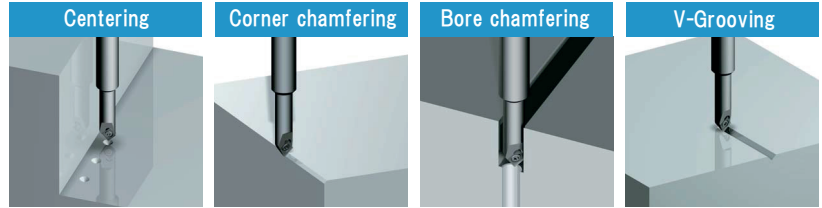




**Hogetex**  
Chamfering  
Deburring  
and  
Radius Tools

Developed screw-on type smallest insert (under-neck diameter  $\phi$  6mm).  
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

Dish Chamfering Processing (Min. Blade Diameter ~ Max. Blade Diameter)

90°  
 $\phi$ 0.6mm ~  $\phi$ 6mm

120°  
 $\phi$ 0.6mm ~  $\phi$ 7.4mm

### Body

Model. No.	Blades	Dimensions (mm)								$\alpha^\circ$
		$\phi$ D	$\phi$ Ds	$\phi$ d	$\phi$ dn	L	$\ell$ s	$\ell$ n	S	
SCN0845E	1	6	0.58	8	5.6	82	60	22	2.8	90°
SCN0830E	1	7.4	0.52	8	7	82	60	22	2.0	120°

Insert is not equipped as standard accessory. Please purchase it separately.  
We have the clamp screw wrench in our standard equipment.

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

$\alpha^\circ = 90^\circ \rightarrow +0.3$   
 $\alpha^\circ = 120^\circ \rightarrow +0.15$

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

### Cutting Conditions

Centering					
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant	
General Steel	0.02~0.03	4,000~	ENGX040102 AC15N	Yes	
Alloy Steel	0.02~0.03	4,000~	ENGX040102 AC15N	Yes	
Stainless Steel	0.01~0.02	4,000~	ENGX040102 AC15N	Yes	
Aluminum, Resin, Brass	0.05~0.08	4,000~	ENGX040102F ZC16N	Yes	
Castings	0.04~0.06	4,000~	ENGX040102 AC15N	None	

Chamfering					
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant	
General Steel	0.07~0.1	4,000~	ENGX040102 AC15N	Yes	
Alloy Steel	0.07~0.1	4,000~	ENGX040102 AC15N	Yes	
Stainless Steel	0.05~0.1	4,000~	ENGX040102 AC15N	Yes	
Aluminum, Resin, Brass	0.1~0.15	4,000~	ENGX040102F ZC16N	Yes	
Castings	0.07~0.12	4,000~	ENGX040102 AC15N	None	

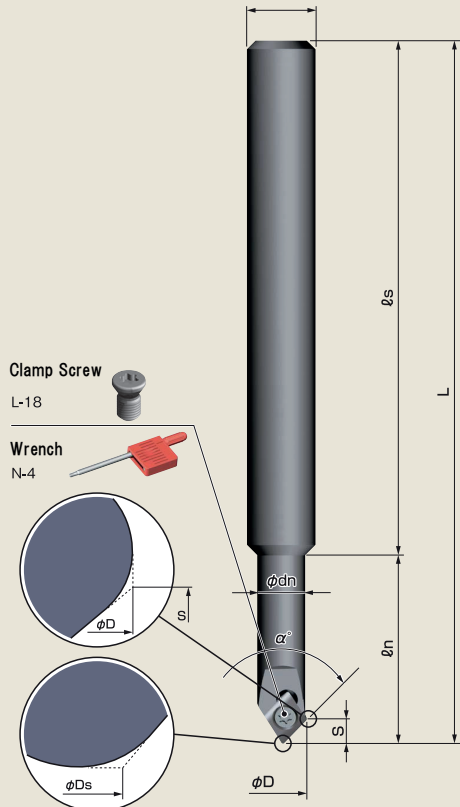
V-groove processing					
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant	
General Steel	0.05~0.07	4,000~	ENGX040102 AC15N	Yes	
Alloy Steel	0.05~0.07	4,000~	ENGX040102 AC15N	Yes	
Stainless Steel	0.03~0.05	4,000~	ENGX040102 AC15N	Yes	
Aluminum, Resin, Brass	0.05~0.08	4,000~	ENGX040102F ZC16N	Yes	
Castings	0.04~0.06	4,000~	ENGX040102 AC15N	None	

● 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

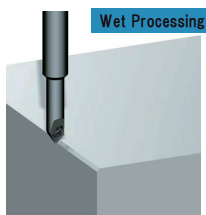


### Processing Example

#### [ Perimetry C2 Chamfering ]

Body : SCN0845E  
Insert : ENGX040102 AC15N

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



#### Result

No secondary burrs. No chattering after processing

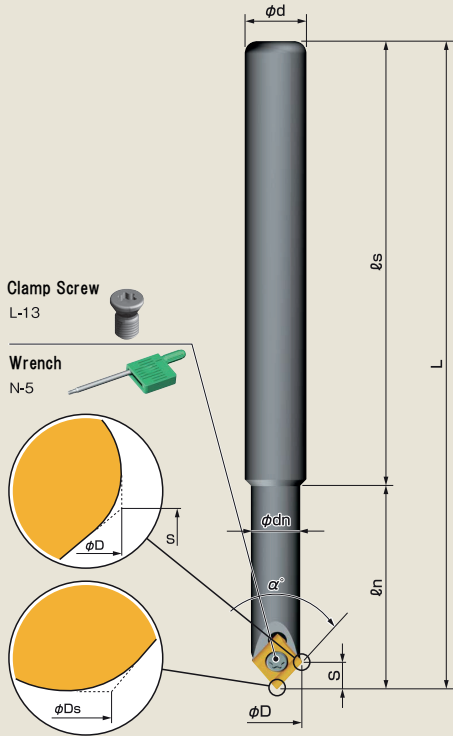
### Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
	<b>NEW</b> ENGX040102F ZC16N	Fine particles Carbide	Sharp edge	None	2	12
	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

Center-drilling and chamfer process can be done by this tool. You can reduce numbers of ATC tooling by using this tool and make high productivity!  
Original insert shape designed by us solves the risk of chattering and breakage.



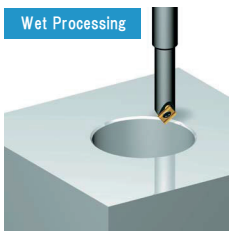
- Carbide made shank increased rigidity and limit of spotting has been much improved with the standard long shank, Protruding limit is now high.
- This tool have (φ10) Shank and (φ9) Blade, and can be used at narrow area

### Processing Example

#### [φ100 Bore Chamfering]

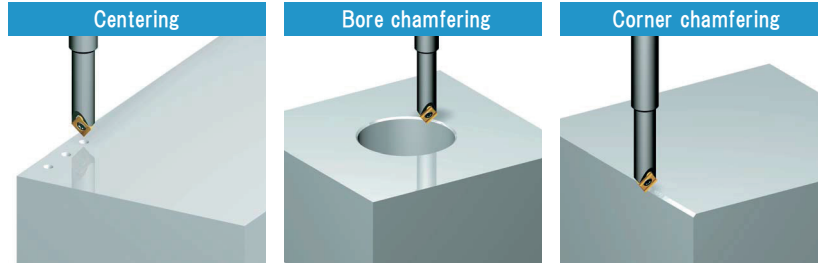
- Body : SCM1045C
- Insert : C22GUX NK5050

- Material ..... SUS304
- Rotation Speed ..... 5,000r.p.m.
- Feed (Z-axis) ..... 500mm/min
- Cutting Depth ..... C1
- Cutting Oil ..... Yes



#### Result

800pcs process has successfully done without size change, secondary burrs and alternant sound during processing



※ This tool cannot be used with drilling machines

### Dish Chamfering Processing (Min. Blade Diameter ~ Max. Blade Diameter)

90°  
φ0.6mm ~ φ9mm

### Body

Model. No.	Blades	Dimensions (mm)								α°	Carbide Shank
		φD	φDs	φd	φdn	L	ls	ln	S		
SCM1045C	1	9	0.5	10	8	105	72	33	4.4	90°	●
SCM1045CL	1	9	0.5	10	8	165	132	33	4.4	90°	
SCM1045CL-CB	1	9	0.5	10	8	165	145	20	4.4	90°	

Insert is not equipped as standard accessory. Please purchase it separately.  
We have the clamp screw wrench in our standard equipment.

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

α° = 90° → +0.2  
[Example]  
Correct Z-value(-4.0)to -3.8in case of φ8mm spot drilling process

### Cutting Conditions

Centering				
Material	Feed Per Blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.05~0.08	2,000~3,500	C22GUX NK2020	Yes
Alloy Steel	0.05~0.08	2,000~3,500	C22GUX NK3030	Yes
Stainless Steel	0.05~0.08	2,000~3,500	C22GUX AC16N	Yes
Aluminum,Resin,Brass	0.05~0.1	3,000~	C22GUX NK1010	Yes
Castings	0.05~0.08	2,000~3,500	C22GUX NK3030	Yes

Chamfering				
Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.1~0.15	2,000~	C22GUX NK2020	Yes
Alloy Steel	0.1~0.15	2,000~	C22GUX NK3030	Yes
Stainless Steel	0.1~0.15	2,000~	C22GUX AC16N	Yes
Aluminum,Resin,Brass	0.1~0.15	3,000~	C22GUX NK1010	Yes
Castings	0.1~0.15	2,000~	C22GUX NK3030	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 process with large amount chamfer, please take reducing cutting condition
- In case of chamfering process of stainless steel, please take the down cutting

### Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
<p>(Except nose R)</p>	C22GUX NK1010	Carbide K10	Sharp edge	None	2	12
	C22GUX NK2020	Carbide M20	Honing edge	None	2	12
	C22GUX NK3030	Carbide M20	Honing edge	TiN	2	12
	C22GUX NK5050	Carbide K10	Sharp edge	TiN	2	12
	C22GUX NK6060	Carbide M20	Honing edge	TiAlN	2	12
	C22GUX NK8080	Carbide K10	Sharp edge	TiAlN	2	12
	C22GUX AC16N	Fine particles Carbide	Sharp edge	AlCrN	2	12
	C22GUX AC16N	Fine particles Carbide	Honing edge	AlCrN	2	12

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

Center-drilling and chamfer process can be done by this tool. You can reduce numbers of ATC tooling by using this tool and make high productivity! Original insert shape designed by us solves the risk of chattering and breakage.



※ This tool cannot be used with drilling machines

### Dish Chamfering Processing (Min. Blade Diameter ~ Max. Blade Diameter)

**90°**  
φ2mm ~ φ13.5mm

**118°**  
φ2mm ~ φ16.15mm

### Body

Model. No.	Blades	Dimensions (mm)								α°
		φD	φDs	φd	φdn	L	ℓs	ℓn	S	
SC1045C	1	13.5	1.0	10	13	110	82	28	6.3	90°
SC1245C	1	13.5	1.0	12	13	110	82	28	6.3	90°
SC1645C	1	13.5	1.0	16	13	110	82	28	6.3	90°
SC1645CL	1	13.5	1.0	16	13	200	172	28	6.3	90°
SC1630C	1	16.15	0.39	16	16.5	110	82	28	4.6	118°
SC1630CL	1	16.15	0.39	16	16.5	200	172	28	4.6	118°

Insert is not equipped as standard accessory. Please purchase it separately. Lock Pin is supplied as standard accessory.

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

α° = **90°** → +0.45  
 α° = **118°** → +0.2

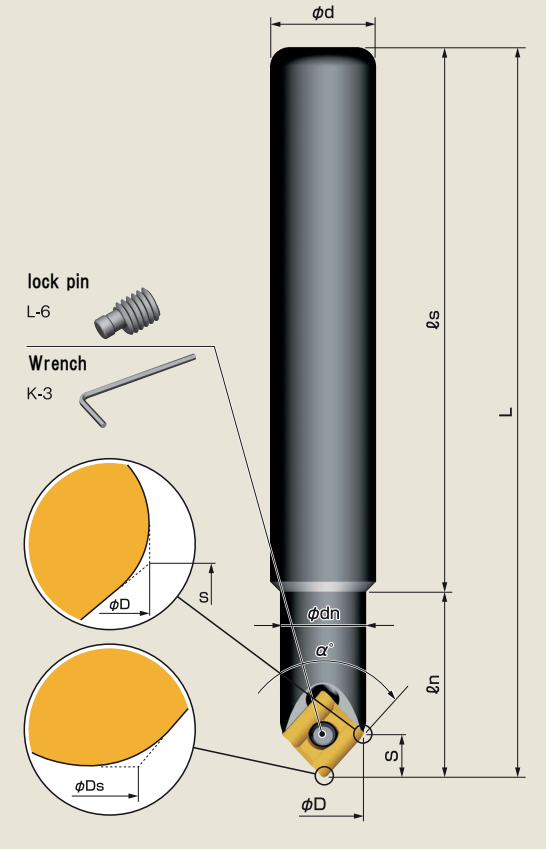
[Example]  
 Correct Z-value(-6.0) to -5.55 in case of φ12mm spot drilling process

### Cutting Conditions

Centering				
Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.05~0.1	1,500~3,000	C32GUX NK2020	Yes
Alloy Steel	0.05~0.1	1,500~3,000	C32GUX NK3030	Yes
Stainless Steel	0.05~0.1	1,500~3,000	C32GUX AC15D	Yes
Aluminum, Resin, Brass	0.05~0.2	3,000~	C32GUX NK1010	Yes
Castings	0.05~0.1	1,500~3,000	C32GUX NK3030	Yes

Chamfering				
Material	Feed per blade (fz)	Rotation speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.1~0.2	2,000~	C32GUX NK2001	None
Alloy Steel	0.1~0.2	2,000~	C32GUX NK2001	None
Stainless Steel	0.1~0.2	2,000~	C32GUX AC15D	Yes
Aluminum, Resin, Brass	0.1~0.2	3,000~	C32GUX NK1010	Yes
Castings	0.1~0.2	2,000~	C32GUX NK2001	None

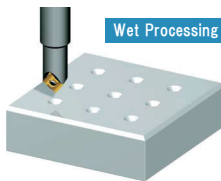
- In case of bore chamfering process by Z-axis only, please take same cutting condition of centering process
- According to the shape of work, large or small chamfering, amount and position of blade, the cutting condition will have to be adjusted.
- In case of process with large amount chamfer, please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



### Processing Example

[φ8 of Centering Processing, Circumference C3 Chamfering]

- Body : SC1645C
- Insert : C32GUX NK3030
- Material.....S45C
- Rotation Speed...3,500r.p.m
- Feed (Z-axis).....100mm/min
- Feed (X-axis).....300mm
- Cutting Oil.....Yes



Result

No secondary burrs and no chattering process

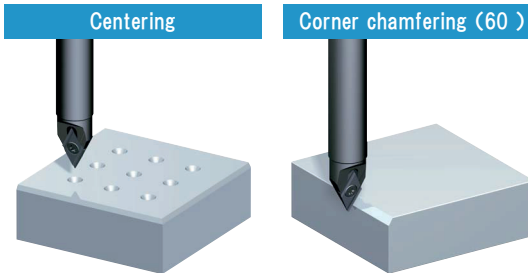
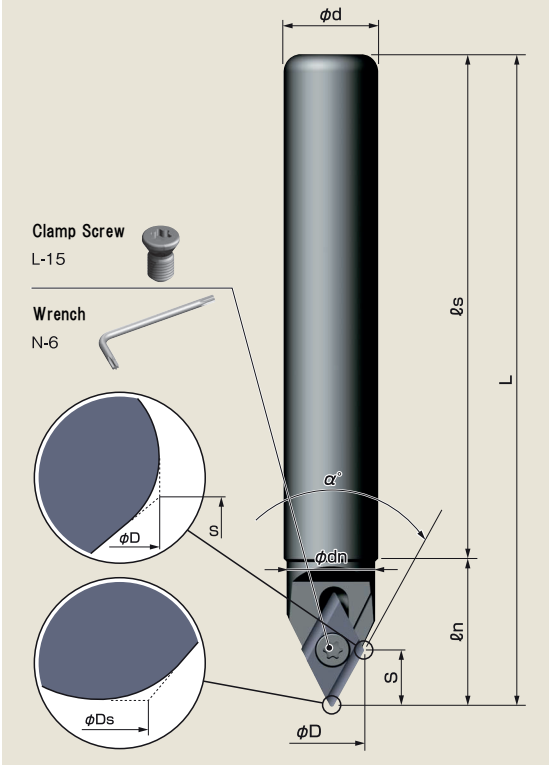
### Insert

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	TiAlN	2	12
	C32GUX NK8080	Carbide K10	Sharp edge	TiAlN	2	12
	C32GUX AC15D	Fine particles Carbide	Honing edge	AlCrN	2	12
	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



Blade edge by centering processing could not be a perfect vertex angle  
 When mounting insert, please do not take reverse tightening.  
 Due to the eccentricity looking mechanism, poor accuracy or breakage of insert may be occurred  
 When replacing insert, please confirm whether you have been taking reserve tightening or not.

Throw-away type tool ensured no alignment work. Center-drilling and chamfer process can be done by tool. You can reduce numbers of ATC tooling and ensured high speed cutting and high productivity. Slim body (shank:  $\phi 16\text{mm}$  and  $\phi 12\text{mm}$  blade) is suitable for work at narrow areas.



※ This tool cannot be used with drilling machines

### Dish Chamfering Processing (Min. Blade Diameter ~ Max. Blade Diameter)

60°  
 $\phi 1.2\text{mm} \sim \phi 11.88\text{mm}$

### Body

Model. No.	Blades	Dimensions (mm)								$\alpha^\circ$
		$\phi D$	$\phi D_s$	$\phi d$	$\phi d_n$	L	$l_s$	$l_n$	S	
SC1660DS	1	11.88	0.97	16	15	110	85	25	9.4	60°
SC1660DSL	1	11.88	0.97	16	15	200	175	25	9.4	60°

Inset is not equipped as standard accessory. Please purchase it separately. We have the clamp screw wrench in our standard equipment.

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

$\alpha^\circ = 60^\circ \rightarrow +0.82$

[Example] --- Correct Z-value (-8.66) to -7.84 in case of  $\phi 10\text{mm}$  centering process

### Cutting Conditions

Centering				
Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.03~0.05	3,000~3,500	DCET11X304 AC15N	Yes
Alloy Steel	0.03~0.05	3,000~3,500	DCET11X304 AC15N	Yes
Stainless Steel	0.03~0.05	3,000~3,500	DCET11X304 AC15N	Yes
Aluminum, Resin, Brass	0.03~0.08	3,000~	DCET11X304 ZA10N	Yes
Castings	0.03~0.05	3,000~3,500	DCET11X304 AC15N	Yes

Chamfering				
Material	Feed Per Blade (fz)	Rotation Speed (r.p.m.)	Recommended Insert	Coolant
General Steel	0.1~0.15	2,000~	DCET11X304 AC15N	Yes
Alloy Steel	0.1~0.15	2,000~	DCET11X304 AC15N	Yes
Stainless Steel	0.1~0.15	2,000~	DCET11X304 AC15N	Yes
Aluminum, Resin, Brass	0.1~0.2	3,000~	DCET11X304 ZA10N	Yes
Castings	0.1~0.15	2,000~	DCET11X304 AC15N	Yes

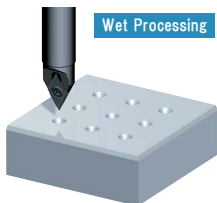
- In case of bore chamfering process by Z-axis only, please take same cutting condition of centering process
- According to the shape of work, large or small chamfering amount and position of blade, the cutting condition will have to be adjusted.
- In case of process with large chanfer, please take reducing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

### Processing Example

[ $\phi 12$  of Centering, Perimetry chamfering]

- Body : SC1660DS
- Insert : DCET11X304 AC15N

- Material ..... S45C
- Rotation Speed ... 3,500r.p.m
- Feed (Z-axis) ... 100mm/min
- Cutting Depth ... 300mm/min
- Cutting Oil ..... Yes



Result

No secondary burrs and no chattering process

### Insert

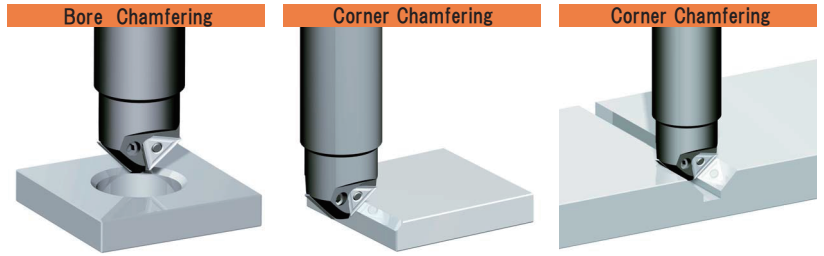
Figure	Model.No.	Material	Blade Shape	Coating	Usable Corner	Quantity per box
	DCET11X304 ZA10N	Carbide K10	Sharp edge	None	2	12
	DCET11X304 AC15N	Fine Particles Carbide	Sharp edge	AlCrN	2	12
	DCET11X304E AC16N	Fine Particles Carbide	Honing edge	AlCrN	2	12



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

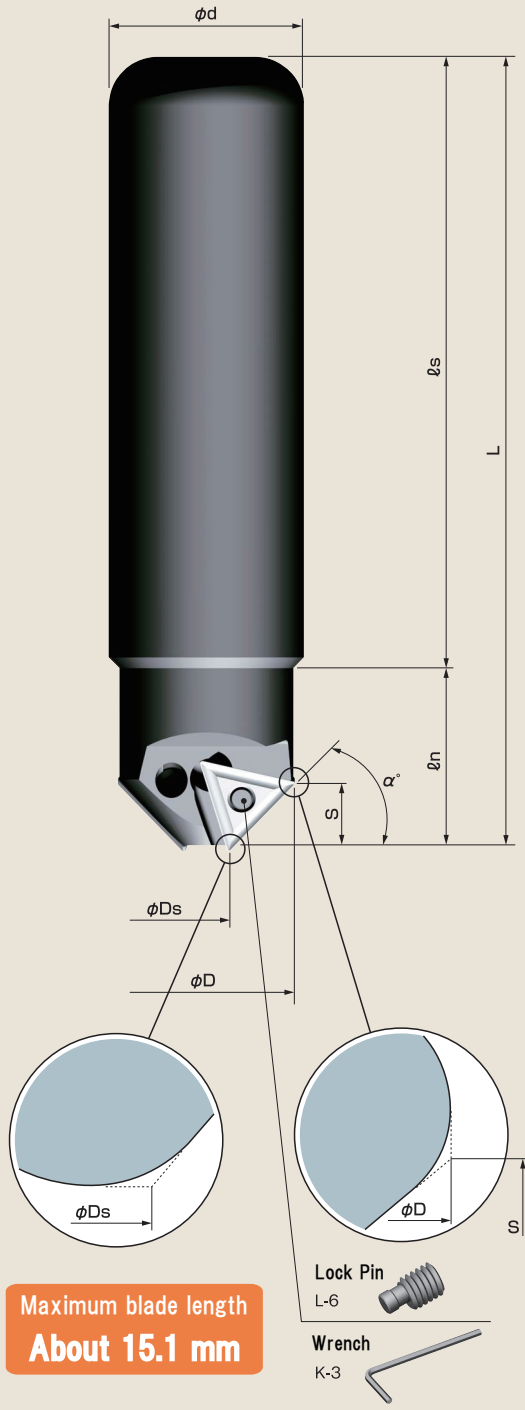
Applications use	Capacity												
	NK1536T	NK2035T	NK2535T	NK3030T	NK3532T	NK4031T	NK4530T	NK5031T	NK5532T	NK6030T	NK6533T	NK7032T	NK7533T
$\alpha^\circ$	15°	20°	25°	30°	35°	40°	45°	50°	55°	60°	65°	70°	75°
Bore chamfering	$\phi 8 \sim 36\text{mm}$	$\phi 8 \sim 36\text{mm}$	$\phi 8 \sim 35\text{mm}$	$\phi 8 \sim 33\text{mm}$	$\phi 8 \sim 32\text{mm}$	$\phi 8 \sim 31\text{mm}$	$\phi 8 \sim 29\text{mm}$	$\phi 12 \sim 31\text{mm}$	$\phi 15 \sim 32\text{mm}$	$\phi 15 \sim 30\text{mm}$	$\phi 20 \sim 33\text{mm}$	$\phi 22 \sim 32\text{mm}$	$\phi 25 \sim 33\text{mm}$

Angle 15° - 75° (By 5°increments) can be chosen according your application.  
 Insert available are rich and will meet with various applications you may need.



### Body

Model. No.	Blades	Dimensions (mm)							$\alpha^\circ$
		$\phi D$	Minimum cutting diameter $\phi D_s$	$\phi d$	L	$\ell_s$	$\ell_n$	S	
NK1536T-20	2	37.9	8	20	130	100	30	4.0	15°
NK1536T-25	2	37.9	8	25	130	100	30	4.0	15°
NK1536T	2	37.9	8	32	130	100	30	4.0	15°
NK1536TL	2	37.9	8	32	170	140	30	4.0	15°
NK2035T-20	2	37.1	8	20	130	100	30	5.3	20°
NK2035T-25	2	37.1	8	25	130	100	30	5.3	20°
NK2035T	2	37.1	8	32	130	100	30	5.3	20°
NK2035TL	2	37.1	8	32	170	140	30	5.3	20°
NK2535T-20	2	36.0	8	20	130	100	30	6.5	25°
NK2535T-25	2	36.0	8	25	130	100	30	6.5	25°
NK2535T	2	36.0	8	32	130	100	30	6.5	25°
NK2535TL	2	36.0	8	32	170	140	30	6.5	25°
NK3030T-20	2	34.8	8	20	130	100	30	7.7	30°
NK3030T-25	2	34.8	8	25	130	100	30	7.7	30°
NK3030T	2	34.8	8	32	130	100	30	7.7	30°
NK3030TL	2	34.8	8	32	170	140	30	7.7	30°
NK3532T-20	2	33.3	8	20	130	100	30	8.9	35°
NK3532T-25	2	33.3	8	25	130	100	30	8.9	35°
NK3532T	2	33.3	8	32	130	100	30	8.9	35°
NK3532TL	2	33.3	8	32	170	140	30	8.9	35°
NK4031T-20	2	31.7	8	20	130	100	30	9.9	40°
NK4031T-25	2	31.7	8	25	130	100	30	9.9	40°
NK4031T	2	31.7	8	32	130	100	30	9.9	40°
NK4031TL	2	31.7	8	32	170	140	30	9.9	40°
NK4530T-20	2	29.9	8	20	130	100	30	10.9	45°
NK4530T-25	2	29.9	8	25	130	100	30	10.9	45°
NK4530T	2	29.9	8	32	130	100	30	10.9	45°
NK4530TL	2	29.9	8	32	170	140	30	10.9	45°
<b>NEW</b> NK3-4536T	3	36.9	15	32	130	100	30	10.9	45°
<b>NEW</b> NK4-4543T	4	43.9	22	32	130	100	30	10.9	45°
<b>NEW</b> NK5-4559T	5	59.9	38	32	130	100	30	10.9	45°
NK5031T-20	2	31.9	12	20	130	100	30	11.8	50°
NK5031T-25	2	31.9	12	25	130	100	30	11.8	50°
NK5031T	2	31.9	12	32	130	100	30	11.8	50°
NK5031TL	2	31.9	12	32	170	140	30	11.8	50°
NK5532T-20	2	32.7	15	20	130	100	30	12.7	55°
NK5532T-25	2	32.7	15	25	130	100	30	12.7	55°
NK5532T	2	32.7	15	32	130	100	30	12.7	55°
NK5532TL	2	32.7	15	32	170	140	30	12.7	55°
NK6030T-20	2	30.5	15	20	130	100	30	13.4	60°
NK6030T-25	2	30.5	15	25	130	100	30	13.4	60°
NK6030T	2	30.5	15	32	130	100	30	13.4	60°
NK6030TL	2	30.5	15	32	170	140	30	13.4	60°
NK6533T-20	2	33.1	20	20	130	100	30	14.0	65°
NK6533T-25	2	33.1	20	25	130	100	30	14.0	65°
NK6533T	2	33.1	20	32	130	100	30	14.0	65°
NK6533TL	2	33.1	20	32	170	140	30	14.0	65°
NK7032T-20	2	32.6	22	20	130	100	30	14.5	70°
NK7032T-25	2	32.6	22	25	130	100	30	14.5	70°
NK7032T	2	32.6	22	32	130	100	30	14.5	70°
NK7032TL	2	32.6	22	32	170	140	30	14.5	70°
NK7533T-20	2	33.0	25	20	130	100	30	15.0	75°
NK7533T-25	2	33.0	25	25	130	100	30	15.0	75°
NK7533T	2	33.0	25	32	130	100	30	15.0	75°
NK7533TL	2	33.0	25	32	170	140	30	15.0	75°



Insert is not Included. Please order separately.  
 We have the lock pin wrench in our standard equipment.

Applications use	Capacity		
	NK3-4536T	NK4-4543T	NK5-4559T
Blades	3	4	5
$\alpha^\circ$	45°	45°	45°
Bore chamfering	$\phi 15.5\sim 36\text{mm}$	$\phi 22.5\sim 43\text{mm}$	$\phi 38.5\sim 59\text{mm}$

Line-up of 3 blades, 4-blade and 5-blades at 45°

**T32MOR**

The insert breaker is thin and is suitable for hard material process if compared with TT32GUR

**TNEA160304**

Since the thermal resistance is large when processing the hardening heat treatment materials, chamfering amount will have to be up to C3

**TT32GUR**

The Insert's breaker ensures no secondary burrs and no chattering

**Processing Example**

**[C5 chamfering]**

- Body : NK4530T
- Insert : TT32GUR AC15N

- Material.....SUS304
- Rotation Speed...2,000r.p.m
- Table feed.....200/min
- Cuting Depth....C5
- Cutting Oil.....None



**Result**

No secondary burrs and No chattering after processing

**Cutting Conditions**

T32MOR						
Material	Material Model	NK2001	NK1010	NK2020	NK3030	AC16N
		Feed PerBlade (fz)	Cutting speed (m / min)			
General Steel	0.08~0.2	200~250		150~200	150~200	100~200
Alloy Steel	0.08~0.2	200~250		150~200	150~200	100~200
Stainless Steel	0.08~0.2			100~150	100~150	100~200
Aluminum,Resin,Brass						
Castings	0.08~0.2	200~250 *FCD	100~150			

TT32GURF		
Material	Material Model	TC16N
		Feed per blade (fz)
heat resistant alloy (Inconel)	0.02~0.05	150~200
titanium alloy	0.02~0.05	150~200

TNEA160304		
Material	Material Model	TC16N
		Feed per blade (fz)
Hardened alloy steel SKD/HSS (HRC50~65)	0.08~0.2	150~200

TT32GUR										
Material	Material Model	NK2001	NK1010	NK2020	NK3030	NK5050	NK8080	AC15N	HSS	HSS TIN
		Feed PerBlade (fz)	Cutting speed (m / min)							
General Steel	0.08~0.2	200~250		150~200	150~200			150~200	13~23	15~25
Alloy Steel	0.08~0.2	200~250		150~200	150~200			150~200	10~20	13~22
Stainless Steel	0.08~0.2			120~180	150~200	120~180	150~200 *SUS316	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								

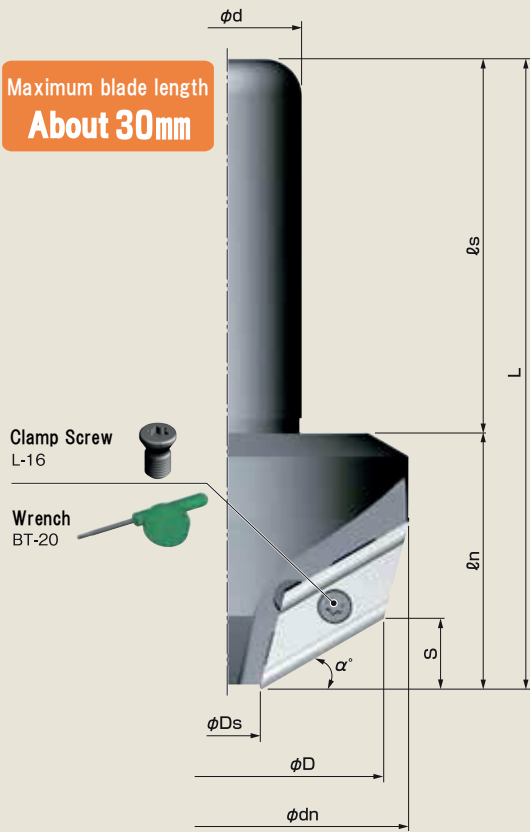
- According to the shape of work, large or small chamfering, amount and position of blade, the cutting condition will have to be adjusted.
- In case of process with large amount chamfer, please take reducing cutting condition
- You have been to the workpiece by recommended inset.
- In case of chamfering process of stainless steel, please take the down cutting

**Insert**

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
<p>(T32MOR)</p>	T32MOR NK2001	Cermet	Honing edge	None	6	12
	T32MOR NK1010	Carbide K10	Sharp edge	None	6	12
	T32MOR NK2020	Carbide M20	Honing edge	None	6	12
	T32MOR NK3030	Carbide M20	Honing edge	TiN	6	12
	T32MOR AC16N	Fine particles Carbide	Honing edge	AlCrN	6	12
<p>(TT32GUR) (TT32GURF)</p>	TT32GUR NK2001	Cermet	Honing edge	None	2	12
	TT32GUR NK1010	Carbide K10	Sharp edge	None	2	12
	TT32GUR NK2020	Carbide M20	Honing edge	None	2	12
	TT32GUR NK3030	Carbide M20	Honing edge	TiN	2	12
	TT32GUR NK5050	Carbide K10	Sharp edge	TiN	2	12
	TT32GUR NK8080	Carbide K10	Sharp edge	TiAl2N	2	12
	TT32GUR AC15N	Fine particles Carbide	Honing edge	AlCrN	2	12
	TT32GURF TC16N	Fine particles Carbide	Sharp edge	TiSiN	2	12
	TT32GUR HSS	HSS	Sharp edge	None	2	12
TT32GUR HSS TIN	HSS	Sharp edge	TiN	2	12	
<p>(TNEA160304)</p>	TNEA160304 TC16N	Fine particles Carbide	Honing edge	TiSiN	6	12

- 30mm blade length and originally designed breaker ensured maximum 30mm Chamfering process without chattering
- Line-up 5°~85° Angle process are ensured

Maximum blade length  
About 30mm



### Corner Chamfering



### Body

Model No.	Blades	Dimensions (mm)								$\alpha^\circ$
		$\phi D$	$\phi D_s$	$\phi d$	$\phi d_n$	L	$\ell_s$	$\ell_n$	S	
NK4554X-1	1	54.9	12.0	32		135	80	55	21.4	45
NK0574X	3	74.8	15.0	32	102.8	135	80	55	2.6	5
NK1074X	3	74.5	15.0	32	99.5	135	80	55	5.2	10
NK1571X	3	73.3	15.0	32	95.2	135	80	55	7.8	15
NK2070X	3	71.8	15.0	32	90.3	135	80	55	10.3	20
NK2568X	3	69.8	15.0	32	84.9	135	80	55	12.8	25
NK3080X	3	67.4	15.0	32	79.0	135	80	55	15.1	30
NK3563X	3	64.6	15.0	32	72.8	135	80	55	17.4	35
NK4060X	3	61.4	15.0	32	66.3	135	80	55	19.5	40
NK4557X	3	57.9	15.0	32		135	80	55	21.4	45
NK5056X	3	57.0	18.0	32		135	80	55	23.2	50
NK5556X	3	56.8	22.0	32		135	80	55	24.8	55
NK6054X	3	54.3	24.0	32		135	80	55	26.3	60
NK6553X	3	53.6	28.0	32		145	80	65	27.5	65
NK7052X	3	52.8	32.0	32		145	80	65	28.5	70
NK7550X	3	50.7	35.0	32		145	80	65	29.3	75
NK8048X	3	48.5	38.0	32		145	80	65	29.9	80
NK8547X	3	47.3	42.0	32		145	80	65	30.3	85

※ Inset is not equipped as standard accessory  
 ※ Clamp screw and wrench are supplied as standard accessory

### Processing Example

#### [C20 Chamfering]

- Body : NK4557X
- Insert : X63GUR AC15N
- Material : SUS304
- Rotation Speed : 800r.p.m
- Table feed : 150mm/min
- Cutting Depth : C20
- Cutting Oil : None



Result

Good!  
By one pass process, C20 Chamfer has been successfully made without chattering

### Cutting Conditions

X63GUR				
Material	material Model	NK1010	NK2020	AC15N
General Steel	0.05~0.15		1,000~2,000	1,000~2,000
Alloy Steel	0.05~0.15		1,000~2,000	1,000~2,000
Stainless Steel	0.05~0.15		700~1,500	700~1,500
Aluminum, Resin, Brass	0.08~0.2	3,000~5,000		
Cast Steel	0.05~0.15	1,000~2,000		

- 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

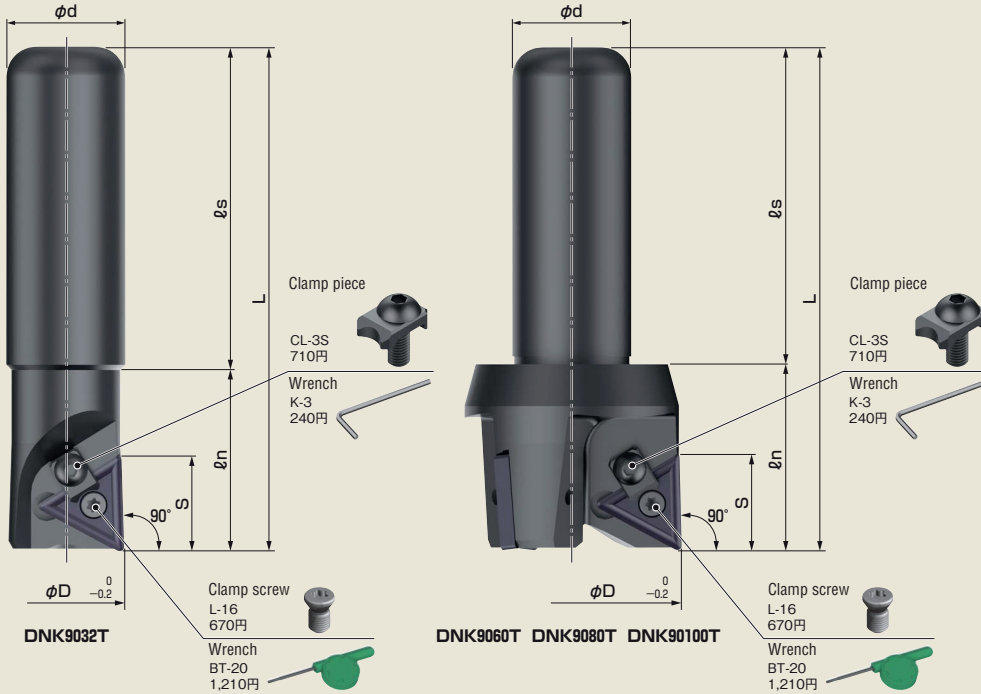
Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
	X63GUR NK1010	Carbide K10	Sharp edge	None	2	3
	X63GUR NK2020	Carbide M20	Honing edge	None	2	3
	X63GUR AC15N	Fine particles Carbide	Honing edge	AlCrN	2	3



## Right angle processing

- Z-20mm Achieves shoulder processing
- $\phi 32 \cdot 60 \cdot 80 \cdot 100$  line-up

$\phi 32\text{mm} \sim \phi 100\text{mm}$



Model. No.	Blades	Dimensions						(g)
		$\phi D$	$\phi d$	L	$l_s$	$l_n$	S	
<b>NEW</b> DNK9032T	1	32	32	135	85	50	24	730
<b>NEW</b> DNK9060T	3	60	32	135	85	50	24	1,100
<b>NEW</b> DNK9080T	3	80	32	135	85	50	24	1,600
<b>NEW</b> DNK90100T	3	100	32	135	85	50	24	2,300

※ Inset is not included. Please order separately.  
 ※ lock pin wrench clamp piece we have standard equipment.

## Cutting conditioning

Material	General steel etc.	Alloy steel	Hardened steel HRC~45	Hardened steel HRC45~65	Stainless steel	Castings	Resin.brass	Aluminum	Titanium alloy
Feed per blade [fz]	0.08~0.2	0.08~0.2	—	—	0.08~0.2	0.08~0.3	0.08~0.3	0.08~0.3	—
Cutting speed [m/min]	120~200	120~200	—	—	120~150	120~200	150~200	150~200	—
Rotation speed [r.p.m.]	800	800	—	—	600	800	1,500	1,500	—
Coolant	None	None	—	—	None	None	None	None	—
Recommended insert	TNMX270412 AC15N	TNMX270412 AC15N	—	—	TNMX270412 AC15N	TNEQ270412 ZA10N	TNEX270412 ZA10T	TNEX270412 ZA10T	—

## Insert

Fig.	Model.No.	Material	Usable corner	Quantity per box
	TNEX270412	ZA10T	2	3
	TNEQ270412	ZA10N	6	3
	TNMX270412	AC15N	6	3

## For drilling machine

For Customers Purchased

Clamp Screw M-1 Wrench MA-1



To customers who only purchase tools and parts

Lock pin L-6 Wrench K-3

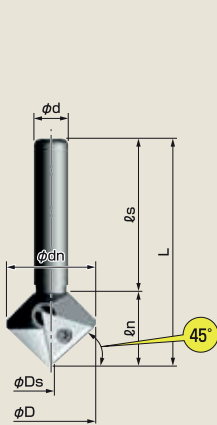


※ 1 piece TM32GUR HSS Insert is supplied as standard accessory  
 ※ Clamp Screw, lock pin and wrench are supplied as standard accessory

Please check it

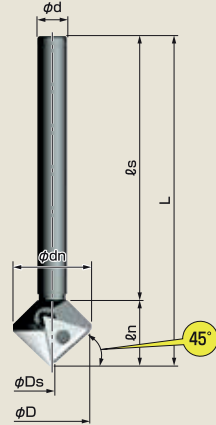
4 BM4538T, 5 BM4552T, 6 BM4566T  
 There are new type and old type.

● Fantastic machining with HSS insert and breaker originally designed by us  
 Line-up 30°, 45° and 60° fantastic angle processing are ensured



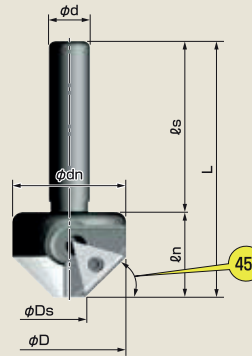
1 **BM4524T**

TM32GUR :  $\phi 5\text{mm} \sim \phi 24\text{mm}$   
 TM32GSR :  $\phi 5\text{mm} \sim \phi 21\text{mm}$



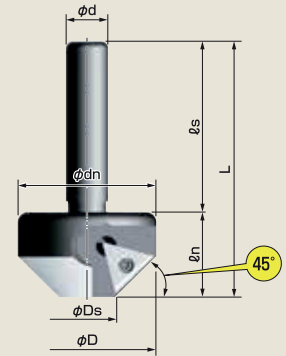
2 **BM4524TL**

TM32GUR :  $\phi 5\text{mm} \sim \phi 24\text{mm}$   
 TM32GSR :  $\phi 5\text{mm} \sim \phi 21\text{mm}$



3 **BM4531T**

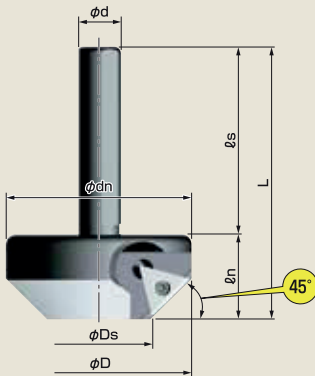
TM32GUR :  $\phi 12\text{mm} \sim \phi 31\text{mm}$   
 TM32GSR :  $\phi 12\text{mm} \sim \phi 28\text{mm}$



4 **BM4538T**

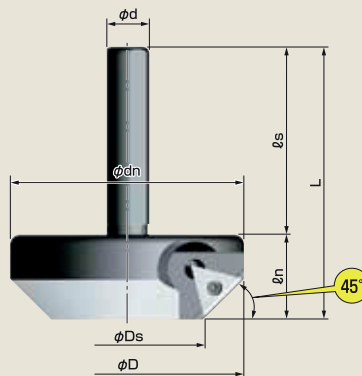
TM32GUR :  $\phi 19\text{mm} \sim \phi 38\text{mm}$   
 TM32GSR :  $\phi 19\text{mm} \sim \phi 36\text{mm}$

※Please purchase a commercially available product separately.



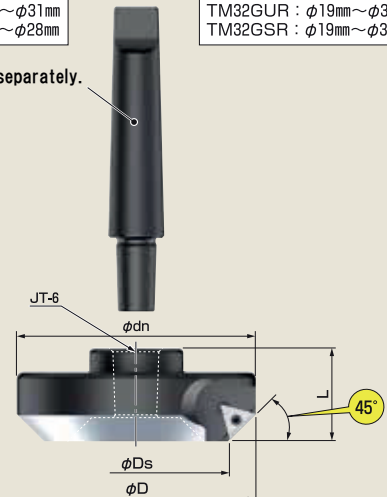
5 **BM4552T**

TM32GUR :  $\phi 33\text{mm} \sim \phi 52\text{mm}$   
 TM32GSR :  $\phi 33\text{mm} \sim \phi 50\text{mm}$



6 **BM4566T**

TM32GUR :  $\phi 47\text{mm} \sim \phi 66\text{mm}$   
 TM32GSR :  $\phi 47\text{mm} \sim \phi 64\text{mm}$



7 **BM4580T-JT6**

TM32GUR :  $\phi 61\text{mm} \sim \phi 80\text{mm}$   
 TM32GSR :  $\phi 61\text{mm} \sim \phi 77\text{mm}$

**BM4594T-JT6**

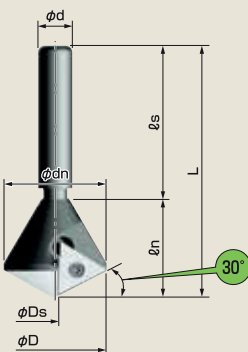
TM32GUR :  $\phi 75\text{mm} \sim \phi 94\text{mm}$   
 TM32GSR :  $\phi 75\text{mm} \sim \phi 91\text{mm}$

**BM45100T-JT6**

TM32GUR :  $\phi 81\text{mm} \sim \phi 100\text{mm}$   
 TM32GSR :  $\phi 81\text{mm} \sim \phi 97\text{mm}$

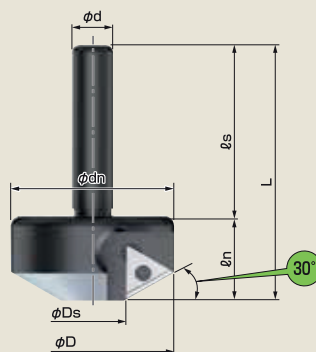
**BM45108T-JT6**

TM32GUR :  $\phi 89\text{mm} \sim \phi 108\text{mm}$   
 TM32GSR :  $\phi 89\text{mm} \sim \phi 105\text{mm}$



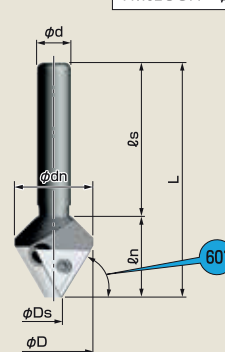
8 **BM3029T**

TM32GUR :  $\phi 6\text{mm} \sim \phi 29\text{mm}$   
 TM32GSR :  $\phi 6\text{mm} \sim \phi 26\text{mm}$



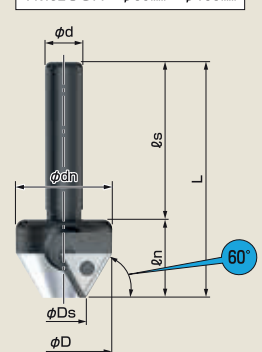
9 **BM3047T**

TM32GUR :  $\phi 21\text{mm} \sim \phi 46\text{mm}$   
 TM32GSR :  $\phi 21\text{mm} \sim \phi 43\text{mm}$



10 **BM6021T**

TM32GUR :  $\phi 7\text{mm} \sim \phi 21\text{mm}$   
 TM32GSR :  $\phi 7\text{mm} \sim \phi 19\text{mm}$



11 **BM6030T**

TM32GUR :  $\phi 15\text{mm} \sim \phi 29\text{mm}$   
 TM32GSR :  $\phi 15\text{mm} \sim \phi 27\text{mm}$

## Body

Model. No.	Figure	Blades	Dimensions (mm)							
			φD	φDs	φd	φdn	L	ℓs	ℓn	α°
BM4524T	①	1	25.20	4.49	10	26	67	45	22	45°
BM4524TL	②	1	25.20	4.49	10	26	110	88	22	45°
BM4531T	③	1	33.06	11.57	12	33	75	50	25	45°
BM4538T	④	1	39.83	18.17	12	40	75	50	25	45°
BM4552T	⑤	1	53.91	32.17	13	54	80	55	25	45°
BM4566T	⑥	1	67.94	46.17	13	68	80	55	25	45°
BM4580T-JT6	⑦	1	81.96	60.17		82	40			45°
NEW BM4594T-JT6	⑦	1	95.96	74.17		96	40		45°	
BM45100T-JT6	⑦	1	101.96	80.16		101	40		45°	
NEW BM45108T-JT6	⑦	1	109.96	88.17		110	40		45°	
BM3029T	⑧	1	30.2	5.52	10	30	74	45	29	30°
BM3047T	⑨	1	47.39	21	12	47.5	75	50	25	30°
BM6021T	⑩	1	21.77	6.60	10	23	69	45	24	60°
BM6030T	⑪	1	30.38	15	12	30.4	75	50	25	60°

※ 1 piece TM32GUR HSS Insert is supplied as standard accessory  
 ※ Clamp Screw, lock pin and wrench are supplied as standard accessory

## Cutting Conditions

Model. No.	TM32GUR HSS	TM32GUR HSS TiAlN	TM32GSR HSS	TM32GSR HSS TiAlN	TM32GSR AC16N
	Rotation Speed (r.p.m.)				
BM4524T	160~320	200~400	160~320	200~400	200~400
BM4524TL	160~320	200~400	160~320	200~400	200~400
BM4531T	130~280	150~350	130~280	150~350	150~350
BM4538T	130~280	150~350	130~280	150~350	150~350
BM4552T	80~120	100~150	80~120	100~150	100~150
BM4566T	40~80	50~100	40~80	50~100	50~100
BM4580T-JT6	20~50	20~50	20~50	20~50	20~50
BM4594T-JT6	20~50	20~50	20~50	20~50	20~50
BM45100T-JT6	20~50	20~50	20~50	20~50	20~50
BM45108T-JT6	20~50	20~50	20~50	20~50	20~50
BM3029T	160~320	200~400	160~320	200~400	200~400
BM3047T	130~280	150~350	130~280	150~350	150~350
BM6021T	160~320	200~400	160~320	200~400	200~400
BM6030T	130~280	150~350	130~280	150~350	150~350

● Depending on the Machine's rigidity, above conditions may not be Suitable.  
 In case of soft material like Aluminum, Copper etc., reduce rotation speed accordingly  
 In case the chattering is occurred, rotation speed will have to be reduced and use cutting oil

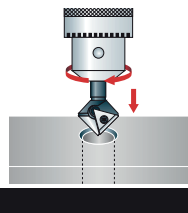
● Please use our original Insert for our tool  
 ● According to the shape, clamp condition and volume of chamfering amount the above cutting condition have to be adjusted. For large amount chamfering, the rate will have to be reduced

## Processing Example

[ φ 12mm Bore mouth chamfering ]

- Body : BM4524T
- Insert : TM32GUR HSS

- Material : SUS304
- Rotation Speed : 320r.p.m.
- Use machine : Bench type Drilling Machine



Result

No deburring even after more than 1000 time processing

## Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable Corner	Quantity per box
	TM32GUR HSS	HSS	Sharp edge	None	2	3
	TM32GUR HSS TiAlN	HSS	Sharp edge	TiAlN	2	3
	TM32GSR HSS	HSS	Sharp edge	None	6	3
	TM32GSR HSS TiAlN	HSS	Sharp edge	TiAlN	6	3
	NEW TM32GSR AC16N	Fine particles Carbide	Honing edge	AlCrN	6	3

- Optimal tool for small hole chamfering
- Using durable high speed steel body
- Achieve a super long life by using Ultrafine particle carbide and new coating tips!
- Positive type with 3-coner fine carbide tip can be used

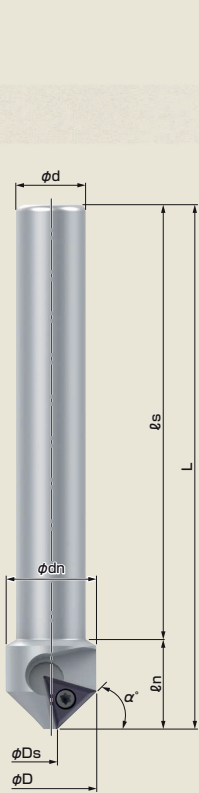
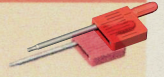
Maximum blade length  
about 7.6mm  
[TBC4533T : about 22mm]

Spare parts

Clamp Screw  
L-18

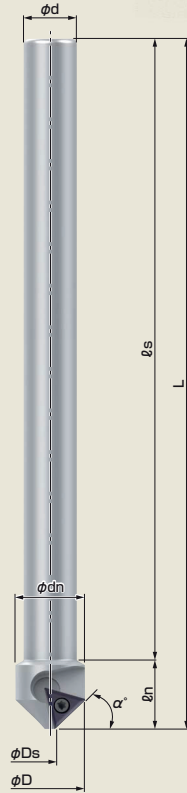


Wrench  
N-4



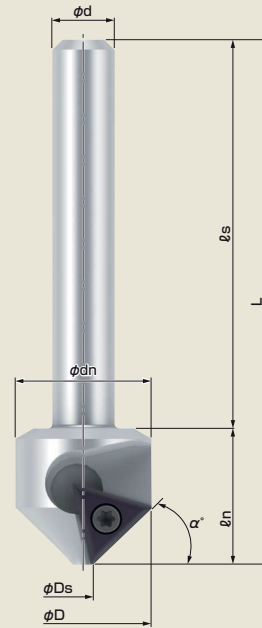
1 MBM4513T

$\phi 2.5\text{mm} \sim \phi 11.0\text{mm}$



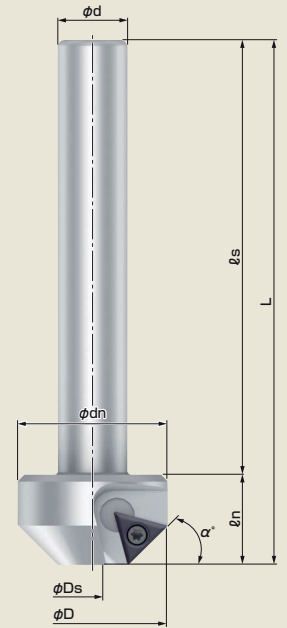
2 MBM4513TL

$\phi 2.5\text{mm} \sim \phi 11.0\text{mm}$



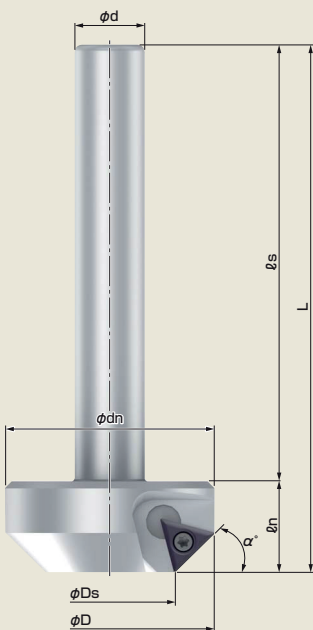
3 MBM4513T-6

$\phi 2.5\text{mm} \sim \phi 11.0\text{mm}$



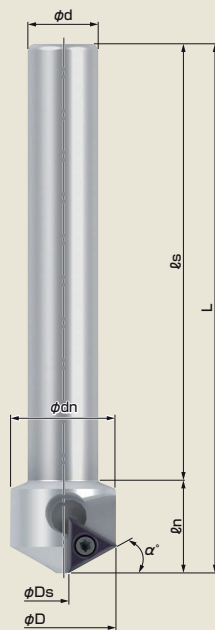
4 MBM4521T

$\phi 10.8\text{mm} \sim \phi 19.5\text{mm}$



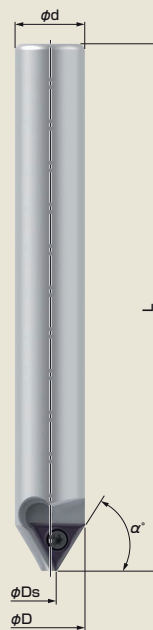
5 MBM4529T

$\phi 19.3\text{mm} \sim \phi 27.5\text{mm}$



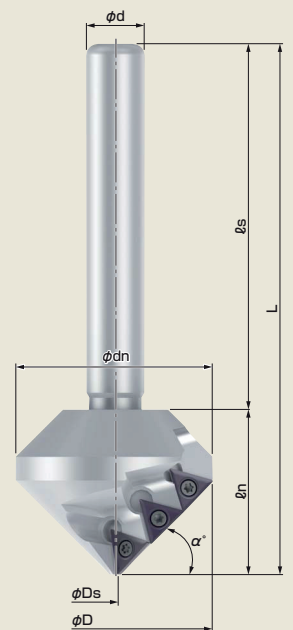
6 MBM3015T

$\phi 2.5\text{mm} \sim \phi 13.0\text{mm}$



7 MBM6010T

$\phi 3.0\text{mm} \sim \phi 7.0\text{mm}$

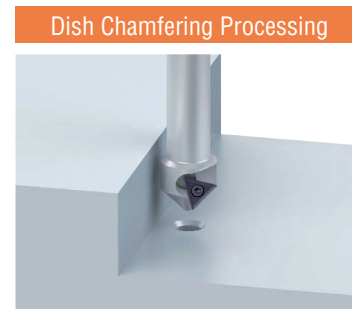
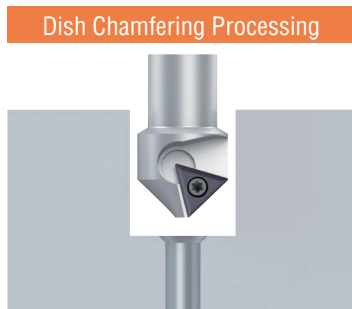


8 TBC4533T

$\phi 2.5\text{mm} \sim \phi 31.0\text{mm}$



Model No.	Capacity	
	Dish Chamfering Processing	
	[Min. blade diameter-max. blade diameter]	
	TCXT080102F / TCXT080102E	
MBM4513T	φ2.5mm~φ11.0mm	
MBM4513TL	φ2.5mm~φ11.0mm	
MBM4513T-6	φ2.5mm~φ11.0mm	
MBM4521T	φ10.8mm~φ19.5mm	
MBM4529T	φ19.3mm~φ27.5mm	
MBM3015T	φ2.5mm~φ13.0mm	
MBM6010T	φ3.0mm~φ7.0mm	
TBC4533T	φ2.5mm~φ31.0mm	



## Body

Model No.	Fig.		Dimensions (mm)							α°
			φD	φDs	φd	φdn	L	ℓs	ℓn	
MBM4513T	1	1	13.0	2.4	10	13.0	75	62	13	45°
MBM4513TL	2	1	13.0	2.4	10	13.0	143	130	13	45°
NEW MBM4513T-6	3	1	13.0	2.4	6	13.0	50	37	13	45°
NEW MBM4521T	4	1	21.3	10.5	10	21.5	75	62	13	45°
NEW MBM4529T	5	1	29.5	19.0	10	29.8	75	62	13	45°
NEW MBM3015T	6	1	15.3	2.4	10	15	75	62	13	30°
NEW MBM6010T	7	1	10.3	2.7	10		75			60°
NEW TBC4533T	8	3	33.7	2.4	10	33.8	90	62	28	45°

※ 1-pce of TCXT080102E AC16N insert is equipped as standard accessory

※ Clamp Screw and Wrench are standard accessory

※ TBC4533---Insert is not included. Please Order Separately.

## Cutting condition 1

Cutting condition	Material	General steel etc.	Alloy steel	Hardened steel HRC~45	Hardened steel HRC45~65	Stainless steel	Castings	Resin.brass	Aluminum	Titanium alloy
Cutting speed		5~40	5~40	—	—	5~40	5~40	10~50	10~50	—
Recommended insert		TCXT080102E AC16N	TCXT080102E AC16N	—	—	TCXT080102E AC16N	TCXT080102E AC16N	TCXT080102F ZC16N	TCXT080102F ZC16N	—

## Cutting condition 2

	TCXT080102F ZC16N	TCXT080102E AC16N
MBM4513T	250~1,200	100~800
MBM4513TL	250~1,200	100~800
MBM4513T-6	250~1,200	100~800
MBM4521T	150~750	75~600
MBM4529T	100~550	55~400
MBM3015T	250~1,200	100~800
MBM6010T	250~1,200	100~800
TBC4533T	100~1,200	55~800

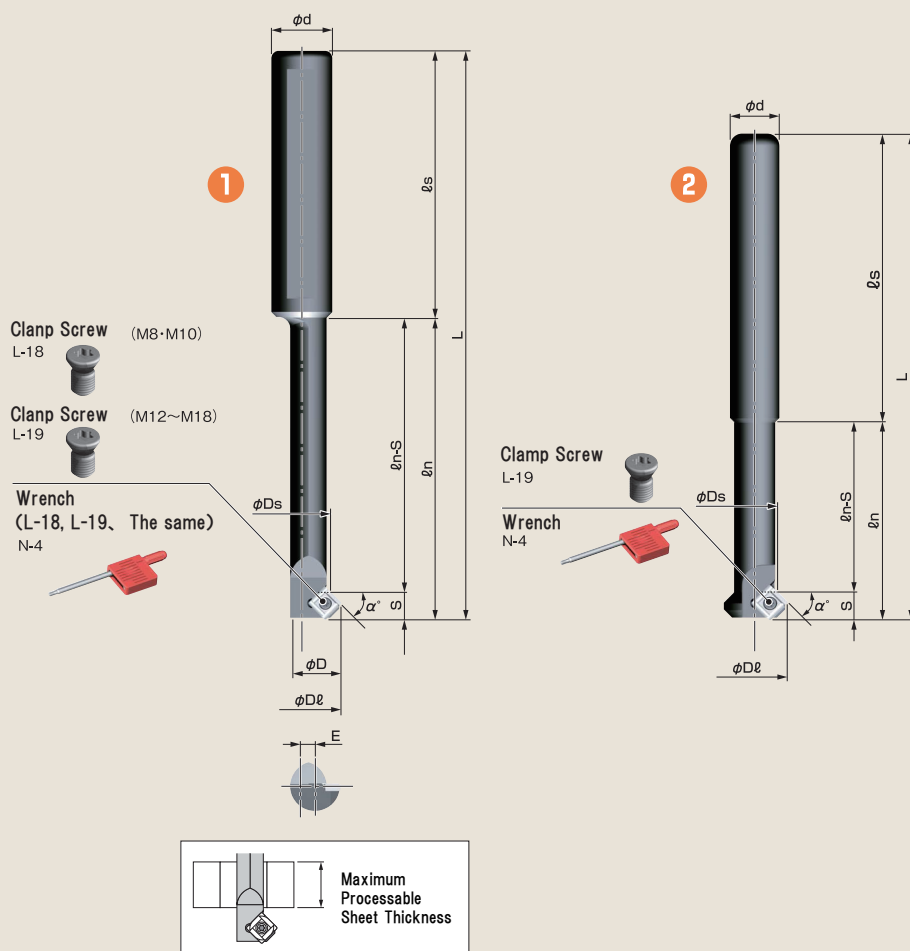
- Due to the rigidity of the machines, the above conditions may not be met [Hard to cut materials like A5052, coppers etc.]
- In case chattering surface, reduce revolutions and use cutting oil
- Please use a dedicated tip listed below
- Please adjust the cutting condition due to the workshape and clamp condition
- In case the processing diameter and chamfering amount is large, reduce the amount
- There is a cutting surface streak between the inserts

## Insert

Drawing	Model number	Material	Usable corner		Quantity per box
	TCXT080102F	ZC16N	3		3
	TCXT080102E	AC16N			

## Exclusive use for back chamfering

● This is a special tool for back spot hole chamfering and edge chamfering process



30°		
Model. No.	Hole diameter	Capacity
		Rear edge chamfering
UMH12-6.8S-M8-30	φ6.8	φ6.8mm~φ9.7mm
UMH12-8.5S-M10-30	φ8.5	φ8.5mm~φ11.7mm
UMH12-10S-M12-30	φ10.0	φ10.0mm~φ14.8mm
UMH12-12S-M14-30	φ12.0	φ12.0mm~φ16.8mm
UMH12-14S-M16-30	φ14.0	φ14.0mm~φ18.8mm
UMH16-16S-M18-30	φ16.0	φ16.0mm~φ20.8mm
UM12-16S-30		φ16.0mm Over ~

45°		
Model. No.	Hole diameter	Capacity
		Rear edge chamfering
UMH12-6.8S-M8	φ6.8	φ6.8mm~φ9.7mm
UMH12-8.5S-M10	φ8.5	φ8.5mm~φ11.7mm
UMH12-10S-M12	φ10.0	φ10.0mm~φ14.8mm
UMH12-12S-M14	φ12.0	φ12.0mm~φ16.8mm
UMH12-14S-M16	φ14.0	φ14.0mm~φ18.8mm
UMH16-16S-M18	φ16.0	φ16.0mm~φ20.8mm
UM12-16S		φ16.0mm Over ~

60°		
Model. No.	Hole diameter	Capacity
		Rear edge chamfering
UMH12-6.8S-M8-60	φ6.8	φ6.8mm~φ9.7mm
UMH12-8.5S-M10-60	φ8.5	φ8.5mm~φ11.4mm
UMH12-10S-M12-60	φ10.0	φ10.0mm~φ13.5mm
UMH12-12S-M14-60	φ12.0	φ12.0mm~φ15.5mm
UMH12-14S-M16-60	φ14.0	φ14.0mm~φ17.5mm
UMH16-16S-M18-60	φ16.0	φ16.0mm~φ19.5mm
UM12-14.5S-60		φ14.5mm Over ~

### Body

Model. No.	Figure	Blades	Dimensions (mm)											Inserts	α°
			φD	φDℓ	φDs	φd	L	ℓs	ℓn	ℓn-S	S	T	E		
UMH12-6.8S-M8-30	①	1	6.2	9.7	6.8	12	107	70	37	32.1	4.9	28	1.76	SP-SPET040102	30°
UMH12-8.5S-M10-30	①	1	7.5	11.7	8.5	12	117	70	47	42.0	5.0	38	2.11	SPET040102	
UMH12-10S-M12-30	①	1	9.0	14.8	10.0	12	129	70	59	52.2	6.8	47	2.92	SPET06T104	
UMH12-12S-M14-30	①	1	10.0	16.8	12.0	12	134	70	64	57.2	6.8	52	3.42	SPET06T104	
UMH12-14S-M16-30	①	1	12.0	18.8	14.0	12	139	70	69	62.2	6.8	57	3.41	SPET06T104	
UMH16-16S-M18-30	①	1	14.0	20.8	16.0	16	149	70	79	72.2	6.8	67	3.41	SPET06T104	
UM12-16S-30	②	1		16.0	11.0	12	118	70	48	41.1	6.9			SPET06T104	45°
UMH12-6.8S-M8	①	1	6.2	9.7	6.8	12	107	70	37	32.2	4.8	28	1.76	SP-SPET040102	
UMH12-8.5S-M10	①	1	7.5	11.7	8.5	12	117	70	47	42.0	5.0	38	2.11	SPET040102	
UMH12-10S-M12	①	1	9.0	14.8	10.0	12	129	70	59	52.1	6.9	47	2.92	SPET06T104	
UMH12-12S-M14	①	1	10.0	16.8	12.0	12	134	70	64	57.1	6.9	52	3.42	SPET06T104	
UMH12-14S-M16	①	1	12.0	18.8	14.0	12	139	70	69	62.1	6.9	57	3.41	SPET06T104	
UMH16-16S-M18	①	1	14.0	20.8	16.0	16	149	70	79	72.1	6.9	67	3.41	SPET06T104	60°
UM12-16S	②	1		16.0	11.0	12	118	70	48	41.0	7.0			SPET06T104	
UMH12-6.8S-M8-60	①	1	6.2	9.7	6.8	12	107	70	37	32.0	5.0	28	1.76	SP-SPET040102	
UMH12-8.5S-M10-60	①	1	7.5	11.4	8.5	12	117	70	47	42.0	5.0	38	1.96	SPET040102	
UMH12-10S-M12-60	①	1	9.0	13.5	10.0	12	129	70	59	52.7	6.3	47	2.27	SPET06T104	
UMH12-12S-M14-60	①	1	10.0	15.5	12.0	12	134	70	64	57.7	6.3	52	2.77	SPET06T104	
UMH12-14S-M16-60	①	1	12.0	17.5	14.0	12	139	70	69	62.7	6.3	57	2.76	SPET06T104	60°
UMH16-16S-M18-60	①	1	14.0	19.5	16.0	16	149	70	79	72.7	6.3	69	2.76	SPET06T104	
UM12-14.5S-60	②	1		14.5	11.0	12	118	70	48	41.7	6.3			SPET06T104	

※ Inset is not supplied as standard accessory. Please order separately.

※ Clamp screw and wrench are supplied as standard accessory.

Rear Spot surface chamfer process in bore process



Rear surface Edge chamfering process

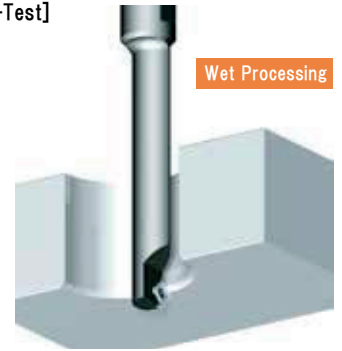


Processing Example

[Eccentric Rear Chamfering Cutter-Test]

- Body : UMH12-8 5S-M10
- Insert : SPET040102 AC16N

- Material .....SKD11
- Rotation Speed .....800r.p.m.
- Cutting Speed .....21m/min
- Table Feed .....40mm/min
- Blade Feed .....0.05mm/tooth
- Hole diameter .....8.5mm
- Cutting Depth .....1mm



Result

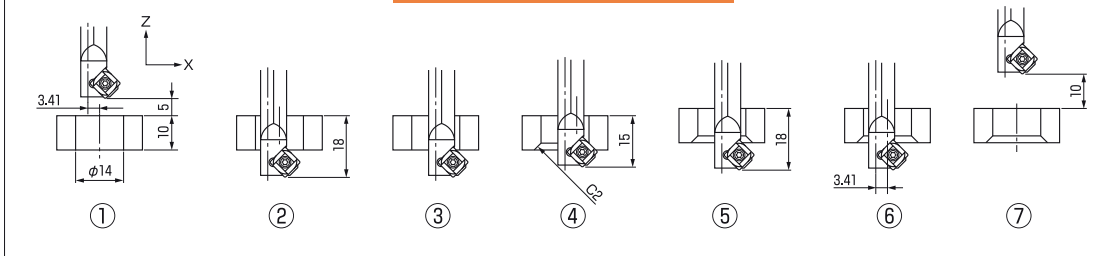
Without secondary burrs and chattering

Cutting Conditions

Material	Material Model	1 UMH□□-□□□-M□-30 UMH□□-□□□-M□ UMH□□-□□□-M□-60			2 UM12-16S UM12-16S-30 UM12-14.5S-60			
		NK1010	NK2020	AC16N	Material Model	NK1010	NK2020	AC16N
General Steel	Feed Per Blade (fz)	Cutting speed (m / min)			Feed Per Blade (fz)	Cutting Speed (m / min)		
Alloy Steel	0.03~0.05	25~30			0.05~0.1	50~70		
Stainless Steel	0.03~0.05	20~25			0.05~0.1	40~50		
Aluminum, Resin, Brass	0.03~0.05	30~35			0.05~0.1	80~100		
Cast Steel	0.03~0.05	30~35			0.05~0.1	80~100		

- According to the shape of work, clamp condition, large or small chamfering amount and position of blade, the cutting condition will have to be reduced
- Coolant is recommended
- Yellow marked condition is recommended for the material listed

How to use



Example program (UMH12-14S-M16)

- N10
- G90 G00 G54 X-3.41 Y0 M19
- G43 Z5.0 H3 T11.....①
- G1 Z-18.0 F2000.....②
- X0.....③
- M3 S600
- G1 Z-14.9 F30.....④
- Z-18.0 F200.....⑤
- M19
- X-3.41.....⑥
- G0 Z10.0.....⑦
- G80 Z10.0
- G30 Z10.0

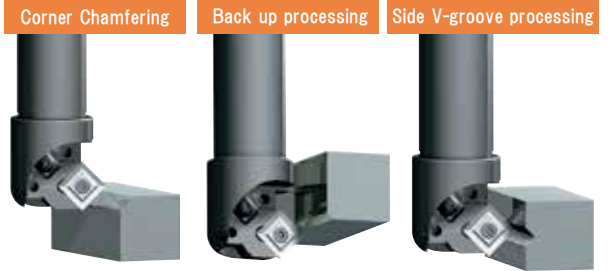
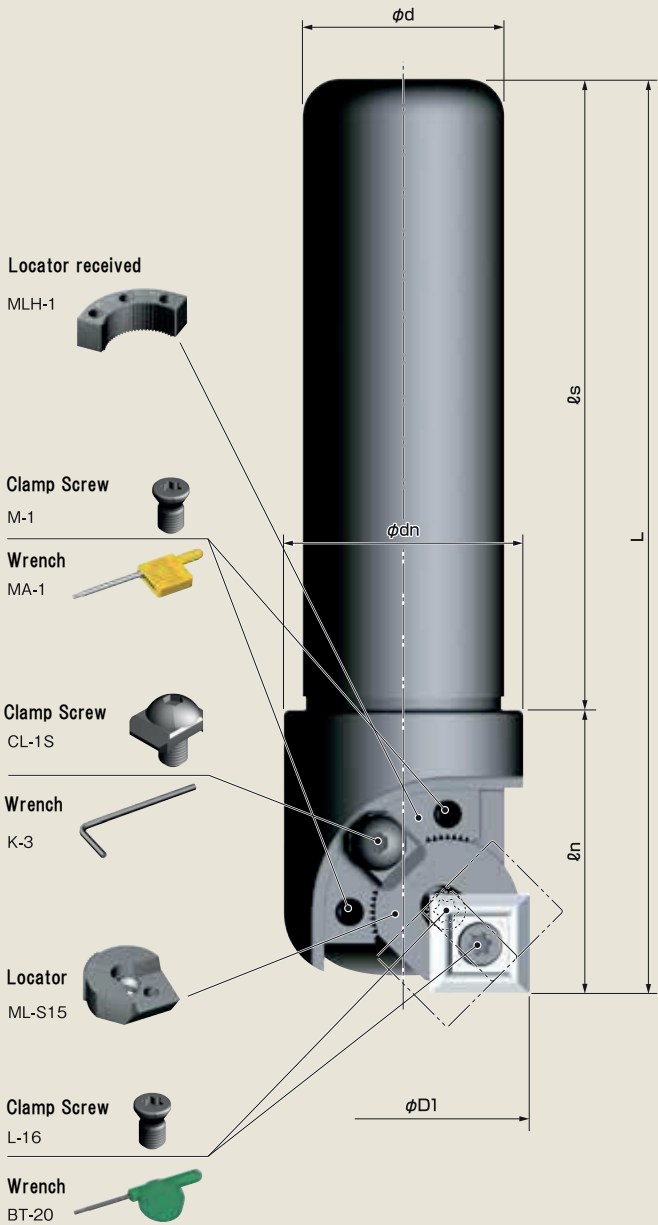
Max. processing thickness: T  
Chamfer amount: C  
Z = -(T+S-C)

Insert

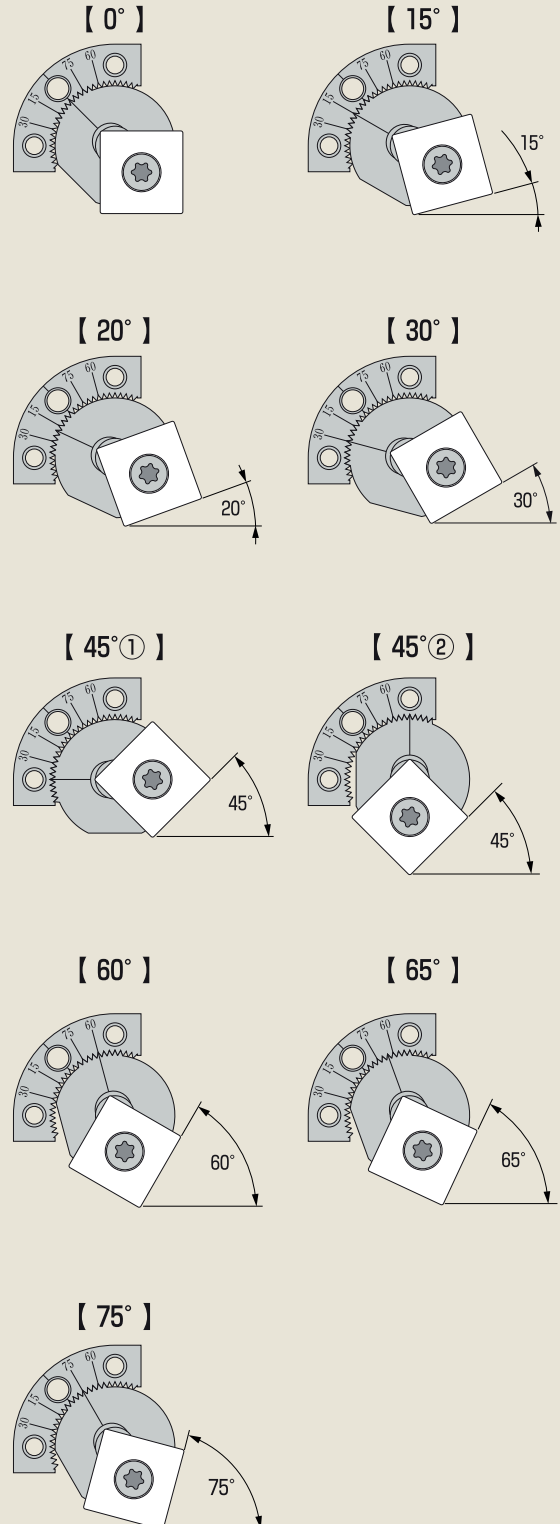
Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
<b>● M8</b> (SP-SPET040102) 	SP-SPET040102 NK1010	Carbide K10	Sharp edge	None	1	12
	SP-SPET040102 NK2020	Carbide M20	Honing edge	None	1	12
	<b>NEW</b> SP-SPET040102 AC16N	Fine particles Carbide	Honing edge	AICrN	1	12
<b>● M10</b> (SPET040102) 	SPET040102 NK1010	Carbide K10	Sharp edge	None	4	12
	SPET040102 NK2020	Carbide M20	Honing edge	None	4	12
	<b>NEW</b> SPET040102 AC16N	Fine particles Carbide	Honing edge	AICrN	4	12
<b>● M12~18/UM12-16S</b> (SPET06T104) 	SPET06T104 NK1010	Carbide K10	Sharp edge	None	4	12
	SPET06T104 NK2020	Carbide M20	Honing edge	None	4	12
	<b>NEW</b> SPET06T104 AC16N	Fine particles Carbide	Honing edge	AICrN	4	12

## Variable angle Processing

By the serration mechanism and our original double clamp system, the holding parts are superior to prevent insert movement.  
0° - 90° Angle adjustment can be easily and securely made



### Display for division of angle



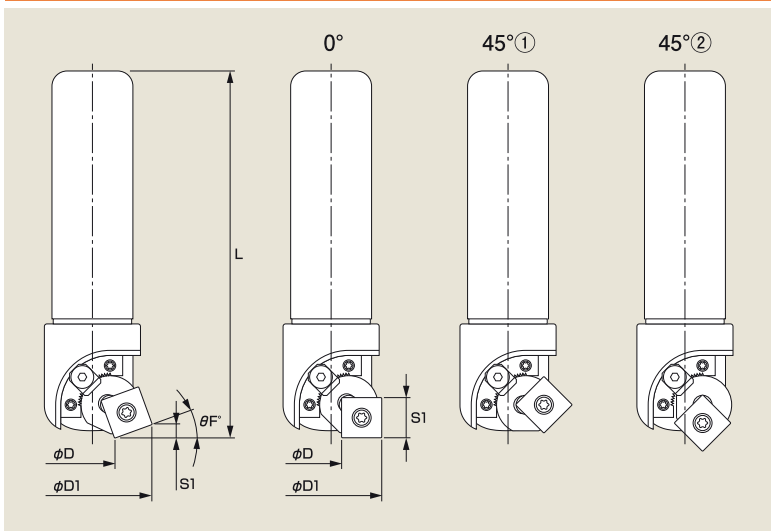
### Body

Model No.	blades	Dimensions (mm)					
		$\phi D1$	$\phi d$	$\phi dn$	L	$\ell s$	$\ell n$
MAM32-50S	1	※1	32	38	145	100	45
MAM32-50SL	1	※1	32	38	200	155	45

※ Insert is not equipped as standard accessory. Please purchase it separately  
 ※ Clamp screw, wrench and locator are supplied as standard accessories  
 ※ Please refer to angle dimension table (P-36)

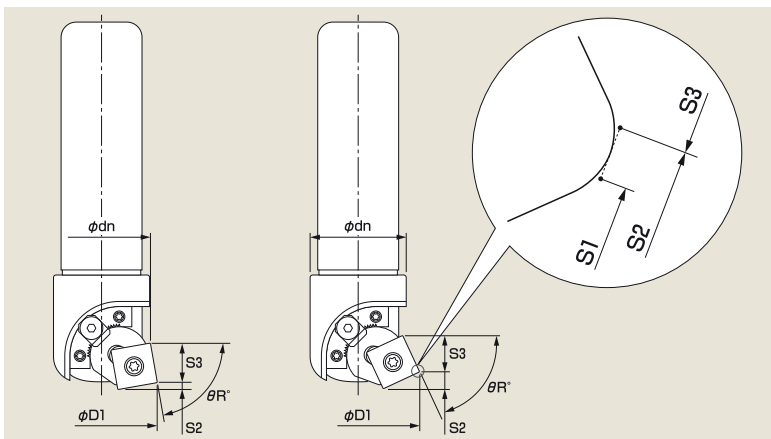


<θF°> Angle Dimension Table 1 (MAM32-50S)



θF°	φD	φD1	S1	L
0°	φ8.3	φ40	15.9	145
5°	φ11.3	φ42.1	1.3	145.2
10°	φ13.6	φ44	2.7	145.2
15°	φ15.9	φ45.7	4.0	145.2
20°	φ18.1	φ47.1	5.3	145.1
25°	φ20.4	φ48.3	6.5	144.8
30°	φ22.6	φ49.3	7.7	144.5
35°	φ24.7	φ49.9	8.8	144.1
40°	φ26.7	φ50.3	9.9	143.6
45°①	φ28.7	φ50.5	10.9	143
45°②	φ14.3	φ36	10.9	150.2
50°	φ17.4	φ37.2	11.8	150.2
55°	φ20.5	φ38.2	12.6	150
60°	φ23.6	φ39.1	13.4	149.6
65°	φ26.7	φ39.7	14	149.2
70°	φ29.6	φ40.1	14.5	148.6
75°	φ32.4	φ40.4	14.9	147.8
80°	φ35.1	φ40.5	15.2	147
85°	φ37.6	φ40.3	15.4	146.1

<θR°> Angle Dimension Table 2 (θR°=90°-θF°)



θR°	φD1	φdn	S2	S3
85°	φ42.1	φ39.4	1.7	15.4
80°	φ44	φ38.6	3.1	15.2
75°	φ45.7	φ38.0	4.4	14.3
70°	φ47.1	φ38.0	5.6	12.5
65°	φ48.3	φ38.0	6.9	11.1
60°	φ49.3	φ38.0	8	9.7
55°	φ49.9	φ38.0	9.2	8.5
50°	φ50.3	φ38.0	10.2	7.4
45°	φ50.5	φ38.0	11.2	6.2

**Cutting Conditions**

	SDET150404		SDMT150404	
	Material Model	ZA10N	ZA20N	AC15N
<b>Material</b>	Feed per blade (fz)	Cutting speed (m/min)		
General Steel	0.05~0.15		100~150	100~150
Alloy Steel	0.05~0.15		100~150	100~150
Stainless Steel	0.05~0.15		80~120	80~120
Aluminum, Resin, Brass	0.08~0.2	150~400		
Castings	0.05~0.15		100~150	

● In case of Stainless steel processing, please take down cut

**Processing Example**

**[Perimetry C5 Chamfering]**

- Body : MAM32-50S
- Body : SDMT150404 ZA20N
- Material.....S45C
- Rotation Speed...630.p.m.
- Table feed.....63mm/min
- Depth of Cut.....C5
- Cutting Oil.....None

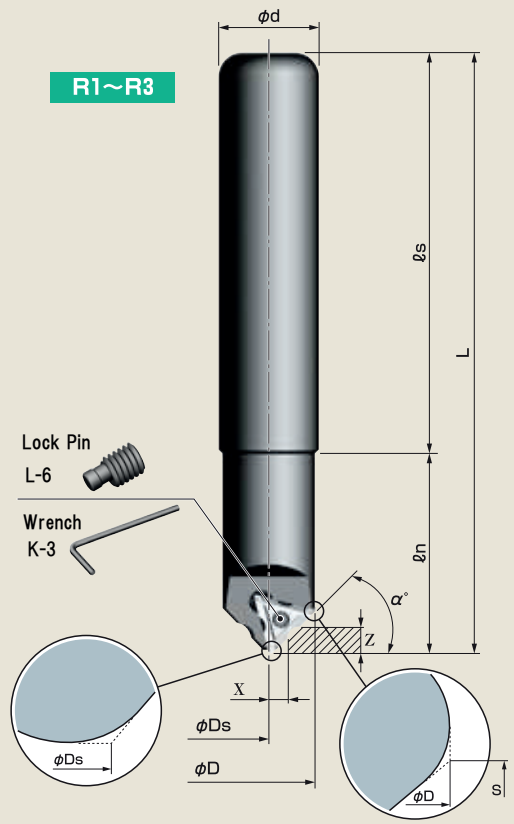
**Result**

Good!  
No secondary burrs and, No chattering after processing

**Insert**

Figure	Model.No.	Material	Blade Shape	Coating	Usable Corner	Quantity per box
<p>(SDET150404)</p>	SDET150404 ZA10N	Carbide K10	Sharp edge	None	2	3
<p>(SDMT150404)</p>	SDMT150404 ZA20N	Carbide M20	Honing edge	None	4	3
	SDMT150404 AC15N	Fine particles Carbide	Honing edge	AlCrN	4	3

● Possible R-Chamfering And C-Chamfering process ensured by changing insert



### Setting numerical values

Processing R	X-axis position (mm)	Z-axis position (mm)
R1	6.40	5.81
R2	5.90	6.30
R3	5.40	6.78

● numeric value might get some errors, please acknowledge.

### R Chamfering

### C-Chamfering



### Processing Example

[Periphery R3 Chamfering process]

- Body : CR25-05T
- Insert : T32GSR-3R NK2020
- Table feed ..... Bakelite
- Material ..... 4,000r.p.m.
- Rotational speed ..... 800mm/min



Dry cutting

### Result

Good discharge of chips, surface accuracy also good Results came out.

### Insert

T32GSR		
Material	Feed PerBlade (fz)	Cutting speed (m / min)
General Steel	0.08~0.2	150~200
Alloy Steel	0.08~0.2	150~200
Stainless Steel	0.08~0.2	120~180
Aluminum, Resin, Brass	0.08~0.3	200~800
Castings	0.08~0.2	150~200

### Body

Model. No.	blades	Dimensions (mm)							α°
		φD	φDs	φd	L	ℓs	ℓn	S	
CR25-05T	1	25	3.8	25	150	100	50	10.6	45°

※ Insert is not Included. Please Order Separately.  
 ※ Lock pin Wrench we have Standard Equipment.



When mounting insert, please do not take reverse tightening.  
 Due to the eccentricity looking mechanism, poor accuracy or breakage of insert may be occurred  
 When replacing insert, please confirm whether you have been taking reserve tightening or not.

### Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
<p>Figure: T32GSR (90° chamfer)</p>	T32GSR-1R NK2020	Carbide M20	/	None	3	3
	T32GSR-2R NK2020	Carbide M20		None	3	3
	T32GSR-3R NK2020	Carbide M20		None	3	3
<p>Figure: T32MOR (60° chamfer)</p>	T32MOR NK2001	Cermet	Honing edge	None	6	12
	T32MOR NK1010	Carbide K10	Sharp edge	None	6	12
	T32MOR NK2020	Carbide M20	Honing edge	None	6	12
	T32MOR NK3030	Carbide M20	Honing edge	TiN	6	12
	T32MOR AC16N	Fine particles Carbide	Honing edge	AlCrN	6	12
<p>Figure: TT32GUR/TT32GURF (60° chamfer)</p>	TT32GUR NK2001	Cermet	Honing edge	None	2	12
	TT32GUR NK1010	Carbide K10	Sharp edge	None	2	12
	TT32GUR NK2020	Carbide M20	Honing edge	None	2	12
	TT32GUR NK3030	Carbide M20	Honing edge	TiN	2	12
	TT32GUR NK5050	Carbide K10	Sharp edge	TiN	2	12
	TT32GUR NK8080	Carbide K10	Sharp edge	TiAlN	2	12
	TT32GUR AC15N	Fine particles Carbide	Honing edge	AlCrN	2	12
	TT32GURF TC16N	Fine particles Carbide	Sharp edge	TiSiN	2	12
	TT32GUR HSS	HSS	Sharp edge	None	2	12
TT32GUR HSS TiN	HSS	Sharp edge	TiN	2	12	
<p>Figure: TNEA160304 (60° chamfer)</p>	TNEA160304 TC16N	Fine particles Carbide	Honing edge	TiSiN	6	12



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**THE BEST:**

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**CHAMFERING TOOLS  
DEBURRING TOOLS  
COUNTERSINK TOOLS  
RADIUS TOOLS**

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# R-Special Jr. / R-Special

## R-Special Jr.

R0.5~R5

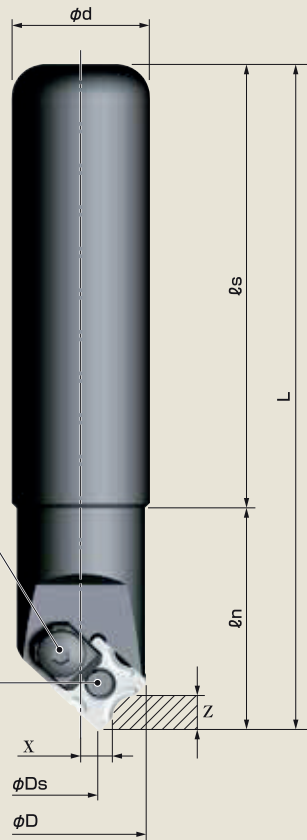
1 Blade

Clamp piece  
CL-1S

Wrench  
K-3

Lock Pin  
L-14

Wrench  
K-4



## Easy radius change

● Various Radius chamfering can be made by just exchanging Inserts

### Setting numerical values

Processing R	X-axis position (mm)	Z-axis position (mm)
R0.5	8.05	4.42
R0.75	7.93	4.55
R1	7.80	4.67
R1.5	7.55	4.92
R2	7.30	5.17
R2.5	7.06	5.42
R3	6.81	5.67
R3.5	6.56	5.91
R4	6.31	6.16
R4.5	6.06	6.41
R5	5.82	6.66

● numeric value might get some errors, please acknowledge.

R Chamfering



### Body

Model. No.	Blades	Dimensions (mm)					
		φD	φDs	φd	L	l <sub>s</sub>	l <sub>n</sub>
NK20-05R	1	25	8.4	20	120	80	40
NK25-05R	1	25	8.4	25	120	80	40

※ Inset is not supplied as standard accessory. Please order separately.  
※ lock pin and wrench are supplied as standard accessory.

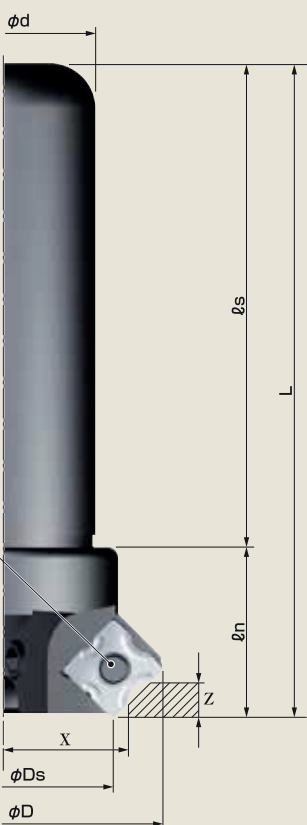
## R-Special

R0.5~R5

3 Blade

Lock Pin  
L-12

Wrench  
K-4



## Easy radius change

● Various Radius chamfering can be made by just exchanging Inserts

### Setting numerical values

Processing R	X-axis position (mm)	Z-axis position (mm)
R0.5	23.54	4.42
R0.75	23.42	4.54
R1	23.29	4.66
R1.5	23.04	4.91
R2	22.79	5.16
R2.5	22.54	5.41
R3	22.29	5.66
R3.5	22.04	5.91
R4	21.78	6.16
R4.5	21.53	6.41
R5	21.28	6.65

● numeric value might get some errors, please acknowledge.

R Chamfering



### Body

Model. No.	Blades	Dimensions (mm)					
		φD	φDs	φd	L	l <sub>s</sub>	l <sub>n</sub>
NK20-40R-3	3	56	39.3	20	115	85	30
NK25-40R-3	3	56	39.3	25	115	85	30
NK32-40R-3	3	56	39.3	32	115	85	30




When mounting insert, please do not take reverse tightening.  
Due to the eccentricity locking mechanism, poor accuracy or breakage of insert may be occurred  
When replacing insert, please confirm whether you have been taking reserve tightening or not.

### Processing Example (R-Special Jr.)

[R5 Chamfering process of  $\phi 20$  hole Result]

**Dry cutting**

- Body: NK25-05R
- Insert: N43GXR8-5R NK2020
- Material .....S45C
- Rotational speed ...2,500r.p.m.
- Table feed .....400mm/min



**Result**


Surface Accuracy is good when the processing was made without rough cutting

### Processing Example (R-Special)

[Periphery R4 Chamfering process]

**Dry cutting**

- Body: NK32-40R-3
- Insert: N43GXR8-4R AC16N
- Material .....SKD11
- Rotational speed ...1,200r.p.m.
- Table feed .....576mm/min



**Result**

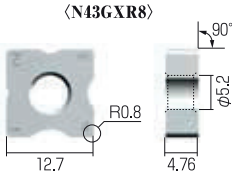
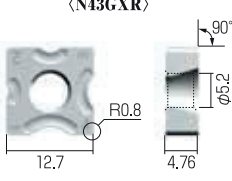
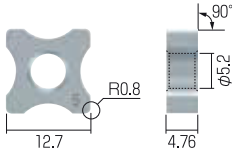
Surface Accuracy is good when the processing was made without rough cutting

## Cutting Conditions

		N43GXR			
Material	Material Model	NK2001	NK1010	NK2020	AC16N
		Cutting Speed (m / min)			
General Steel	0.1~0.2	100~250		100~200	
Alloy Steel	0.1~0.2	100~250		100~200	150~200
Stainless Steel	0.1~0.2			80~160	150~200
Aluminum,Resin,Brass	0.1~0.3		150~300	150~300	
Castings	0.1~0.3	80~150 ※FCD	80~150	80~150	

- 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	ModelNo.	Material	Blade Shape	Coating	Usable corner	Quantity per box	
 <p>〈N43GXR8〉</p>	N43GXR8 NK2001	Cermet	R1·2·3·4	None	8	3/12	
	N43GXR8-1R NK2001	Cermet	The Same R Each corner	None	8	3/12	
	N43GXR8-2R NK2001	Cermet	The Same R Each corner	None	8	3/12	
	N43GXR8-3R NK2001	Cermet	The Same R Each corner	None	8	3/12	
	N43GXR8-4R NK2001	Cermet	The Same R Each corner	None	8	3/12	
	<b>Semi standard</b>						
 <p>〈N43GXR〉</p>	<b>NEW</b> N43GXR8-5R NK2001	Cermet	The Same R Each corner	None	8	3/12	
	N43GXR NK1010	Carbide K10	R1·2·3·4	None	4	3/12	
	<b>NEW</b> N43GXR8 NK2020	Carbide M20	R1·2·3·4	None	8	3/12	
	<b>NEW</b> N43GXR8-1R NK2020	Carbide M20	The Same R Each corner	None	8	3/12	
	<b>NEW</b> N43GXR8-2R NK2020	Carbide M20	The Same R Each corner	None	8	3/12	
	<b>NEW</b> N43GXR8-3R NK2020	Carbide M20	The Same R Each corner	None	8	3/12	
	<b>NEW</b> N43GXR8-4R NK2020	Carbide M20	The Same R Each corner	None	8	3/12	
	<b>Semi standard</b>						
	<b>NEW</b> N43GXR8-0.5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12	
	<b>NEW</b> N43GXR8-0.75R NK2020	Carbide M20	The Same R Each corner	None	8	3/12	
	<b>NEW</b> N43GXR8-1.5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12	
	<b>NEW</b> N43GXR8-2.5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12	
 <p>〈N43GXR8 Semistandard Insert〉</p>	<b>NEW</b> N43GXR8-3.5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12	
	<b>NEW</b> N43GXR8-4.5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12	
	<b>NEW</b> N43GXR8-5R NK2020	Carbide M20	The Same R Each corner	None	8	3/12	
	<b>NEW</b> N43GXR8 AC16N	Fine particles Carbide	R1·2·3·4	AICrN	8	3/12	
	<b>NEW</b> N43GXR8-1R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12	
	<b>NEW</b> N43GXR8-2R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12	
	<b>NEW</b> N43GXR8-3R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12	
	<b>NEW</b> N43GXR8-4R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12	
	<b>Semi standard</b>						
	<b>NEW</b> N43GXR8-0.5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12	
	<b>NEW</b> N43GXR8-0.75R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12	
	<b>NEW</b> N43GXR8-1.5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12	
<b>NEW</b> N43GXR8-2.5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12		
<b>NEW</b> N43GXR8-3.5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12		
<b>NEW</b> N43GXR8-4.5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12		
<b>NEW</b> N43GXR8-5R AC16N	Fine particles Carbide	The Same R Each corner	AICrN	8	3/12		

※ R0.5~R3.5 insert can be used for R Bit  
 ※ Semi standard Insert have no breaker

# R-Nouveau Jr./R-Nouveau

## R-Nouveau Jr.

R5~R10

1 Blade

Clamp piece  
CL-1S

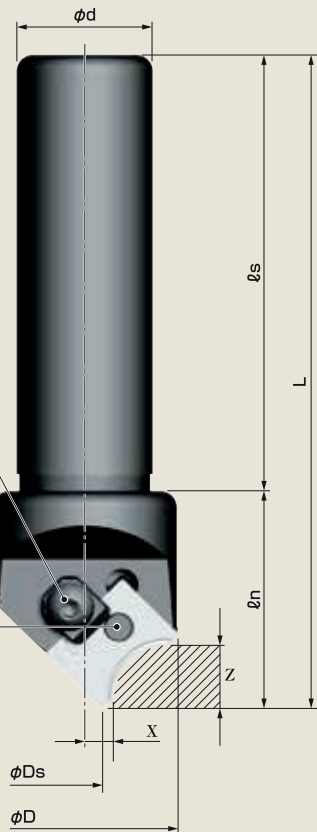
Wrench  
K-3



Lock Pin  
L-12



Wrench  
K-4



## Easy radius change

● Various Radius chamfering can be made by just exchanging Inserts

### Setting numerical values

Processing R	X-axis position (mm)	Z-axis position (mm)
R5	6.00	6.70
R6	5.41	7.21
R7	5.64	8.42
R8	6.00	9.65
R9	5.41	10.16
R10	6.00	11.62

● numeric value might get some errors, please acknowledge.

R Chamfering



### Body

Model. No.	Blades	Dimensions (mm)					
		φD	φDs	φd	L	l <sub>s</sub>	l <sub>n</sub>
NK20-10R	1	35.4	8.9	20	120	80	40
NK25-10R	1	35.4	8.9	25	120	80	40

※ Inset is not supplied as standard accessory. Please order separately.

※ look pin and wrench are supplied as standard accessory.

## R-Nouveau

R5~R10

3 Blade

Clamp piece  
CL-1S



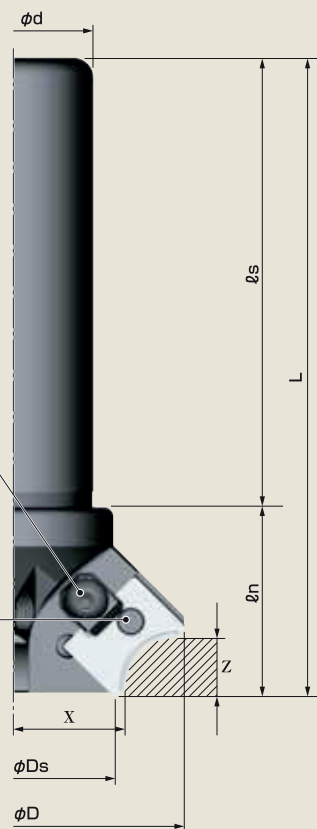
Wrench  
K-3



Lock Pin  
L-12



Wrench  
K-4



## Easy radius change

● Various Radius chamfering can be made by just exchanging Inserts

### Setting numerical values

Processing R	X-axis position (mm)	Z-axis position (mm)
R5	22.80	6.80
R6	22.25	7.32
R7	22.49	8.56
R8	22.80	9.80
R9	22.25	10.32
R10	22.80	11.80

● numeric value might get some errors, please acknowledge.

R Chamfering



### Body

Model. No.	Blades	Dimensions (mm)					
		φD	φDs	φd	L	l <sub>s</sub>	l <sub>n</sub>
NK25-70R	3	69.2	42.3	25	130	90	40
NK32-70R	3	69.2	42.3	32	130	90	40
NK32-70RL	3	69.2	42.3	32	200	150	50

※ Inset is not supplied as standard accessory. Please order separately.

※ look pin and wrench are supplied as standard accessory.



When mounting insert, please do not take reverse tightening.


Due to the eccentricity looking mechanism, poor accuracy or breakage of insert may be occurred

When replacing insert, please confirm whether you have been taking reserve tightening or not.

### Processing Example (R-Nouveau Jr.)

[Periphery R10 Chamfering process]

- Body : NK25-10R
- Insert : N54GCR-10R NK2020
- Material : Aluminum
- Rotational speed : 4,000r.p.m.
- Table feed : 800mm/min




**Dry cutting**

**Result**

Surface Accuracy is good when the processing was made without rough cutting

### Processing Example (R-Nouveau)

- Body : NK32-70R
- Insert : N54GCR-10R NK2020
- Material : S50C
- Rotational speed : 1,300r.p.m.
- Table feed : 700mm/min



**Dry cutting**

**Result**

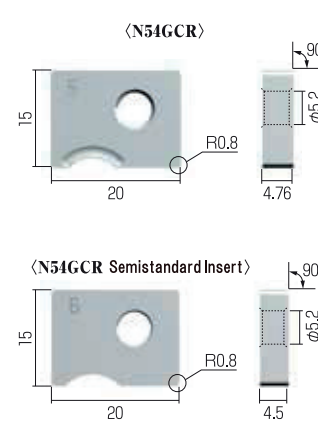

Surface Accuracy is good when the processing was made without rough cutting

## Insert

N54GCR			
Material	Feed PerBlade (fz)	NK2020	NK6060
		Cutting speed(m / min)	
General Steel	0.1~0.3	100~250	
Alloy Steel	0.1~0.3	100~250	150~250
Stainless Steel	0.1~0.25	80~160	150~250
Aluminum,Resin,Brass	0.1~0.3	150~400	
Castings	0.1~0.3	80~200	

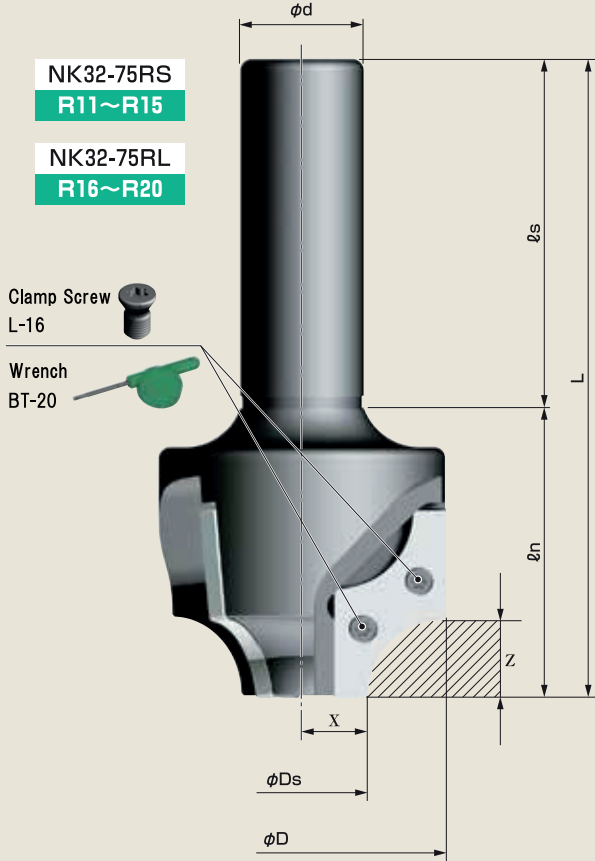
- According to the shape of work, clamp condition and large or small chamfering amount, the cutting condition will have to be adjusted.
- Yellow marked condition is recommended for the material listed
- In case of chamfering process of Stainless steel, kindly take down cutting

## Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box	
 <p>※ Semi standard Insert have no breaker</p>	N54GCR-5R NK2020	Carbide M20		None	1	3	
	N54GCR-8R NK2020	Carbide M20		None	1	3	
	N54GCR-10R NK2020	Carbide M20		None	1	3	
	N54GCR-5R NK6060	Carbide M20		TiAlN	1	3	
	N54GCR-8R NK6060	Carbide M20		TiAlN	1	3	
	N54GCR-10R NK6060	Carbide M20		TiAlN	1	3	
	Semi standard	N54GCR-6R NK2020		Carbide M20	None	1	3
		N54GCR-7R NK2020		Carbide M20	None	1	3
		N54GCR-9R NK2020		Carbide M20	None	1	3

### Easy radius change

● Various Radius chamfering can be made by just exchanging Inserts



NK32-75RS  
R11~R15

NK32-75RL  
R16~R20

Clamp Screw  
L-16

Wrench  
BT-20

This is not standard production model.  
Please check the delivery time when ordering

#### SETTING NUMERICAL VALUES

Processing R	X-axis position (mm)	Z-axis position (mm)
R11	17.50	11.77
R12	17.50	12.70
R13	17.50	13.63
R14	17.50	14.56
R15	17.50	15.48
R16	17.50	16.41
R17	17.50	17.34
R18	17.50	18.27
R19	17.50	19.20
R20	17.50	20.12

● numeric value might get some errors, please acknowledge.

#### R Chamfering



#### CUTTING CONDITIONS

Material	Material model number	NK2020
General Steel	0.1~0.3	100~250
Alloy Steel	0.1~0.3	100~250
Stainless Steel	0.1~0.25	80~160
Aluminum, Resin, Brass	0.1~0.3	150~400
Castings	0.1~0.3	80~200

- 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

[Periphery R20 Chamfering process]

- Body : NK32-75RL
- Insert : XNEW3004-20R NK2020

- Material : S50C
- Rotational speed : 750r.p.m.
- Table feed : 225mm/min

Wet Processing



#### Result

Surface Accuracy is good when the processing was made without rough cutting

#### Body

Model. No.	Blades	Dimensions (mm)					
		φD	φDs	φd	L	ℓs	ℓn
NK32-75RS	R11~R15	75.5	35	32	165	90	75
NK32-75RL	R16~R20	75.5	35	32	165	90	75

- ※ Insert is not equipped as standard accessory. Please purchase it separately
- ※ Clamp screw, screw, wrench and locator are supplied as standard accessories

#### Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
	XNEW3004-11R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-12R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-13R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-14R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-15R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-16R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-17R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-18R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-19R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-20R NK2020	Carbide M20	Honing edge	None	2	3

This is not standard production model.  
Please check the delivery time when ordering



**R-Bit** 1 Blade

**R0.5~R4**

**Specific agency Items**

lock pin L-12

Wrench K-4

**For general purpose lathe**

R0.5~R4 Chamfering process can be made by lathe



**BODY**

Product name	Model No.	blades	Dimensions (mm)			Inserts
			d1	D2	L	
R-Bit <b>Specific agency Items</b>	20XR	1	19	20	126	N43GXR NK1010 N43GXR8-0.5R~4R

- ✘ Inset is not supplied as standard accessory. Please purchase it separately.
- ✘ Lock Pin and wrench are supplied as standard accessory



Insert information P. 21

**10R-Bit** 1 Blade

**R5~R10**

Clamp Screw CL-1S

Wrench K-3

lock pin L-12

Wrench K-4

**For general purpose lathe**

R5~R10 Chamfering process can be made by lathe



**BODY**

Product name	Model No.	blades	Dimensions (mm)			Inserts
			d1	D2	L	
10R-Bit	25CR	1	25	25	150	N54GCR-5R~10R



Insert information P. 23



When mounting insert, please do not take reverse tightening.  
 Poor accuracy or finish or breakage of insert may be occurred due to the Eccentricity looking mechanism  
 When replacing insert, please make sure that the reserve tightening Was not made.

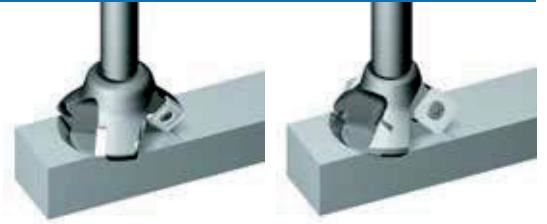
## Smaller shank

- Consider to use this Aeromill for Non-Rigidity Machines like Tapping Center !
- Choose various workpiece with Negative and Positive type Face Milling Cutters !

Aeromill  
**φ30mm · φ40mm**



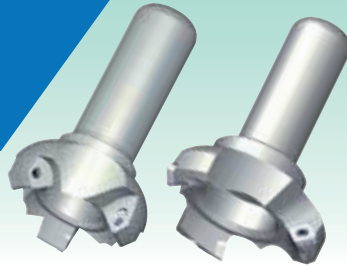
Face Milling (Aeromill)



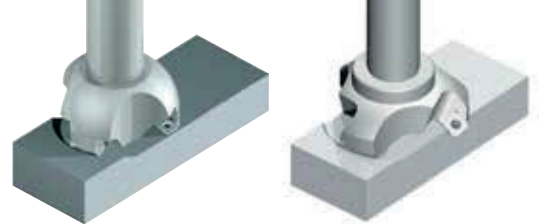
φ30mm · φ40mm

## Thin workpiece processing

NEW Tiko Cutter  
**φ60mm · φ80mm**



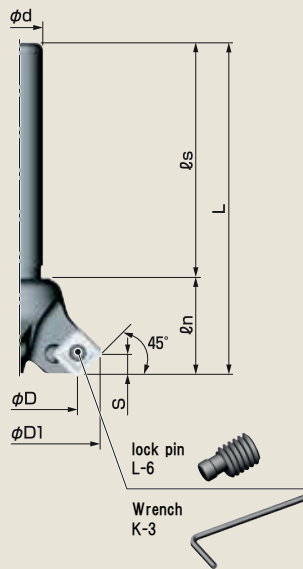
Face Milling (NEW Tiko Cutter, NS type)



φ60mm · φ80mm

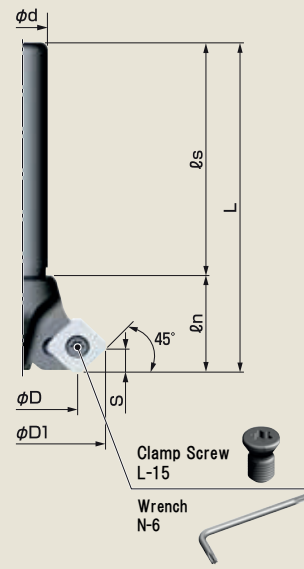
### 1 Aeromill

NS type (Negative S)



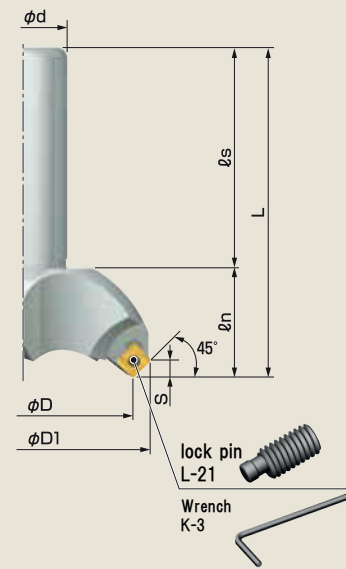
### 2 Aeromill

PS type (Positive S)



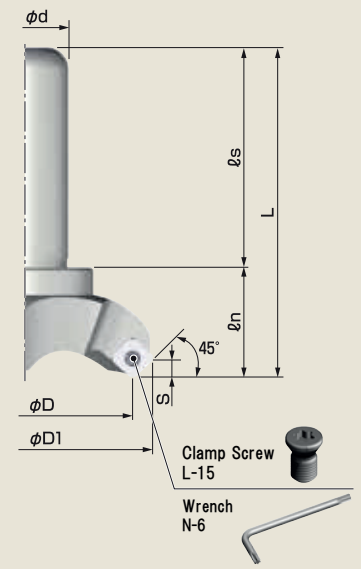
### 3 NEW Tiko Cutter

NS type (Negative S)



### 4 NEW Tiko Cutter

PS type (Positive S)



## Body

Product name	Model No.	Fig.	blades	Dimensions (mm)								Weight (g)	Inserts
				φD	φD1	φd	L	ℓs	ℓn	S			
Aeromill	NS	ARN12-30S	1	3	30	42	12	85	60	25	5.0	132	S32M0Z / S32GUR
		ARN16-40S	1	3	40	52	16	85	60	25	5.0	210	S32M0Z / S32GUR
	PS	ARP12-30S	2	3	30	43.2	12	85	60	25	6.0	116	S3H3MNZ / S3H3GNZ
		ARP16-40S	2	3	40	53.6	16	85	60	25	6.0	224	S3H3MNZ / S3H3GNZ
NEW Tiko Cutter	NS	TKN20-60S-03	3	3	60	73	20	120	80	40	5.0	668	S32M0Z / S32GUR
		TKN20-80S-03	3	3	80	93	20	120	80	40	5.0	826	S32M0Z / S32GUR
		TKN32-60S-03	3	3	60	73	32	120	80	40	5.0	968	S32M0Z / S32GUR
		TKN32-80S-03	3	3	80	93	32	120	80	40	5.0	1,126	S32M0Z / S32GUR
	PS	TKP20-60S-03	4	3	60	74	20	120	80	40	6.0	600	S3H3MNZ / S3H3GNZ
		TKP20-80S-03	4	3	80	94	20	120	80	40	6.0	780	S3H3MNZ / S3H3GNZ
		TKP32-60S-03	4	3	60	74	32	120	80	40	6.0	900	S3H3MNZ / S3H3GNZ
		TKP32-80S-03	4	3	80	94	32	120	80	40	6.0	1,070	S3H3MNZ / S3H3GNZ

※ Insert is not supplied as standard accessory

※ Clamp Screw, Lock Pin and wrench are supplied as standard accessories

### Cutting Conditions

S32MOZ								
Material	Material Model	NK2001	NK2050	AB01F	NK1010	NK2020	NK3030	AC15T
	Feed per blade (fz)	Cutting speed (m / min)						
General Steel	0.1~0.3	200~300	200~300	200~300		150~200	150~250	
Alloy Steel	0.1~0.3	200~250	200~250	200~250		150~200	150~250	
Stainless Steel	0.1~0.25					120~180	150~200	150
Aluminum, Resin, Brass								
Castings	0.1~0.3	200~250 *FCD		200~250 *FCD	150~200			

- Chamfered Insert nose increase feed speed per l-blade and make a good surface finishing
- Yellow marked rate is recommended for the workpiece listed

S32GUR									
Material	Material Model	NK2001	NK1010	NK2020	NK3030	NK5050	NK6060	NK8080	DIA
	Feed per blade (fz)	Cutting speed (m / min)							
General Steel	0.08~0.2	200~300		150~200					
Alloy Steel	0.08~0.2	200~250		150~200					
Stainless Steel	0.08~0.2			120~180	150~200		150~250	150~250 *SUS316	
Aluminum, Resin, Brass	0.08~0.3		250~800			200~800		200~800	500~2,000
Castings	0.08~0.2	200~250 *FCD	100~150						

- Insert breaker ensures sharp processing and R shaped nose ensure less cutting resistance, and recommended the workpiece which are easily chattered and a distortion arises
- Yellow marked rate is recommended for the workpiece listed

S3H3MNZ					S3H3GNZ	
Material	Material Model	NK2001	NK2020	AC15D	NK1010	NK9090
	Feed per blade (fz)	Cutting speed (m / min)				
General Steel	0.08~0.2	200~300	150~200			
Alloy Steel	0.08~0.2	200~300	150~200			
Stainless Steel	0.1			150		
Aluminum, Resin, Brass	0.1~0.2				500~1,000	500~1,000
Castings						

- Chamfered Insert nose increase feed speed per l-blade and make a good surface finishing
- Yellow marked rate is recommended for the workpiece listed

### Insert

Fig.	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
<b>● Negative Type</b> 	S32MOZ NK2001	Cermet	Honing edge	None	8	12
	S32MOZ NK2050	Cermet	Honing edge	None	8	12
	S32MOZ AB01F	Cermet	Honing edge	AlCrN	8	12
	S32MOZ NK1010	Carbide K10	Sharp edge	None	8	12
	S32MOZ NK2020	Carbide M20	Honing edge	None	8	12
	S32MOZ NK3030	Carbide M20	Honing edge	TiN	8	12
	S32MOZ AC15T	Fine particles Carbide	Honing edge	AlCrN	8	12
	S32GUR NK2001	Cermet	Honing edge	None	8	12
	S32GUR NK1010	Carbide K10	Sharp edge	None	8	12
	S32GUR NK2020	Carbide M20	Honing edge	None	8	12
	S32GUR NK3030	Carbide M20	Honing edge	TiN	8	12
	S32GUR NK5050	Carbide K10	Sharp edge	TiN	8	12
	S32GUR NK6060	Carbide M20	Honing edge	TiAlN	8	12
	S32GUR NK8080	Carbide K10	Sharp edge	TiAlN	8	12
	S32GUR DIA	DIA	Sharp edge	None	1	1
<b>● Positive Type</b> 	S3H3MNZ NK2001	Cermet	Honing edge	None	4	12
	S3H3GNZ NK1010	Carbide K10	Sharp edge	None	4	12
	S3H3MNZ NK2020	Carbide M20	Honing edge	None	4	12
	S3H3GNZ NK9090 (Mirror polished finish)	Carbide K10	Sharp edge	None	4	12
	S3H3MNZ AC15D	Fine particles Carbide	Honing edge	AlCrN	4	12

### Processing Example (Aeromill)

#### [Face Milling (PS type)]

- Body : ARP16-40S
- Insert : S3H3MNZ NK1010
- Material..... A5052
- Rotation Speed... 1,000r.p.m.
- Table feed..... 300mm/min
- Depth of Cut.... 0.5mm
- Cutting Oil..... None



**Result**  
Machined surface good.

### Processing Example (NEW TikoCutter)

#### [Face Milling (PS type)]

- Body : TKP32-80S-03
- Insert : S3H3MNZ NK1010
- Material..... S50C
- Rotation Speed... 1,060r.p.m.
- Table feed..... 636mm/min
- Depth of Cut.... 3mm
- Cutting Oil..... None



**Result**  
Machined surface good.

#### [Face Milling (NS type)]

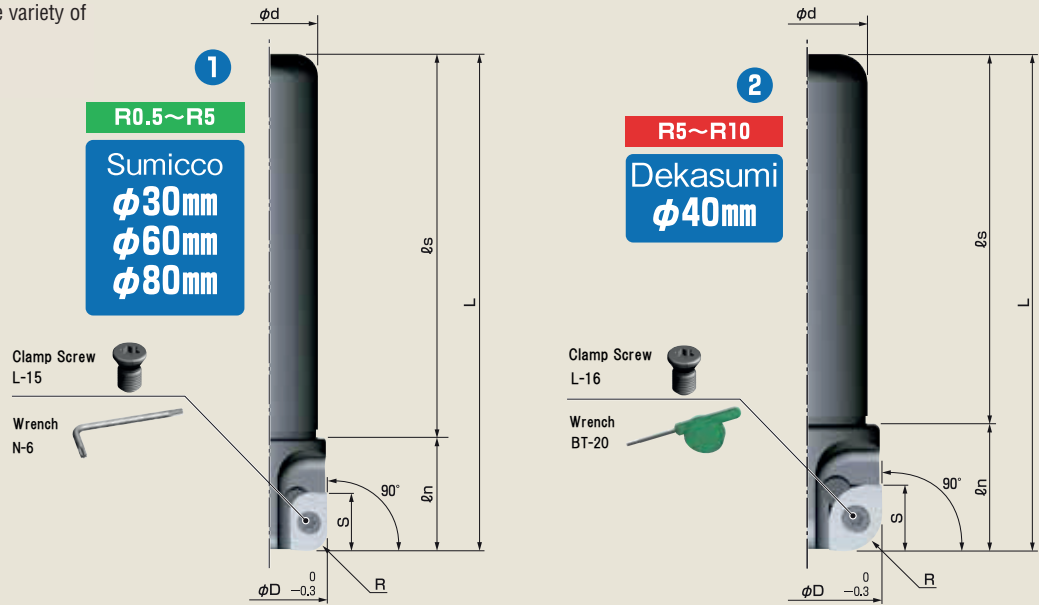
- Body : TKN32-60S-03
- Insert : S32MOZ AC15T
- Material..... SUS304
- Rotation Speed... 1,000r.p.m.
- Table feed..... 300mm/min
- Depth of Cut.... 2mm
- Cutting Oil..... None



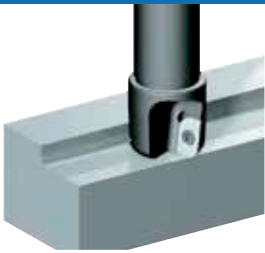
**Result**  
Machined surface good.

## Corner R processing

By chip exchange, it allows a wide variety of Corner R processing.



### Shoulder Milling (R)



### ⚠ Cautions

● Please choose the body to match the Insert to be used.

(Sumicco-Dekasumi are common.)  
The peripheral cutting edge have about 0.3~0.5° (Sumicco and Dekasumi are same)

### Body

Product name	Model No.	Fig.	blades	Dimensions (mm)						Inserts	Weight (g)
				φD	φd	L	ℓs	ℓn	S		
Sumicco	SK25-30ASR	①	2	30	25	130	100	30	15	A52GNR-0.5R~2.5R	478
	SK25-30ASRL	①	2	30	25	200	170	30	15	A52GNR-0.5R~2.5R	748
	SK25-30ALR	①	2	30	25	130	100	30	15	A52GNR-2.5R~5R	474
	SK25-30ALRL	①	2	30	25	200	170	30	15	A52GNR-2.5R~5R	746
	SK32-60ASR	①	4	60	32	105	80	25	15	A52GNR-0.5R~2.5R	798
	SK32-60ASRL	①	4	60	32	175	150	25	15	A52GNR-0.5R~2.5R	1,240
	SK32-60ALR	①	4	60	32	105	80	25	15	A52GNR-2.5R~5R	784
	SK32-60ALRL	①	4	60	32	175	150	25	15	A52GNR-2.5R~5R	1,240
	SK32-80ASR	①	4	80	32	105	80	25	15	A52GNR-0.5R~2.5R	1,100
	SK32-80ASRL	①	4	80	32	175	150	25	15	A52GNR-0.5R~2.5R	1,560
Dekasumi	DC32-40ASR	②	2	40	32	135.0	100	35.0	18.1	ADEW19T3-5R~7R	820
	DC32-40ASRL	②	2	40	32	185.0	150	35.0	18.1	ADEW19T3-5R~7R	1,140
	DC32-40ALR	②	2	40	32	134.6	100	34.6	17.6	ADEW19T3-8R~10R	813
	DC32-40ALRL	②	2	40	32	184.6	150	34.6	17.6	ADEW19T3-8R~10R	1,140

※ Insert is not equipped as standard accessories. Please order separately  
 ※ Clamp screw, and wrench are supplied as standard accessories

### Cutting Conditions

		Sumicco		
Material	Material Model	NK1010	NK2020	AC16N
		Cutting speed (m / min)		
General Steel	0.1~0.2		100~150	150~200
Alloy Steel	0.1~0.2		100~150	150~200
Stainless Steel	0.1~0.2		80~120	120~160
Aluminum, Resin,	0.1~0.3	250~600		
Castings	0.1~0.2	80~150		

		Dekasumi		
Material	Material Model	NK1010	NK2020	AC16N
		Cutting speed (m / min)		
General Steel	0.1~0.2		100~150	150~200
Alloy Steel	0.1~0.2		100~150	150~200
Stainless Steel	0.1~0.2		80~120	120~160
Aluminum, Resin,	0.1~0.3	250~600		
Castings	0.1~0.2	80~150		

● Work shape, clamping state, tool protrusion length, please adjust the conditions by cutting amount  
 ● You have been to the workpiece by recommended Insert.

● Work shape, clamping state, tool protrusion length, please adjust the conditions by cutting amount  
 ● Recommended Inserts

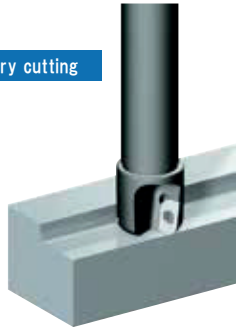
**Processing Example Sumicco**

**[Shoulder Milling (R3)]**

- Body : SK25-30ALR
- Insert : A52GNR-3R NK2020
- Material.....SKD11
- Work length.....200mm
- Rotation Speed...1,600r.p.m
- Feed (X-axis)....320mm/min
- Down cut air blow
- Cutting Oil.....None

**Result**

No secondary burrs and no chattering process




**Processing Example Dekasumi**

**[Shoulder Milling (R10)]**

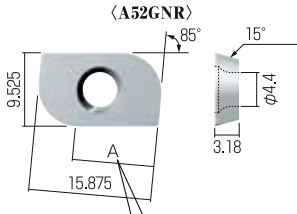
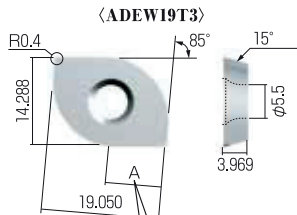
- Body : DC32-40ALR
- Insert : ADEW 19T3-R NK2020
- Material.....S50C
- Rotation Speed...1,500r.p.m
- Feed (X-axis)....450mm/min
- Cutting Depth....11mm
- Cutting Oil.....None

**Result**

No secondary burrs and no chattering process



**Insert**

Fig.	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box																						
<p>● Sumicco ※ R0.5 Stocks in size.</p>  <p><b>Blade length of the insert (Except nose R)</b></p> <table border="1"> <thead> <tr> <th>Model.No.</th> <th>A</th> </tr> </thead> <tbody> <tr><td>0.5R</td><td>15mm</td></tr> <tr><td>1R</td><td>14.4mm</td></tr> <tr><td>1.5R</td><td>13.9mm</td></tr> <tr><td>2R</td><td>13.3mm</td></tr> <tr><td>2.5R</td><td>12.8mm</td></tr> <tr><td>3R</td><td>12.2mm</td></tr> <tr><td>3.5R</td><td>11.7mm</td></tr> <tr><td>4R</td><td>11.1mm</td></tr> <tr><td>4.5R</td><td>10.5mm</td></tr> <tr><td>5R</td><td>10mm</td></tr> </tbody> </table>	Model.No.	A	0.5R	15mm	1R	14.4mm	1.5R	13.9mm	2R	13.3mm	2.5R	12.8mm	3R	12.2mm	3.5R	11.7mm	4R	11.1mm	4.5R	10.5mm	5R	10mm	A52GNR-0.5R NK1010 A52GNR-1R NK1010 A52GNR-1.5R NK1010 A52GNR-2R NK1010 A52GNR-2.5R NK1010 A52GNR-3R NK1010 A52GNR-3.5R NK1010 A52GNR-4R NK1010 A52GNR-4.5R NK1010 A52GNR-5R NK1010	Carbide K10	Sharp edge	None	2	12
	Model.No.	A																										
	0.5R	15mm																										
	1R	14.4mm																										
	1.5R	13.9mm																										
	2R	13.3mm																										
	2.5R	12.8mm																										
	3R	12.2mm																										
	3.5R	11.7mm																										
	4R	11.1mm																										
	4.5R	10.5mm																										
	5R	10mm																										
		A52GNR-0.5R NK2020 A52GNR-1R NK2020 A52GNR-1.5R NK2020 A52GNR-2R NK2020 A52GNR-2.5R NK2020 A52GNR-3R NK2020 A52GNR-3.5R NK2020 A52GNR-4R NK2020 A52GNR-4.5R NK2020 A52GNR-5R NK2020	Carbide M20	Honing edge	None	2	12																					
		A52GNR-0.5R AC16N A52GNR-1R AC16N A52GNR-1.5R AC16N A52GNR-2R AC16N A52GNR-2.5R AC16N A52GNR-3R AC16N A52GNR-3.5R AC16N A52GNR-4R AC16N A52GNR-4.5R AC16N A52GNR-5R AC16N	Fine Particles Carbide	Honing edge	AlCrN	2	12																					
	<p>● Dekasumi ※ R1 Stocks in size.</p>  <p><b>Blade length of the insert (Except nose R)</b></p> <table border="1"> <thead> <tr> <th>Model.No.</th> <th>A</th> </tr> </thead> <tbody> <tr><td>R5</td><td>13.2mm</td></tr> <tr><td>R6</td><td>12mm</td></tr> <tr><td>R7</td><td>11mm</td></tr> <tr><td>R8</td><td>9.8mm</td></tr> <tr><td>R9</td><td>8.7mm</td></tr> <tr><td>R10</td><td>7.7mm</td></tr> </tbody> </table>	Model.No.	A	R5	13.2mm	R6	12mm	R7	11mm	R8	9.8mm	R9	8.7mm	R10	7.7mm	ADEW19T3-5R NK1010 ADEW19T3-6R NK1010 ADEW19T3-7R NK1010 ADEW19T3-8R NK1010 ADEW19T3-9R NK1010 ADEW19T3-10R NK1010	Carbide K10	Sharp edge	None	2	4							
		Model.No.	A																									
		R5	13.2mm																									
		R6	12mm																									
R7		11mm																										
R8		9.8mm																										
R9		8.7mm																										
R10		7.7mm																										
		ADEW19T3-5R NK2020 ADEW19T3-6R NK2020 ADEW19T3-7R NK2020 ADEW19T3-8R NK2020 ADEW19T3-9R NK2020 ADEW19T3-10R NK2020	Carbide M20	Honing edge	None	2	4																					
		ADEW19T3-5R AC16N ADEW19T3-6R AC16N ADEW19T3-7R AC16N ADEW19T3-8R AC16N ADEW19T3-9R AC16N ADEW19T3-10R AC16N	Fine Particles Carbide	Honing edge	AlCrN	2	4																					

# Pricelist Catalogue Hogetex - Chamfering and Radius - Tools

## PAGE 2 - MOMIMEN NANO

1W20.6.21	SCN0845E	129,00€
Inserts:		
1W20.6.31	ENGX040102 AC15N	17,80€

## PAGE 3 - CHIBIMOMI

1W20.6.01	SCM1045C	95,00€
1W20.6.02	SCM1045CL	115,00€
Inserts:		
1W20.6.11	C22GUX NK5050	19,50€
1W20.6.12	C22GUX NK1010	15,90€

## PAGE 4 - MOMIMEN

1W20.7.01	SC1645C	122,00€
1W20.7.02	SC1645CL	177,00€
1W20.7.03	SC1045C	94,00€
1W20.7.04	SC1245C	122,00€
1W20.7.05	SC1630C	122,00€
1W20.7.06	SC1630CL	179,00€
Inserts:		
1W20.7.11	C32GUX NK1010	14,50€
1W20.7.12	C32GUX NK2001	15,00€
1W20.7.13	C32GUX NK2020	14,50€
1W20.7.14	C32GUX NK3030	20,80€
1W20.7.15	C32GUX NK5050	20,80€
1W20.7.16	C32GUX NK8080	25,00€
1W20.7.17	C32GUX HSS	18,00€

## PAGE 5 - 60° MOMIMEN

1W20.8.01	SC1660D (old Model)	140,00€
1W20.8.02	SC1660DS (new Model)	160,00€
Inserts:		
1W20.8.11	D43GUX NK1010 (old Model)	26,80€
1W20.8.12	D43GUX NK5050 (old Model)	31,50€
1W20.8.13	DCET11X304 ZA10N (new Model)	36,80€
1W20.8.14	DCET11X304 AC15N (new Model)	26,80€
1W20.8.15	DCET11X304E AC16N (new Model)	36,80€

## PAGE 6 AND 7 - CHAMFERING CUTTER

1W21.3.01	NK1536T-20	275,00€
1W21.3.03	NK2035T-20	275,00€
1W21.3.05	NK2535T-20	275,00€
1W21.3.07	NK3030T-20	275,00€
1W21.3.09	NK3532T-20	275,00€
1W21.3.11	NK4031T-20	275,00€
1W21.3.13	NK4530T-20	275,00€
1W21.3.15	NK5031T-20	275,00€
1W21.3.17	NK5532T-20	275,00€
1W21.3.19	NK6030T-20	275,00€
1W21.3.21	NK6533T-20	275,00€
1W21.3.23	NK7032T-20	275,00€
1W21.3.25	NK7533T-20	275,00€

## PAGE 6 AND 7 - CHAMFERING CUTTER

INSERTS:		
1W20.1.14	T32MOR NK2001	6,00€
1W20.1.15	TT32GUR NK2020	12,70€
1W20.1.16	TT32GUR NK2001	12,70€
1W20.1.17	TT32GUR NK1010	12,70€
1W20.1.18	TT32GUR NK3030	16,50€
1W20.1.19	TT32GUR NK5050	16,50€
1W20.1.20	T32MOR NK2020	6,00€
1W20.1.21	T32MOR NK1010	6,00€
1W20.1.22	TT32GUR NK6060/AC15N	20,00€
1W20.1.23	TT32GUR NK8080	18,20€

## PAGE 8 - GENTLEMEN

1W21.2.01	NK4557X	589,00€
1W21.2.02	NK6054X	570,00€
1W21.2.03	NK3080X	619,00€
Inserts:		
1W21.2.11	X63GUR NK1010	45,00€
1W21.2.12	X63GUR NK2020	45,00€
1W21.2.13	X63GUR AC15N	51,00€

## PAGE 9 - DEKATCUT

1W22.1.21	DNK9032T	205,00€
1W22.1.22	DNK9060T	369,00€
1W22.1.23	DNK9080T	410,00€
1W22.1.24	DNK90100T	465,00€
Inserts:		
1W22.1.27	TNEX270412 ZA10T	31,00€
1W22.1.28	TNEQ270412 ZA10N	21,00€
1W22.1.29	TNMX270412 AC15N	25,00€

## PAGE 10 AND 11 - MENTRUBE

1W20.3.01	BM-4524T	83,00€
1W20.3.02	BM-4538T	101,00€
1W20.3.03	BM-4552T	127,00€
1W20.3.04	BM-4566T	167,00€
1W20.3.05	BM-4524TL	118,00€
1W20.3.07	BM-6021T	112,00€
1W20.3.08	BM-3029T	115,00€
Inserts:		
1W20.3.11	TM32GUR-HSS	15,50€
1W20.3.12	TM32GUR HSS TIALN	24,00€
1W20.3.13	TM32-GSR-HSS	23,50€
1W20.3.14	TM32-GSR-HSS-TIALN	26,80€

## PAGE 12 AND 13 - MENTRUDEE

1W22.1.01	MBM4513T	91,00€
1W22.1.02	MBM4513TL	93,00€
1W22.1.06	MBM3015T	98,00€
1W22.1.07	MBM6010T	98,00€
Inserts:		
1W22.1.11	TCXT080102F ZC16N	11,50€
1W22.1.12	TCXT080102E AC16N	17,50€

## PAGE 14 AND 15 - URATORIMEN-C

1W21.1.01	UMH12-6.8S-M8	175,00€
1W21.1.02	UMH12-8.5S-M10	175,00€
1W21.1.03	UMH12-10S-M12	175,00€
1W21.1.04	UMH12-12S-M14	175,00€
1W21.1.05	UMH12-14S-M16	175,00€
1W21.1.06	UM12-16S	120,00€
Inserts:		
1W21.1.11	SP-SPET040102 NK1010	16,00€
1W21.1.12	SP-SPET040102 NK2020	16,00€
1W21.1.13	SP-SPET040102 AC16N	21,50€
1W21.1.21	SPET040102 NK1010	18,90€
1W21.1.22	SPET040102 NK2020	18,90€
1W21.1.23	SPET040102 AC16N	24,50€
1W21.1.31	SPET06T104 NK1010	19,30€
1W21.1.32	SPET06T104 NK2020	19,30€
1W21.1.33	SPET06T104 AC16N	24,90€

## PAGE 16 AND 17 - MULTI-ANGLE MILL

1W20.3.60	MAM32-50S	379,00€
Inserts:		
1W20.3.65	SDMT150404 ZA20N	15,30€
1W20.3.66	SDMT150404 DA20N /AC15N	29,00€

PRICES VALID TILL 31.12.2023. PRICES EXCLUDED VAT.

# Pricelist Catalogue Hogetex - Chamfering and Radius - Tools

## PAGE 18 - RC INDO CUTTER

1W20.1.01	CR25-05T	125,00€
Inserts:		
1W20.1.11	T32GSR-1R NK2020	28,00€
1W20.1.12	T32GSR-2R NK2020	28,00€
1W20.1.13	T32GSR-3R NK2020	28,00€
1W20.1.14	T32MOR NK2001	6,00€
1W20.1.15	TT32GUR NK2020	12,70€
1W20.1.16	TT32GUR NK2001	12,70€
1W20.1.17	TT32GUR NK1010	12,70€
1W20.1.18	TT32GUR NK3030	16,50€
1W20.1.19	TT32GUR NK5050	16,50€
1W20.1.20	T32MOR NK2020	6,00€
1W20.1.21	T32MOR NK1010	6,00€
1W20.1.22	TT32GUR NK6060/AC15N	20,00€
1W20.1.23	TT32GUR NK8080	18,20€

## PAGE 20 AND 21 - R-SPECIAL JR. / R-SPECIAL

1W20.4.00	NK20-05R	126,00€
1W20.4.01	NK25-05R	126,00€
1W20.4.02	NK20-40R-3	354,00€
1W20.4.03	NK25-40R-3	354,00€
1W20.4.04	NK32-40R-3	354,00€
Inserts:		
1W20.4.08	N43GXR8 NK2001	22,80€
1W20.4.09	N43GXR8 NK1010	22,80€
1W20.4.10	N43GXR8 NK2020	22,80€
1W20.4.11	N43GXR8-1R NK2020	22,80€
1W20.4.12	N43GXR8-2R NK2020	22,80€
1W20.4.13	N43GXR8-3R NK2020	22,80€
1W20.4.14	N43GXR8-4R NK2020	22,80€
1W20.4.15	N43GXR8-5R NK2020	44,50€
1W20.4.16	N43GXR8-0,5R NK2020	44,50€
1W20.4.17	N43GXR8-0,75R NK2020	44,50€
1W20.4.18	N43GXR8-1,5R NK2020	44,50€
1W20.4.19	N43GXR8-2,5R NK2020	44,50€
1W20.4.20	N43GXR8-3,5R NK2020	44,50€
1W20.4.21	N43GXR8-4,5R NK2020	44,50€
1W20.4.31	N43GXR8-1R NK2001	22,80€
1W20.4.32	N43GXR8-2R NK2001	22,80€
1W20.4.33	N43GXR8-3R NK2001	22,80€
1W20.4.34	N43GXR8-4R NK2001	22,80€

## PAGE 22 AND 23 - R-NOUVEAU JR. / R-NOUVEAU

1W20.5.01	NK25-10R	142,00€
1W20.5.02	NK20-10R	142,00€
1W20.5.03	NK32-70R	455,00€
Inserts:		
1W20.5.11	N54GCR-5R NK2020	33,50€
1W20.5.12	N54GCR-8R NK2020	33,50€
1W20.5.13	N54GC-10R NK2020	33,50€
1W20.5.14	N54GCR-6R NK2020	44,50€
1W20.5.15	N54GCR-7R NK2020	44,50€
1W20.5.16	N54GCR-9R NK2020	44,50€

## PAGE 24 - R-GIGA

1W20.5.30	NK32-75RS	759,00€
1W20.5.31	NK32-75RL	759,00€
Inserts:		
1W20.5.41	XNEW3004-12R NK2020	259,00€
1W20.5.43	XNEW3004-14R NK2020	259,00€
1W20.5.44	XNEW3004-15R NK2020	259,00€
1W20.5.45	XNEW3004-16R NK2020	259,00€
1W20.5.47	XNEW3004-18R NK2020	259,00€
1W20.5.49	XNEW3004-20R NK2020	259,00€

## PAGE 25 - R-BIT / 10R-BIT

1W20.2.01	Radiusbeitel 20XR	229,00€
Inserts:		
1W20.4.08	N43GXR8 NK2001	22,80€
1W20.4.09	N43GXR8 NK1010	22,80€
1W20.4.10	N43GXR8 NK2020	22,80€
1W20.4.11	N43GXR8-1R NK2020	22,80€
1W20.4.12	N43GXR8-2R NK2020	22,80€
1W20.4.13	N43GXR8-3R NK2020	22,80€
1W20.4.14	N43GXR8-4R NK2020	22,80€
1W20.4.15	N43GXR8-5R NK2020	44,50€
1W20.4.16	N43GXR8-0,5R NK2020	44,50€
1W20.4.17	N43GXR8-0,75R NK2020	44,50€
1W20.4.18	N43GXR8-1,5R NK2020	44,50€
1W20.4.19	N43GXR8-2,5R NK2020	44,50€
1W20.4.20	N43GXR8-3,5R NK2020	44,50€
1W20.4.21	N43GXR8-4,5R NK2020	44,50€
1W20.4.31	N43GXR8-1R NK2001	22,80€
1W20.4.32	N43GXR8-2R NK2001	22,80€
1W20.4.33	N43GXR8-3R NK2001	22,80€
1W20.4.34	N43GXR8-4R NK2001	22,80€

## PAGE 26 AND 27 - AEROMILL/NEW TIKO CUTTER

1W21.6.01	ARN12-30S	195,00€
1W21.6.02	ARN16-40S	220,00€
1W21.7.01	ARP12-30S	196,00€
1W21.7.02	ARP16-40S	220,00€
Inserts:		
1W21.6.11	S32MOZ NK2020	5,70€
1W21.6.12	S32MOZ NK3030	10,50€
1W21.6.13	S32MOZ NK6060 / AC15T	12,90€
1W21.6.14	S32GUR NK2020	10,90€
1W21.6.15	S32GUR NK3030	13,50€
1W21.6.16	S32GUR NK6060	16,00€
1W21.6.17	S32GUR DIA	108,00€
1W21.7.11	S3H3MNZ NK2020	8,90€
1W21.7.12	S3H3MNZ NK6060 / AC15D	14,00€

## PAGE 28 AND 29 - SUMICCO / DEKASUMI

1W21.4.01	SK25-30ASR	169,00€
1W21.4.02	SK25-30ALR	168,00€
1W21.5.01	DC32-40ASR	259,00€
1W21.5.02	DC32-40ALR	259,00€
Inserts:		
1W21.4.11	A52GNR-1R NK2020	15,90€
1W21.4.12	A52GNR-2R NK2020	15,90€
1W21.4.13	A52GNR-3R NK2020	15,90€
1W21.4.14	A52GNR-4R NK2020	15,90€
1W21.4.15	A52GNR-5R NK2020	15,90€
1W21.5.11	ADEW19T3-5R NK2020	27,50€
1W21.5.12	ADEW19T3-6R NK2020	27,50€
1W21.5.13	ADEW19T3-7R NK2020	27,50€
1W21.5.21	ADEW19T3-8R NK2020	27,50€
1W21.5.22	ADEW19T3-9R NK2020	27,50€
1W21.5.23	ADEW19T3-10R NK2020	27,50€

PRICES VALID TILL 31.12.2023. PRICES EXCLUDED VAT.

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