
R1.5	23.04	4.91
R2	22.79	5.16
R2.5	22.54	5.41
R3	22.29	5.66
R3.5	22.04	5.91
R4	21.78	6.16
R4.5	21.53	6.41
R5	21.28	6.65

● numeric value might get some errors, please acknowledge.

R Chamfering



Body

Model. No.	Blades	Dimensions (mm)					
		φD	φDs	φd	L	ℓs	ℓn
NK20-40R-3	3	56	39.3	20	115	85	30
NK25-40R-3	3	56	39.3	25	115	85	30
NK32-40R-3	3	56	39.3	32	115	85	30



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-Special Jr.)

[R5 Chamfering process of $\phi 20$ hole Result]

- Body: NK25-05R
- Insert: N43GXR8-5R NK2020
- MaterialS45C
- Rotational speed ...2,500r.p.m.
- Table feed400mm/min

Dry cutting



Result

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

Processing Example (R-Special)

[Periphery R4 Chamfering process]

- Body: NK32-40R-3
- Insert: N43GXR8-4R AC16N
- MaterialSKD11
- Rotational speed ...1,200r.p.m.
- Table feed576mm/min

Dry cutting



Result

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

Cutting Conditions

N43GXR					
Material Model		NK2001	NK1010	NK2020	AC16N
Material	Feed Per Blade (fz)	Cutting Speed (m / min)			
General Steel	0.1~0.2	100~250		100~200	
Alloy Steel	0.1~0.2	100~250		100~200	150~200
Stainless Steel	0.1~0.2			80~160	150~200
Aluminum, Resin, Brass	0.1~0.3		150~300	150~300	
Castings	0.1~0.3	80~150 ※FCD	80~150	80~150	

- 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
(N43GXR8) 	N43GXR8 NK2001	Cermet	R1・2・3・4	None	8	3/12
	N43GXR8-1R NK2001	Cermet	The Same R Each corner	None	8	3/12
	N43GXR8-2R NK2001	Cermet	The Same R Each corner	None	8	3/12
	N43GXR8-3R NK2001	Cermet	The Same R Each corner	None	8	3/12
	N43GXR8-4R NK2001	Cermet	The Same R Each corner	None	8	3/12
	Semi standard					
(N43GXR) 	NEW N43GXR8-5R NK2001	Cermet	The Same R Each corner	None	8	3/12
	N43GXR NK1010	Carbide K10	R1・2・3・4	None	4	3/12
	NEW N43GXR8 NK2020	Carbide M20	R1・2・3・4	None	8	3/12
	NEW N43GXR8-1R NK2020	Carbide M20	The Same R Each corner	None	8	3/12
	NEW N43GXR8-2R NK2020	Carbide M20	The Same R Each corner	None	8	3/12
	NEW N43GXR8-3R NK2020	Carbide M20	The Same R Each corner	None	8	3/12
(N43GXR8 Semistandard Insert) 	NEW N43GXR8-4R NK2020	Carbide M20	The Same R Each corner	None	8	3/12
	NEW N43GXR8-0.5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12
	NEW N43GXR8-0.75R NK2020	Carbide M20	The Same R Each corner	None	8	3/12
	NEW N43GXR8-1.5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12
	NEW N43GXR8-2.5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12
	NEW N43GXR8-3.5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12
(N43GXR8 Semistandard Insert) 	NEW N43GXR8-4.5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12
	NEW N43GXR8-5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12
	NEW N43GXR8 AC16N	Fine particles Carbide	R1・2・3・4	AICrN	8	3/12
	NEW N43GXR8-1R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12
	NEW N43GXR8-2R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12
	NEW N43GXR8-3R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12
(N43GXR8 Semistandard Insert) 	NEW N43GXR8-4R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12
	NEW N43GXR8-0.5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12
	NEW N43GXR8-0.75R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12
	NEW N43GXR8-1.5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12
	NEW N43GXR8-2.5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12
	NEW N43GXR8-3.5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12
(N43GXR8 Semistandard Insert) 	NEW N43GXR8-4.5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12
	NEW N43GXR8-5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12

※ R0.5~R3.5 insert can be used for R Bit
 ※ Semi standard Insert have no breaker