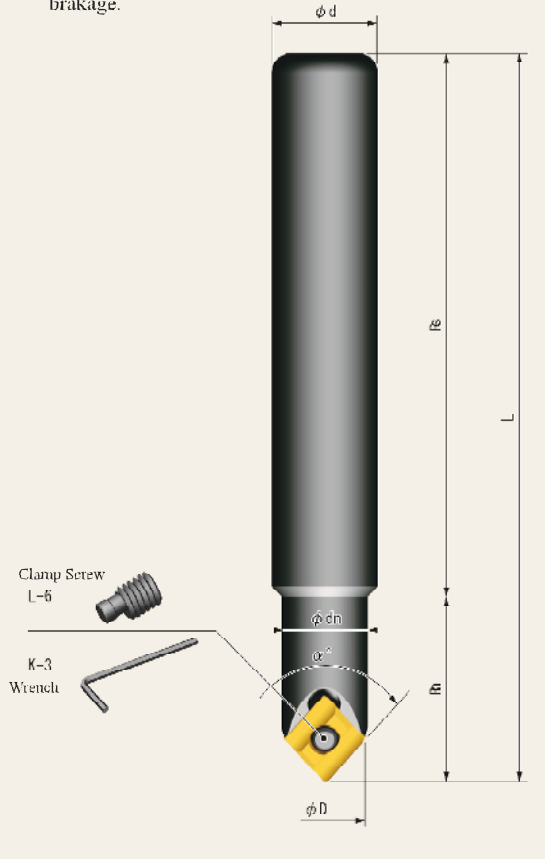


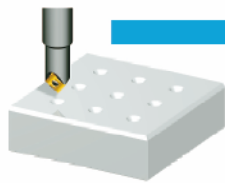
- Number of Tool Holder on ATC can be reduced due to Feature of MOMIMEN which can apply for Centering, Spot Drilling, Chamfering.
- Original Insert design avoids from vibration and brakage.



Example of Cutting

$\phi 8\text{mm}$ Centering, peripheral C3 Processing

- Holder: SC1645C
- Insert: C32GUX NK3030
 - Material: S45C Steel
 - Revolution: 3,500r.p.m.
 - Z-axis table feed: 100mm/min
 - X-axis table feed: 300mm/min



After processing, No Burr, No chattering
Very Good Performance

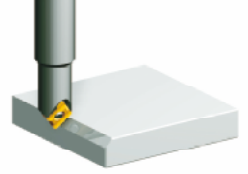
Centering & Spot Drilling



Chamfering & Countersink



Chamfering



*This tool can not be used with Drilling Machines

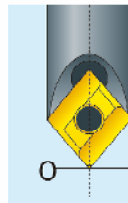
Model. No.	Capacity		α°
	Countersink Process		
SC1045C	$\phi 2 \sim \phi 13.5$		90°
SG1245C	$\phi 2 \sim \phi 13.5$		90°
SC1645C	$\phi 2 \sim \phi 13.5$		90°
SC1645CL	$\phi 2 \sim \phi 13.5$		90°
SG1630C	$\phi 2 \sim \phi 16.15$		118°
SC1630CL	$\phi 2 \sim \phi 16.15$		118°

Body

Model. No.	No. of Blade	Dimensions (mm)						α°
		ϕD	ϕd	ϕdn	L	It	It	
SC1045C	1	13.5	10	13	110	82	28	90°
SC1245C	1	13.5	12	13	110	82	28	90°
SC1645C	1	13.5	16	13	110	82	28	90°
SC1645CL	1	13.5	16	13	200	172	28	90°
SC1630C	1	16.15	16	16.5	110	82	28	118°
SC1630CL	1	16.15	16	16.5	200	172	28	118°

* Insert is Option

+ Clamp Screw, Wrench is equipped



Setting-up of Z-value correction (*Z-value could be making some error)

MOMIMEN $\rightarrow +0.45$

(Example)

Correct Z-value(-6.0) to -5.55 in case of $\phi 12\text{mm}$ Centering Process

Cutting Condition

Centering Process			
Material	(fz)	(r.p.m.)	Recommended Insert
Steel	0.05~0.1	1,500~3,000	C32GUX NK2020
Alloy Steel	0.05~0.1	1,500~3,000	C32GUX NK3030
Stainless Steel	0.05~0.1	1,500~3,000	C32GUX AC15D
Aluminum, Brass, Resin	0.05~0.2	3,000~	C32GUX NK1010
Cast Iron	0.05~0.1	1,500~3,000	C32GUX NK3030

Chmafering Process			
Material	(fz)	(r.p.m.)	Recommended Insert
Steel	0.1~0.2	2,000~	C32GUX NK2001
Alloy Steel	0.1~0.2	2,000~	C32GUX NK2001
Stainless Steel	0.1~0.2	2,000~	C32GUX AC15D
Aluminum, Brass, Resin	0.1~0.2	3,000~	C32GUX NK1010
Cast Iron	0.1~0.2	2,000~	C32GUX NK2001

● Please take Centering cutting condition in case of Z-axis operation only

● Please adjust cutting condition according to work-shape, clamping condition, cutting value etc.

Insert

Diagram	Model	Material	Edge Shape	Coating	Usable Corner	Insert per box
	C32GUX NK2001	サーメット	Honing		2	12 pcs.
	C32GUX NK1010	K10	Sharp		2	12 pcs.
	C32GUX NK2020	M20	Honing		2	12 pcs.
	C32GUX NK3030	M20	Honing	TiN	2	12 pcs.
	C32GUX NK5050	K10	Sharp	TiN	2	12 pcs.
	C32GUX NK6060	M20	Honing	TiAlN	2	12 pcs.
	C32GUX NK8080	K10	Sharp	TiAlN	2	12 pcs.
	C32GUX AC15D	Carbide	Honing	AlCrN	2	12 pcs.
	C32GUX HSS	ハイス	Sharp		2	12 pcs.
	C32GUX HSS TiN	ハイス	Sharp	TiN	2	12 pcs.

