

Body

Product Name	Model No.	Fig.	blades	Dimensions (mm)							Inserts
				φD	φD1	φDs	φd	L	Rs	Rn	
Eaglecut	EC12-8XX-M4	①	1	10.5	8	4	12	96	80	16	XX21MNX
	EC12-9.5XX-M5	①	1	11	9.5	5	12	99	80	19	XX21MNX
	EC12-11XX-M6	①	1	13	11	6	12	102	80	22	XX31MNX
	EC16-14XS-M8	②	2	19	14	8.4	16	108	80	28	XS22MNX
	EC20-17.5XS-M10	②	2	24	17.5	10.2	20	115	80	35	XS22MNX
	EC25-20XS-M12	②	2	26.6	20	13	25	120	80	40	XS22MNX
	EC25-23XS-M14	②	2	30.5	23	15	25	126	80	46	XS32MNX
	EC32-26XS-M16	②	2	33.7	26	17	32	132	80	52	XS32MNX
	EC32-29XS-M18	②	2	38	29	18.4	32	138	80	58	XS42MNX
	EC32-32XS-M20	②	2	41.7	32	20.4	32	144	80	64	XS42MNX
	EC32-35XS-M22	②	2	44.6	35	22.8	32	150	80	70	XS42MNX
	EC32-39XS-M24	②	2	50.2	39	24.2	32	158	80	78	XS53MNX
EC32-43XS-M27	②	2	54.1	43	28.2	32	166	80	86	XS53MNX	
EC32-48XS-M30	②	2	60.5	48	31.2	32	176	80	96	XS53MNX	
Birdiecut	BC16-14XS-M8	③	1	14		8.4	16	108	80	28	XS22MNX
	BC20-17.5XS-M10	③	1	17.5		10.2	20	115	80	35	XS22MNX
	BC20-20XS-M12	③	1	20		13	20	120	80	40	XS22MNX
	BC25-23XS-M14	③	1	23		15	25	126	80	46	XS32MNX
	BC32-26XS-M16	③	1	26		17	32	132	80	52	XS32MNX
	BC32-29XS-M18	③	1	29		18.4	32	138	80	58	XS42MNX
	BC32-32XS-M20	③	1	32		20.4	32	144	80	64	XS42MNX
	BC32-35XS-M22	③	1	35		22.8	32	150	80	70	XS42MNX
	BC32-39XS-M24	③	1	39		24.2	32	158	80	78	XS53MNX
	BC32-43XS-M27	③	1	43		28.2	32	166	80	86	XS53MNX
	BC32-48XS-M30	③	1	48		31.2	32	176	80	96	XS53MNX

※ Above Tools are supplied with NK2020 Insert

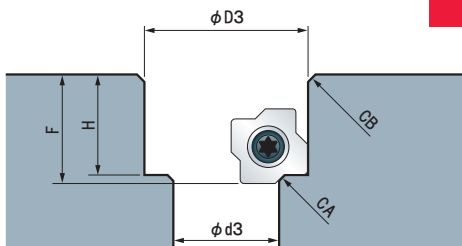
Cutting Conditions

Material	material Model	NK2020	NK6060
	Feed per blade (fz)	Cutting speed (m / min)	
General steel	0.05~0.1	50~100	50~100
Alloy steel	0.05~0.1	50~100	50~100
Stainless steel	0.05~0.1	40~80	40~80
Aluminum, resin, brass	×	×	×
Cast steel	0.05~0.1	50~100	50~100

- According to workpiece shape, large or small chamfering amount and position of blade the cutting conditions will have to be adjusted
- When chamfering in large amount, please take lowering cutting condition
- Coolant will be recommended
- Inset recommended for the workpiece

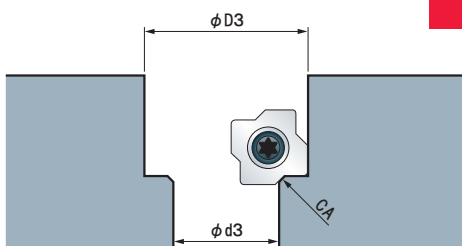


Eaglecut Processing Dimensional drawing



	M4	M5	M6	M8	M10	M12	M14	M16	M18	M20	M22	M24	M27	M30
φd3	φ4.5	φ5.5	φ6.6	φ9	φ11	φ14	φ16	φ18	φ20	φ22	φ24	φ26	φ30	φ33
φD3	φ8	φ9.5	φ11	φ14	φ17.5	φ20	φ23	φ26	φ29	φ32	φ35	φ39	φ43	φ48
CA	C0.3	C0.3	C0.3	C0.5	C0.5	C0.5	C0.5	C0.5	C0.5	C1	C1	C1	C1	C1
CB	C0.5	C0.5	C0.5	C1	C1	C1	C1	C1	C1	C1	C1	C1	C1	C1
H	4.4	5.4	6.5	8.6	10.8	13	15.2	17.5	19.5	21.5	23.5	25.5	29	32
F	4.95	5.95	7.1	9.4	11.7	14	16.2	18.5	20.8	22.8	25.1	27.4	30.9	33.9

Birdiecut Processing Dimensional drawing



	M8	M10	M12	M14	M16	M18	M20	M22	M24	M27	M30
φd3	φ9	φ11	φ14	φ16	φ18	φ20	φ22	φ24	φ26	φ30	φ33
φD3	φ14	φ17.5	φ20	φ23	φ26	φ29	φ32	φ35	φ39	φ43	φ48
CA	C0.5	C0.5	C0.5	C0.5	C0.5	C0.5	C0.5	C1	C1	C1	C1



Insert information P.45