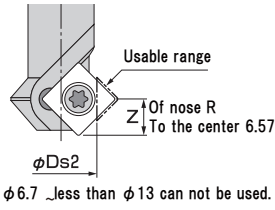


One pass chamfering!

- Enable front/reverse chamfering and V-grooving one pass

Cutting edge effective blade diameter $\phi 13$ more



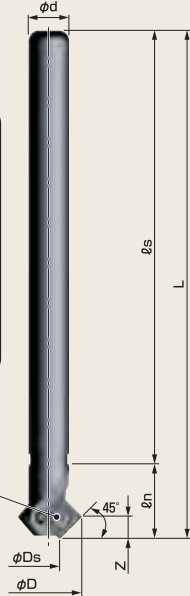
Clamp Screw

L-15

Wrench

N-6

1



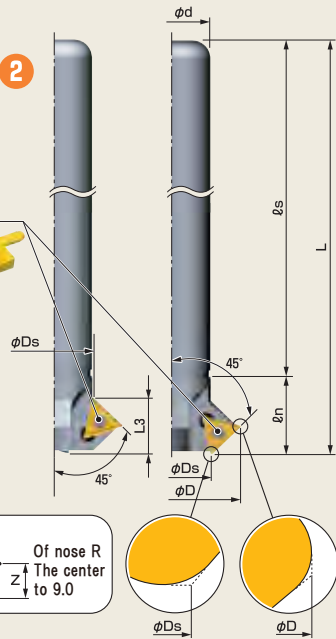
2

Clamp Screw

M-1

Wrench

MA-1



Corner Chamfering



Reverse chamfering



Side V-grooving



Model. No.	Capacity	
	Bore chamfering	
MRV12-19S	$\phi 13\text{mm} \sim \phi 19.5\text{mm}$	
RV16-35T	$\phi 18\text{mm} \sim \phi 35.9\text{mm}$	
RV25-46T	$\phi 28\text{mm} \sim \phi 45.6\text{mm}$	

Body

Model. No.	Fig.	Blades	Dimensions (mm)								Inserts	
			ϕD	ϕDs	$\phi Ds2$	ϕd	L	ℓs	ℓn	L3		Z
MRV12-19S	1	1	19.5	6.7	13	12	150	128	22	—	6.57	SPMT090304
RV16-35T	2	Staggered 2 blade	35.9	18	25	16	200	175	25	18.3	9.0	T22MOR
RV25-46T	2	Staggered 4 blade	45.6	28		25	200	175	25	17.9	9.0	T22MOR

- ※ Inset is not supplied as standard accessory. Please order separately.
- ※ Clamp screw wrench are supplied as standard accessory.

Cutting Conditions

Chamfering		
Material	Feed per blade (fz)	Cutting speed (m / min)
General Steel	0.05~0.2	100~150
Alloy Steel	0.05~0.2	100~150
Stainless Steel	0.05~0.2	80~120
Aluminum, Resin, Brass	0.08~0.25	150~400
Cast Steel	0.05~0.2	100~150

Side V Groove Processing		
Material	Feed per blade (fz)	Cutting speed (m / min)
General Steel	0.03~0.1	100~150
Alloy Steel	0.03~0.1	100~150
Stainless Steel	0.03~0.1	80~120
Aluminum, Resin, Brass	0.05~0.15	150~400
Cast Steel	0.03~0.1	100~150

- According to the shape of work, clamp condition and large or small chamfering amount, the cutting condition will have to be adjusted.
- In case of large amount chamfering process, please reduce the condition
- In case of chamfering process of Stainless steel, kindly take down cutting

Processing Example

[C2 chamfering]

- Body : RV25-46T
- Insert : T22MOR NK5050
- Material : SUS304
- Rotation Speed : 800r.p.m
- Table feed : 160mm/min
- Cutting Depth : 2mm
- Cutting Oil : None

Result

Good! Without secondary burrs and chattering



Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
	T22MOR NK5050	Carbide M10	Sharp edge	TiN	3	12
	SPMT090304 NK6060	Carbide M20	Honing edge	TiAlN	4	12