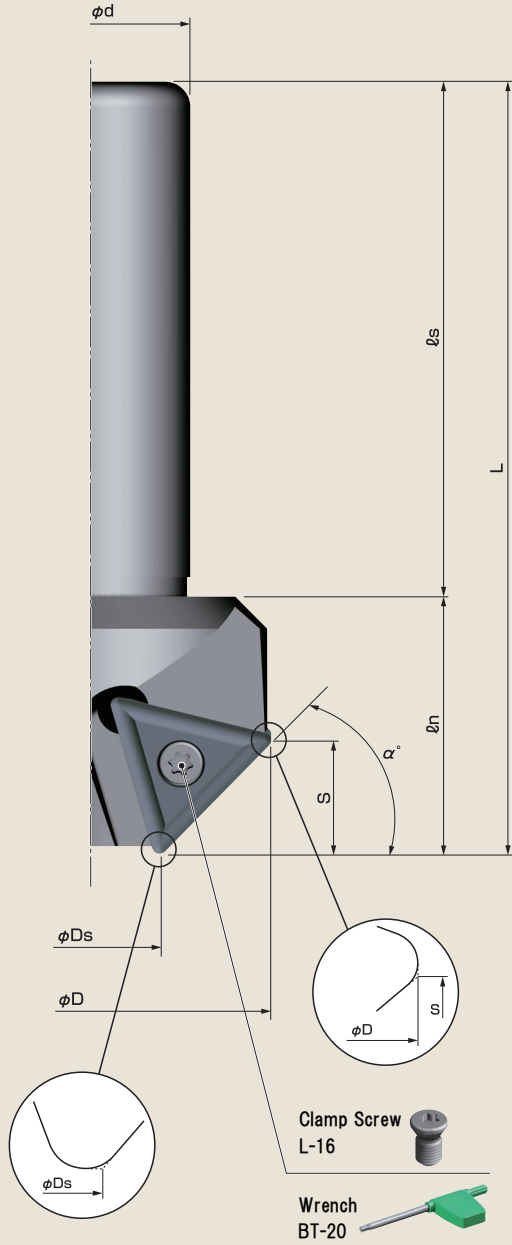
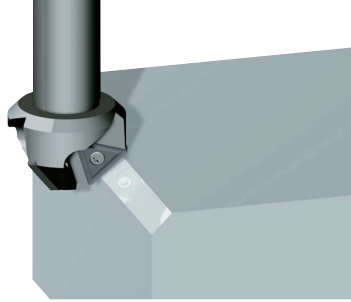


C15 Chamfering!

● Economical and Heavy Cutting



Corner Chamfering



Body

Model. No.	Blades	Dimensions(mm)							α°
		ϕD	ϕD_s	ϕd	L	l_s	l_n	S	
BNK4546T-1	1	46.5	12	32	120	80	40	17.2	45°
BNK3062T	3	62.2	20	32	120	80	40	11.8	30°
BNK4558T	3	58.2	23.8	32	120	80	40	17.2	45°
BNK6058T	3	58.2	33.8	32	120	80	40	21.1	60°

※ Insert is not equipped as standard accessory

※ Clamp screw and wrench are supplied as standard accessory

Cutting Conditions

		TNEX270412		TNMX270412	
		ZA10T	AA20T	AC15N	
Material	Feed per blade (fz)	Rotation speed (r.p.m.)			
General Steel	0.04~0.12		800~1500	800~1500	
Alloy Steel	0.04~0.12		800~1500	800~1500	
Stainless Steel	0.04~0.12		600~1200	600~1200	
Aluminum, Resin, Brass	0.06~0.18	2,500~4,000			
Cast Steel	0.04~0.12	800~1,500			

- 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

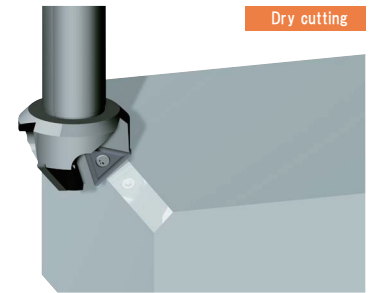
Processing Example

[C15 Chamfering]

- Body : BNK4558T
- Insert : TNMX270412 AA20T
- Material.....SUS304
- Rotation Speed...800r.p.m
- Table feed.....100mm/min
- Cutting Depth....C15
- Cutting Oil.....None

Result

Good!
By one pass process, C15 Chamfer has been successfully made without chattering



Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable Corner	Quantity per box
	TNEX270412 ZA10T	Carbide K10	Sharp edge	None	2	3
	TNMX270412 AA20T	Carbide M20	Honing edge	AlCrN	6	3
	TNMX270412 AC15N	Fine particles Carbide	Honing edge	AlCrN	6	3