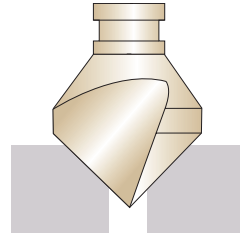
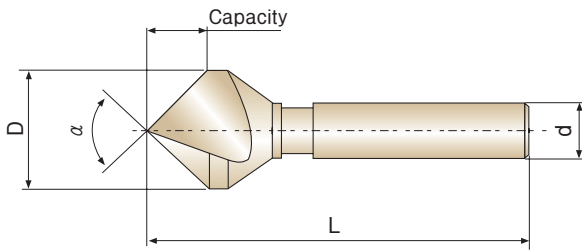


Single flute CHAMFERING CUTTERS



- » For wood and hard plastics.
- » Can drill in sheet materials.
- » Easy to resharpen.
- » Works without vibrations.

Tolerance			
D	α	d	L
+0.3	-1 °	h9	± 1

unit : mm

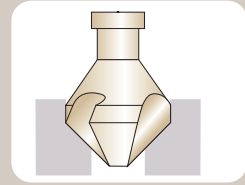
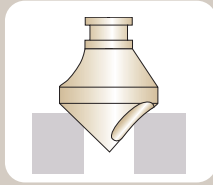
Angle α	Nominal Diameter D	Shank Diameter d	Over All Length L	Capacity min/max	EDP No. (uncoating)		
					M42	M35	M2
90 °	10.0	6.0	45.0	1 - 10	C1119100	C2119100	C3119100
	15.0	8.0	55.0	2 - 15	C1119150	C2119150	C3119150
	20.0	10.0	65.0	2 - 20	C1119200	C2119200	C3119200
	25.0	12.0	78.0	3 - 25	C1119250	C2119250	C3119250
	30.0	12.0	88.0	3 - 30	C1119300	C2119300	C3119300
	35.0	16.0	110.0	4 - 35	C1119350	C2119350	C3119350
	40.0	16.0	115.0	5 - 40	C1119400	C2119400	C3119400
	45.0	16.0	120.0	10 - 45	C1119450	C2119450	C3119450
	50.0	16.0	130.0	12 - 50	C1119500	C2119500	C3119500

* TiN & TiCN coating is available on your request.

COUNTERSINKS

RECOMMENDED CUTTING SPEED

V : Cutting Speed
S : Feed per Revolution



Material	V (mm/min)	S (mm/rev)			V (mm/min)	S (mm/rev)			V (mm/min)	S (mm/rev)		
		$\phi \leq 10$	$\phi \leq 20$	$\phi \leq 30$		$\phi \leq 10$	$\phi \leq 20$	$\phi \leq 30$		$\phi \leq 10$	$\phi \leq 20$	$\phi \leq 30$
Steels $\leq 500\text{N/mm}^2$	35-45	0.20	0.22	0.24	35-45	0.20	0.22	0.24	17-22	0.30	0.32	0.36
Steels 500~800N/mm ²	20-30	0.14	0.17	0.20	20-30	0.14	0.17	0.20	10-15	0.28	0.30	0.31
Steels 800~1000N/mm ²	15-20	0.11	0.12	0.14	15-20	0.11	0.12	0.14	8-12	0.24	0.26	0.28
Steels-Stainless Steel 1000~1300N/mm ²	12-15	0.10	0.12	0.15	12-15	0.10	0.12	0.15	6-8	0.20	0.20	0.22
Stainless Steels	6-8	0.07	0.08	0.09	6-8	0.07	0.08	0.09	4-6	0.08	0.09	0.10
Cast Iron	20-40	0.15	0.24	0.28	20-40	0.15	0.24	0.28	15-25	0.13	0.19	0.24
Aluminium	50-60	0.22	0.25	0.27	50-60	0.22	0.25	0.27	35-45	0.27	0.30	0.35
Brass-Bronze	30-40	0.23	0.25	0.28	30-40	0.23	0.25	0.28	20-30	0.30	0.30	0.31
Copper	20-30	0.22	0.25	0.27	20-30	0.22	0.25	0.27	10-15	0.29	0.30	0.31
Plastics	50-100	0.50	0.60	0.65	50-100	0.50	0.60	0.65	35-70	0.40	0.45	0.50

* TiN & TiCN coating is available on your request.