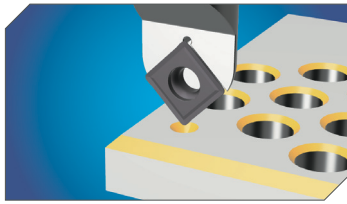


SCE

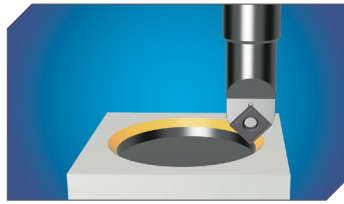
SUPER CHAMFER ENDMILL



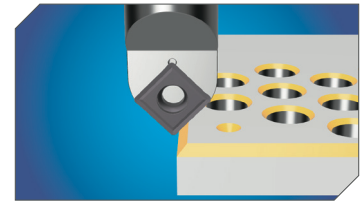
APPLICATION



Centering (1 edge only)



Hole & chamfer endmilling



Chamfering

ITEM CODE

SCE 45 N - D0014 Z1 - SD11

Superior
Chamfer &
Centerring
Endmill

Chamfer
angle
(°)

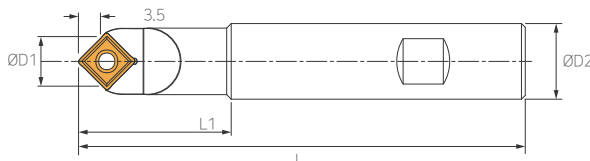
Direction
R/L/N

Cutting Dia'
(mm)

No. of edge

Insert

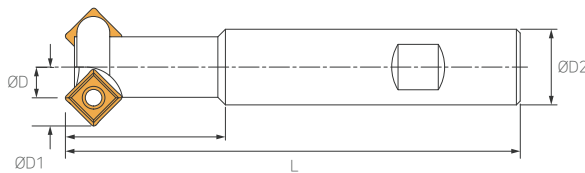
HOLDER



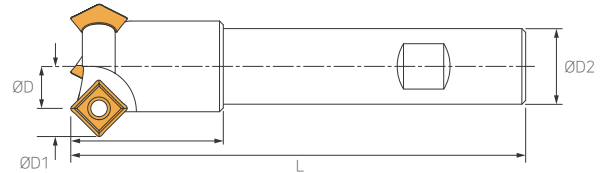
[Pic.1]



[Pic.2]



[Pic.3]

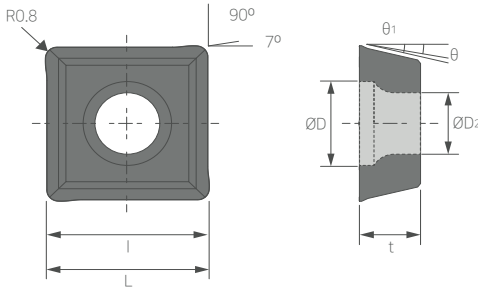


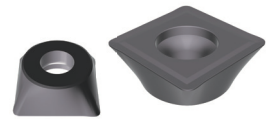
[Pic.4]

[UNIT : mm]

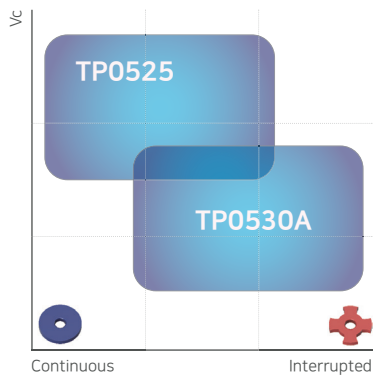
Product	No. of edge	ØD	ØD1	ØD2	L	L1	Insert	Pic.
SCE45N-D0010Z1-SD08	1	0	10.00	10	90	-	SDMT0802-AX	1
SCE45N-D0014-Z1-SD11	1	0	14.00	20	120	40	SDMT11T3-AX	1
SCE45N-D0921-Z1-SD11	1	9.00	21.00					2
SCE45R-D1933-Z2-SD11	2	19.00	33.90					3
SCE45R-D2739-Z3-SD11	3	27.66	39.42					4

INSERT

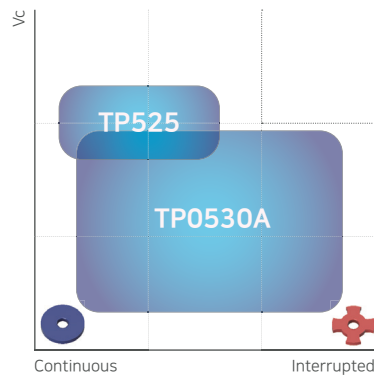
Drawing	Product	L	l	t	ØD	ØD2	r	θ	θ1	Grade
	SDMT0802-AX	8.35	-	2.48	6.0	3.6	0.4	-	15°	TP0525 / TP0530A
	SDMT11T3-AX	11.14	10.94	4.15	6.0	4.4	0.8	7°	15°	



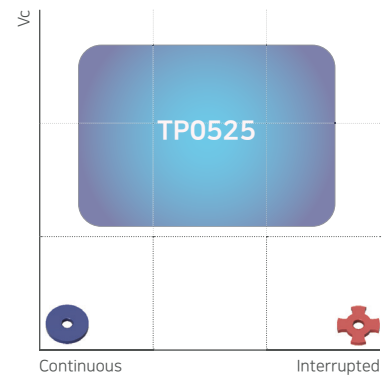
GRADE SELECTION



P

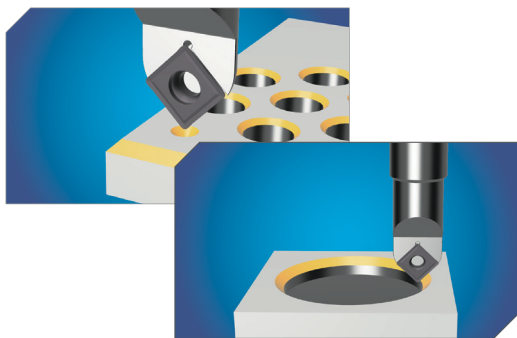


M S



K

RECOMMENDED CUTTING CONDITION



Work piece	vc (mm/min)	fz (mm/t)
Carbon steel	150-250	0.05-0.10
Alloy steel	100-200	0.04-0.06
Stainless steel	65-125	0.03-0.06
Hard to cut (Al, Copper)	150-320	0.05-0.10
Cast iron	80-150	0.05-0.10
Ti, Ti-alloy	60-80	0.03-0.06