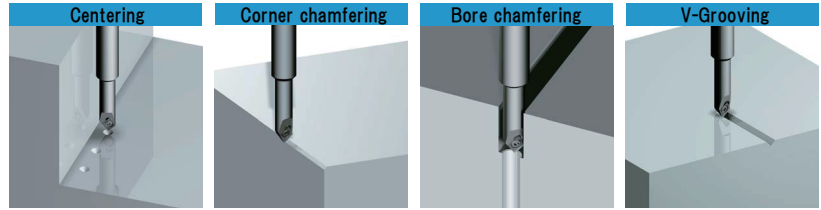


## Smallest Indexable Tools !

- Developed screw-on type smallest insert (under-neck diameter  $\phi 6\text{mm}$ ) This will be smallest insert in the existing market.
- Small diameter long neck prevents tool interference when processing in the deep area
- You can use this tool for engraving process



※ This tool cannot be used with drilling machines

Model.No.	Capacity		$\alpha^\circ$
	Bore chamfering		
SCN0845E	$\phi 0.6\text{mm} \sim \phi 6\text{mm}$		90°
SCN0830E	$\phi 0.6\text{mm} \sim \phi 7.4\text{mm}$		120°

### Body

Model.No.	blades	Dimensions (mm)							$\alpha^\circ$
		$\phi D$	$\phi d$	$\phi dn$	L	$\ell s$	$\ell n$	S	
SCN0845E	1	6	8	5.6	82	60	22	2.8	90°
SCN0830E	1	7.4	8	7	82	60	22	2.0	120°

- ※ Insert is not equipped as standard accessory. Please purchase it separately
- ※ Clamp screw wrench we have standard equipment.

**Z-value compensate standard**  
 ※ Please note that this value may be getting some errors

**Momimen Nano → +0.3**

[Example]  
 Correct Z-value (-2.5) to -2.2 in case of  $\phi 5\text{mm}$  spot drilling process

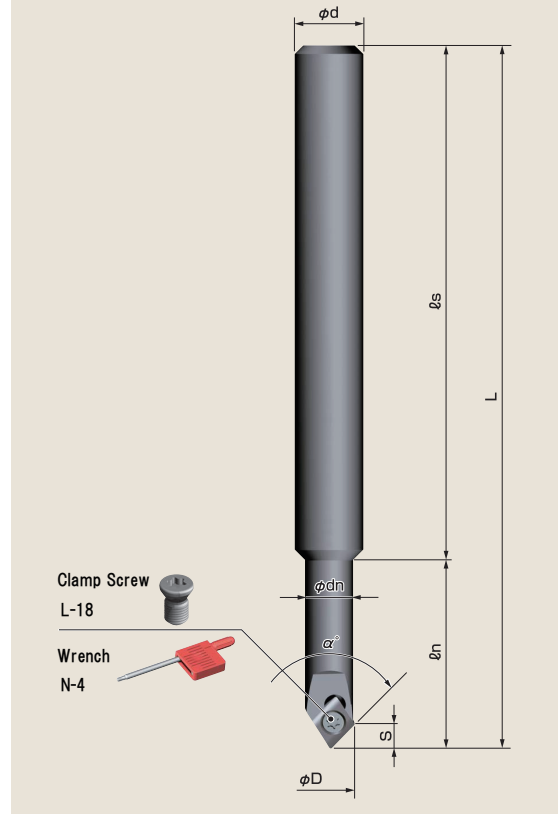
### Cutting Conditions

Centering			
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Coolant
General Steel	0.02~0.03	4,000~	Yes
Alloy Steel	0.02~0.03	4,000~	Yes
Stainless Steel	0.01~0.02	4,000~	Yes
Aluminum, Resin, Brass	0.05~0.08	4,000~	Yes
Castings	0.04~0.06	4,000~	Yes

Chamfering			
Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)	Coolant
General Steel	0.07~0.1	4,000~	Yes
Alloy Steel	0.07~0.1	4,000~	Yes
Stainless Steel	0.05~0.07	4,000~	Yes
Aluminum, Resin, Brass	0.1~0.15	4,000~	Yes
Castings	0.07~0.12	4,000~	Yes

V-groove processing			
Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)	Coolant
General Steel	0.05~0.07	4,000~	Yes
Alloy Steel	0.05~0.07	4,000~	Yes
Stainless Steel	0.03~0.05	4,000~	Yes
Aluminum, Resin, Brass	0.05~0.08	4,000~	Yes
Castings	0.04~0.06	4,000~	Yes

- In case of bore chamfering process by Z-axis only, please take same cutting condition of centering process
- According to the shape of work, large or small chamfering amount and position of blade, the cutting condition will have to be adjusted. In case of processing with large amount chamfer, please take reducing cutting condition
- In case of chamfering process of Stainless Steel, please take the down cutting

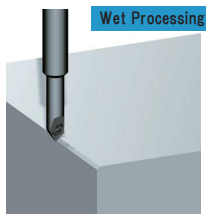


### Processing Example

#### [ Perimetry C2 Chamfering ]

- Body : SCN0845E
- Insert : ENGX040102 AC15N

- Material..... SUS304
- Rotation Speed... 5,000r.p.m.
- Feed (Z-axis) .... 350mm/min
- Cutting Depth..... C2
- Cutting Oil..... Yes



#### Result

Good!  
No secondary burrs and No chattering after processing

### Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
	ENGX040102 AC15N	Fine Particles Carbide	Honing Edge	AlCrN	2	12



Blade edge by V-grooving and centering processing could not be a perfect vertex angle