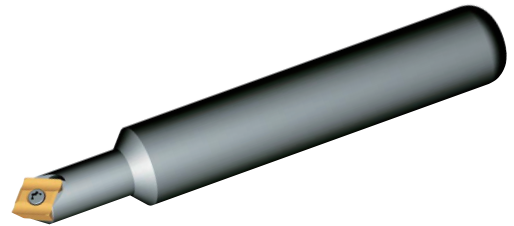
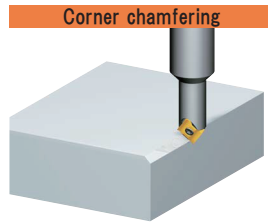


Applications use	Capacity												
	SNK1516C	SNK2016C	SNK2515C	SNK3015C	SNK3514C	SNK4013C	SNK4512C	SNK5014C	SNK5514C	SNK6015C	SNK6515C	SNK7014C	SNK7514C
α°	15°	20°	25°	30°	35°	40°	45°	50°	55°	60°	65°	70°	75°
Bore chamfering	$\phi 1.0 \sim \phi 16.0\text{mm}$	$\phi 2.0 \sim \phi 16.5\text{mm}$	$\phi 1.5 \sim \phi 15.5\text{mm}$	$\phi 1.5 \sim \phi 15.0\text{mm}$	$\phi 1.5 \sim \phi 14.0\text{mm}$	$\phi 1.5 \sim \phi 13.5\text{mm}$	$\phi 1.5 \sim \phi 12.5\text{mm}$	$\phi 5.0 \sim \phi 14.5\text{mm}$	$\phi 6.0 \sim \phi 14.5\text{mm}$	$\phi 7.5 \sim \phi 15.0\text{mm}$	$\phi 8.5 \sim \phi 15.0\text{mm}$	$\phi 9.5 \sim \phi 14.5\text{mm}$	$\phi 10.5 \sim \phi 14.0\text{mm}$

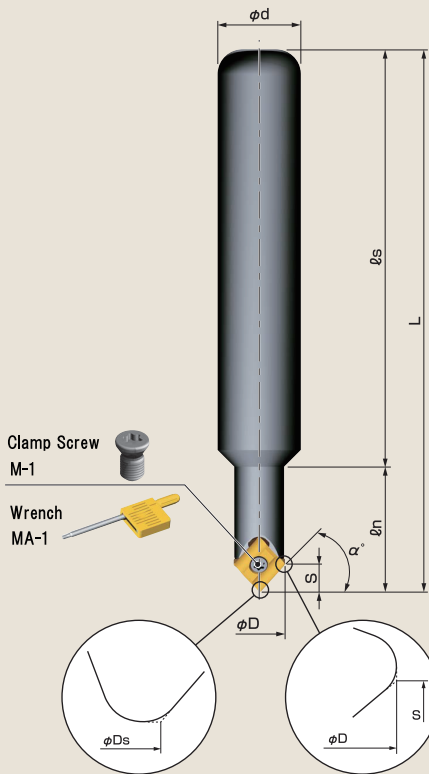
Small Diameter type!

- This tool was developed for Small Diameter processing
- You can choose angle 15°~75° (with 5° increments)
- Rich Inserts can be selected for various workpiece Processing



Body

Model. No.	Blades	Dimensions (mm)							α°
		ϕD	Minimum Processing diameter (ϕD_s)	ϕd	L	ℓ_s	ℓ_n	S	
SNK1516C	1	18.0	0.5	20	125	95	30	2.1	15
SNK2016C	1	18.2	1.1	20	125	95	30	2.8	20
SNK2515C	1	17.0	0.6	20	125	95	30	3.5	25
SNK3015C	1	16.3	0.7	20	125	95	30	4.5	30
SNK3514C	1	15.5	0.7	20	125	95	30	5.2	35
SNK4013C	1	14.6	0.8	20	125	95	30	5.9	40
SNK4512C	1	13.5	0.9	20	125	95	30	6.4	45
SNK5014C	1	15.5	4.0	20	125	95	30	7.0	50
SNK5514C	1	15.2	5.0	20	125	95	30	7.5	55
SNK6015C	1	15.6	6.7	20	125	95	30	7.3	60
SNK6515C	1	15.5	8.0	20	125	95	30	8.4	65
SNK7014C	1	15.1	9.0	20	125	95	30	8.7	70
SNK7514C	1	14.5	10.0	20	125	95	30	9.0	75

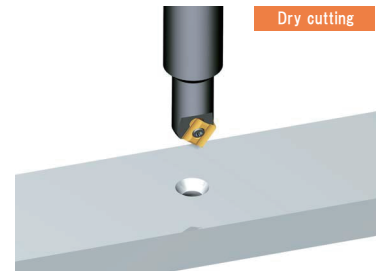


Clamp Screw M-1
Wrench MA-1

Processing Example

[$\phi 7\text{mm}$ Bore chamfering]

- Body : SNK6015C
- Insert : C32GUX AC15D
- Material.....SUS304
- Rotation Speed...3,000r.p.m.
- Cutting Speed....150mm/m
- Depth of Cut....Z-4.0
- Cutting Oil.....Yes



Cutting Conditions

Material	material Model	C32GUX									
		NK2001	NK1010	NK2020	NK3030	NK5050	NK6060	NK8080	AC15D	HSS	HSS TIN
General Steel	0.08~0.2	200~250		150~200	150~200		150~200		150~200	13~23	15~25
Alloy Steel	0.08~0.2	200~250		150~200	150~200		150~200		150~200	10~20	13~22
Stainless Steel	0.08~0.2			120~180	150~200	120~180	150~200	150~200	150~200	10~15	11~17
Aluminum, Resin, Brass	0.08~0.3		250~800			250~800		300~1,000		31~40	31~47
Castings	0.08~0.3	200~250 ※FCD									

- 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

Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
<p>(Except nose R)</p>	C32GUX NK2001	Cermet	Honing edge	None	2	12
	C32GUX NK1010	Carbide K10	Sharp edge	None	2	12
	C32GUX NK2020	Carbide M20	Honing edge	None	2	12
	C32GUX NK3030	Carbide M20	Honing edge	TiN	2	12
	C32GUX NK5050	Carbide K10	Sharp edge	TiN	2	12
	C32GUX NK6060	Carbide M20	Honing edge	TiAl ₂ N	2	12
	C32GUX NK8080	Carbide K10	Sharp edge	TiAl ₂ N	2	12
	C32GUX AC15D	Fine particles Carbide	Honing edge	AlCrN	2	12
	NEW C32GUX AC25D	Fine particles Carbide	Sharp edge	AlCrN	2	12
	C32GUX HSS	HSS	Sharp edge	None	2	12
	C32GUX HSS TiN	HSS	Sharp edge	TiN	2	12