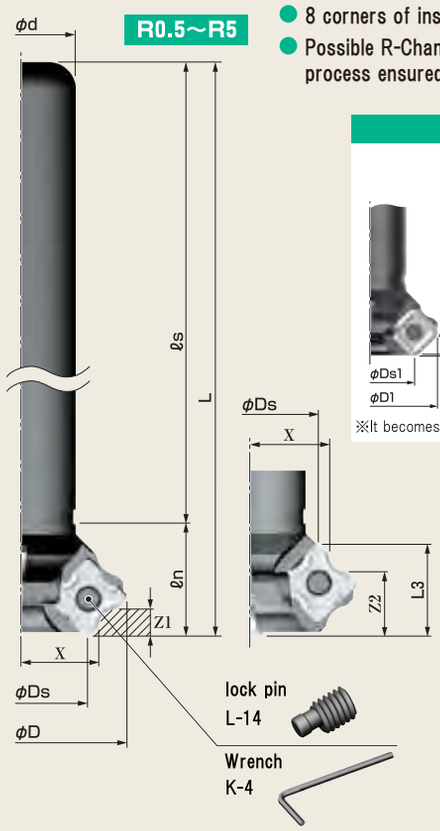
Ryanmencut-R [N TYPE]

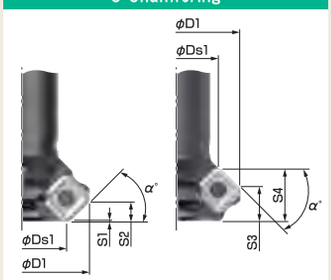
Staggered 4 Blade

Possible R-Chamfering And C-Chamfering process !



- 8 corners of inserts can be usable.
- Possible R-Chamfering And C-Chamfering process ensured by changing insert

C-Chamfering



※It becomes the size when mounting N43 MOZ.

C-Chamfering

R Chamfering

Cutting Conditions

Material	Material model number / Feed per blade (fz)	NK2001	NK1010	NK2020	AC16N
		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	
Cast Steel	0.1～0.3	80～150 ※FCD	80～150	80～150	

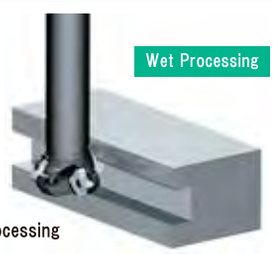
- According to the shape of work, clamp condition and large or small chamfering amount, the cutting condition will have to be adjusted.
- Yellow marked condition is recommended for the material listed
- In case of chamfering process of Stainless steel, kindly take down cutting

Processing Example

[Periphery R5 Chamfering process]

- Body : RR25-48N
- Insert: : N43GXR8-5R NK2020
  - Material ····· SUS304
  - Rotational speed ··· 3,000r.p.m.
  - Table feed ····· 200㎜/min

Wet Processing



Result

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

Body

Model. No.	blades	Dimensions (㎜)						
		φD	φDs	φd	L	ℓs	ℓn	L3
RR25-48N	4	48	31.3	25	200	175	25	20.5

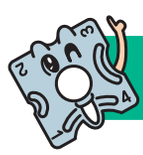
※ Insert is not equipped as standard accessory. Please purchase it separately
※ Clamp screw, screw,wrench and locator are supplied as standard accessories

Setting numerical values

Processing R	X-axis position (mm)	Z1-axis position (mm)	Z2-axis position (mm)
R0.5	19.55	4.42	16.08
R0.75	19.42	4.54	15.96
R1	19.30	4.66	15.84
R1.5	19.05	4.91	15.59
R2	18.80	5.16	15.34
R2.5	18.55	5.41	15.09
R3	18.29	5.66	14.84
R3.5	18.04	5.91	14.59
R4	17.79	6.16	14.34
R4.5	17.54	6.41	14.09
R5	17.29	6.65	13.85

- numeric value might get some errors, please acknowledge.

C chamfer insert
For details, see P105



R chamfer insert
For details, see P102

Insert	Processing type	RR25-48N						
		φD1	φDs1	S1	S2	S3	S4	α°
N43MOZ	C-Chamfering	32.99	46.32	–	6.62	12.22	18.84	45°

- C-Chamfering··· RR25-48N(N43MOZ : φ33.57～φ45.73)
- numeric value might get some errors, please acknowledge.

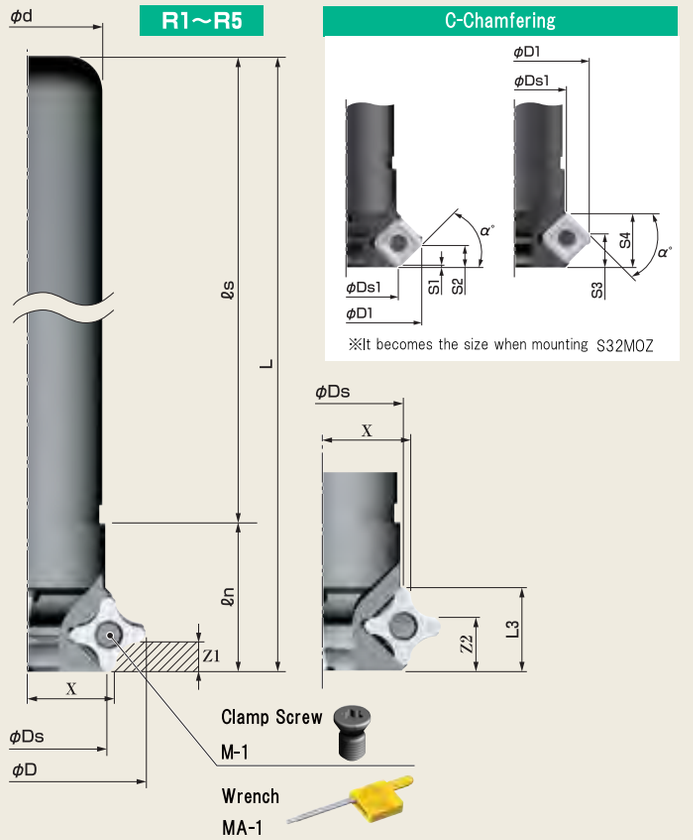
⚠ When mounting insert, please do not take reverse tightening.
Due to the eccentricity looking mechanism ,poor accuracy or breakage of insert may be occurred
When replacing insert, please confirm twhether you have been taking reserve tightening or not.

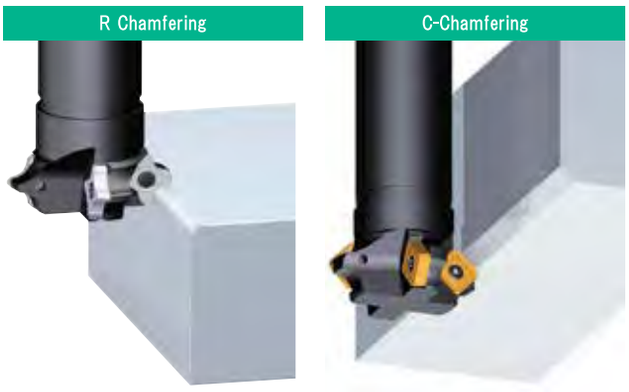
···P.114

Ryanmencut-R [S TYPE]

Possible R-Chamfering And C-Chamfering process !

- 8 corners of inserts can be usable.
- Possible R-Chamfering And C-Chamfering process ensured by changing insert





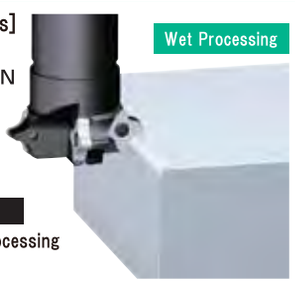
Cutting Conditions

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

Processing Example

[Periphery R4 Chamfering process]

- Body : RR25-40S-4R
- Insert: : SNEQ090308-4RM ZA20N
  - Material ····· SUS304
  - Rotational speed ··· 3,000r.p.m.
  - Table feed ····· 200㎜/min



Result

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

Body

Model. No.	Blades	Dimensions(㎜)						
		φD	φDs	φd	L	ℓs	ℓn	L3
RR16-30S-4R	2	30	17.9	16	200	175	25	16
RR16-30S-5R	2	30	17.9	16	200	175	25	16
RR25-40S-4R	4	40	27.8	25	200	175	25	16
RR25-40S-5R	4	40	27.8	25	200	175	25	16

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

Setting numerical values

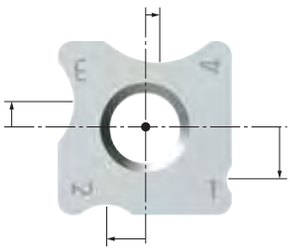
Insert	Processing R	RR16-30S			RR25-40S		
		X-axis position (mm)	Z1-axis position (mm)	Z2-axis position (mm)	X-axis position (mm)	Z1-axis position (mm)	Z2-axis position (mm)
SNEQ090308-1RY ZA20N	1R	9.48	1.53	14.47	14.44	1.53	14.47
SNEQ090308-2RY ZA20N	2R	9.48	2.52	13.48	14.44	2.52	13.48
SNEQ090308-3RY ZA20N	3R	9.48	3.52	12.48	14.44	3.52	12.48
SNEQ090308-4RY ZA20N	4R	9.48	4.51	11.49	14.44	4.51	11.49
SNEQ090308-XRY ZA20N	1·2·3·4R	–	–	–	–	–	–
SNEQ090308-1RM ZA20N	1R	11.44	3.55	12.45	16.42	3.55	12.45
SNEQ090308-2RM ZA20N	2R	10.94	4.04	11.96	15.92	4.04	11.96
SNEQ090308-3RM ZA20N	3R	10.45	4.54	11.46	15.42	4.54	11.46
SNEQ090308-4RM ZA20N	4R	9.95	5.04	10.96	14.92	5.04	10.96
SNEQ090308-5RM ZA20N	5R	9.46	5.50	10.5	14.42	5.5	10.5
SNEQ090308-XRM ZA20N	1·2·3·4R	–	–	–	–	–	–

Insert	Processing type	RR16-30S							RR25-40S						
		φD1	φDs1	S1	S2	S3	S4	α°	φD1	φDs1	S1	S2	S3	S4	α°
S32MOZ	C-Chamfering	29.19	18.70	0.40	5.64	10.36	15.60	45°	39.19	28.61	0.40	5.64	10.36	15.60	45°

- C-Chamfering···
  RR16-30S(S32MOZ : φ19.16～φ28.72) RR25-40S(S32MOZ : φ29.08～φ38.72)
- numeric value might get some errors, please acknowledge.

⚠ Notes on using RY Insert | Please install on the reverse side, front side correctly.

〈SNEQ090308-XRY〉



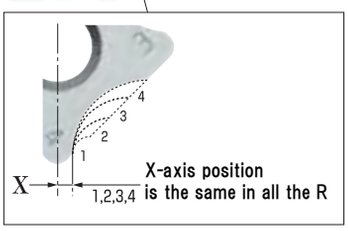
Misaligned from center R

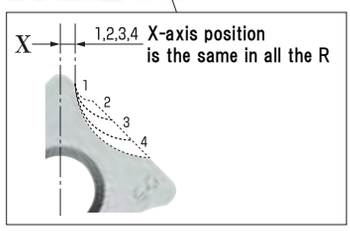
●Economical can use both sides

Surface chamfering

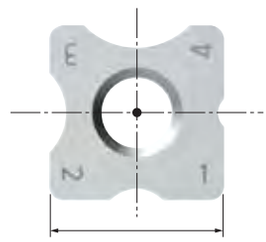
It is the table that it is notation 1234.

Back chamfering



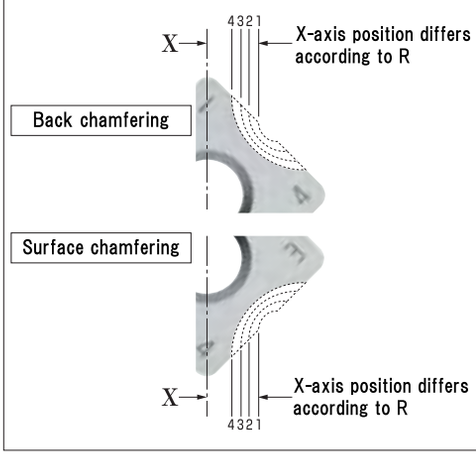


〈SNEQ090308-XRM〉

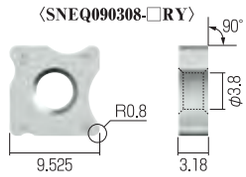
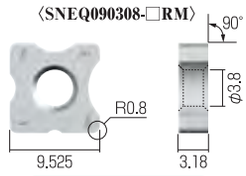
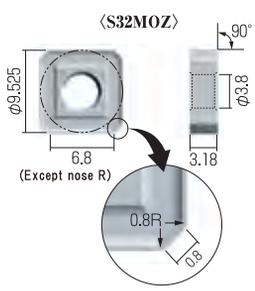


center R

●Economical can use both sides



Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
〈SNEQ090308-□RY〉  Misaligned from center R	SNEQ090308-1RY ZA20N	Carbide M20	The Same R Each corner	None	4+4	12
	SNEQ090308-2RY ZA20N	Carbide M20	The Same R Each corner	None	4+4	12
	SNEQ090308-3RY ZA20N	Carbide M20	The Same R Each corner	None	4+4	12
	SNEQ090308-4RY ZA20N	Carbide M20	The Same R Each corner	None	4+4	12
	SNEQ090308-XRY ZA20N	Carbide M20	R1・2・3・4	None	4+4	12
〈SNEQ090308-□RM〉  center R	SNEQ090308-1RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
	SNEQ090308-2RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
	SNEQ090308-3RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
	SNEQ090308-4RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
	SNEQ090308-5RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
	SNEQ090308-XRM ZA20N	Carbide M20	R1 2 3 4	None	8	12
〈S32MOZ〉 	S32MOZ NK2001	Cermet	Honing edge	None	8	12
	S32MOZ NK2050	Cermet	Honing edge	None	8	12
	S32MOZ AB01F	Cermet	Honing edge	AlCrN	8	12
	S32MOZ NK1010	Carbide K10	Sharp edge	None	8	12
	S32MOZ NK2020	Carbide M20	Honing edge	None	8	12
	S32MOZ NK3030	Carbide M20	Honing edge	TiN	8	12
	S32MOZ AC15T	Fine particles Carbide	Honing edge	AlCrN	8	12