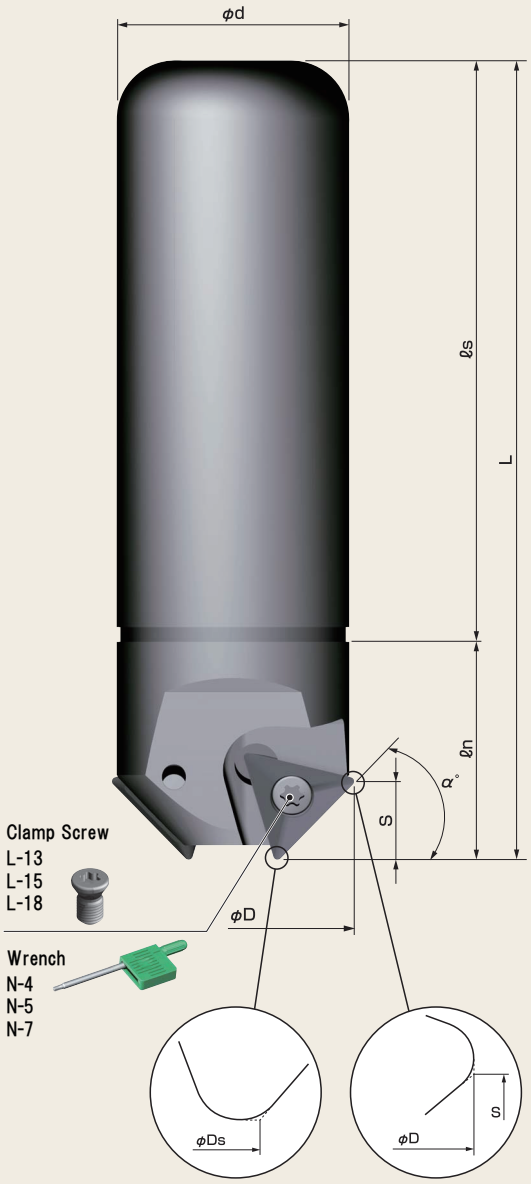
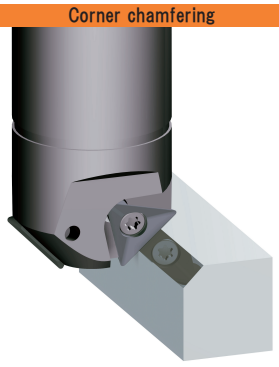
Chibieco2 / Momieco2 / Ecomen2

Cost Reduction !

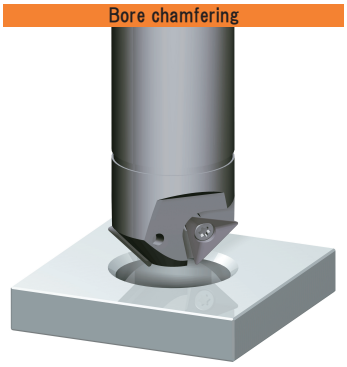
- Original insert have 3 usable corners and decrease the production cost widely
- Due to the improvement of blade shape and new coating, it is machinable more than any other insert, and chip(cuttings) release has been drastically improving
- Micro-grained Carbide with new coating made longer life of insert



Corner chamfering



Bore chamfering



※ This tool cannot be used with drilling machines

Product Name	Model. No.	Capacity Bore chamfering	α°
Chibieco2	NKS3018T	φ7.3～φ18.0	30°
	NKS4516T	φ7.3～φ15.9	45°
	NKS6017T	φ11.3～φ17.1	60°
Momieco2	NKM3025T	φ9.3～φ24.7	30°
	NKM4522T	φ9.3～φ21.7	45°
	NKM6023T	φ14.3～φ22.8	60°
Ecomen2	NKL3036T	φ11.3～φ36.3	30°
	NKL4534T	φ13.4～φ33.8	45°
	NKL6034T	φ20.4～φ34.8	60°

Cutting Conditions

Chamfering				
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.03～0.15	3,000～	TXMT16T306 AC15N	None(※)
Alloy Steel	0.03～0.15	3,000～	TXMT16T306 AC15N	None(※)
Stainless Steel	0.03～0.15	3,000～	TXMT16T306 AC15N	Yes
Aluminum,Resin,Brass	0.03～0.15	5,000～	TXMT16T306 ZA10N	Yes
Castings	0.03～0.15	3,000～	TXMT16T306 AC15N	None(※)

※ Please used as needed.
- 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 process with large amount chamfer, please take reducing cutting condition
- In case of chamfering process of stainless steel,please take the down cutting

Processing Example

[φ15 C5 Bore Chamfering]

- Body : NKL4534T
- Insert : TXMT16T306 AC15N

- Material·····SUS304
- Rotation Speed···4,500r.p.m.
- Feed (Z-axis) ····150/min
- Cutting Depth····C5
- Cutting Oil·····Yes

Result

Good!
No secondary burrs and
No chattering after processing

Wet Processing

Body

Product name	Model. No.	blades	Dimensions (mm) φD	φDs	φd	L	ℓs	ℓn	S	α°	Inserts	Accessories Clamp Screw	Wrench
Chibieco2	NKS3018T	2	18.6	7	16	95	80	15	3.3	30°	TXMT080206	L-18	N-4
	NKS4516T	2	16.5	7	16	95	80	15	4.7	45°	TXMT080206	L-18	N-4
	NKS6017T	2	17.7	11	16	95	80	15	5.8	60°	TXMT080206	L-18	N-4
Momieco2	NKM3025T	2	25.3	9	20	100	80	20	4.7	30°	TXMT110306	L-13	N-5
	NKM4522T	2	22.3	9	20	100	80	20	6.7	45°	TXMT110306	L-13	N-5
	NKM6023T	2	23.4	14	20	100	80	20	8.2	60°	TXMT110306	L-13	N-5
Ecomen2	NKL3036T	2	36.9	11	32	110	80	30	7.5	30°	TXMT16T306	L-15	N-7
	NKL4534T	2	34.1	13	32	110	80	30	10.5	45°	TXMT16T306	L-15	N-7
	NKL6034T	2	34.9	20	32	110	80	30	12.9	60°	TXMT16T306	L-15	N-7