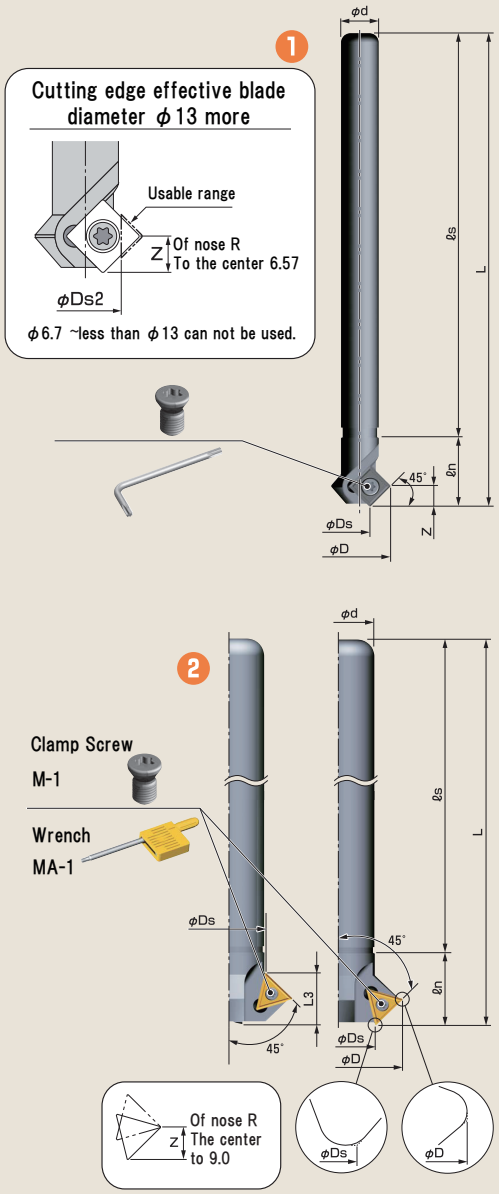
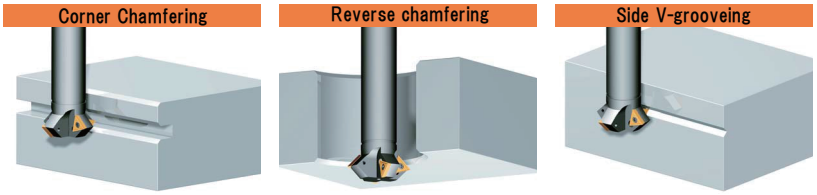
One pass chamfering!

- Enable front/reverse chamfering and V-grooving one pass





Model. No.	Capacity
	Bore chamfering
MRV12-19S	φ13mm～φ19.5mm
RV16-35T	φ18mm～φ35.9mm
RV25-46T	φ28mm～φ45.6mm

Body

Model. No.	Fig.	Blades	Dimensions (mm)									Inserts
			φD	φDs	φDs2	φd	L	ℓs	ℓn	L3	Z	
MRV12-19S	1	1	19.5	6.7	13	12	150	128	22	—	6.57	SPMT090304
RV16-35T	2	Staggered 2 blade	35.9	18		16	200	175	25	18.3	9.0	T22MOR
RV25-46T	2	Staggered 4 blade	45.6	28		25	200	175	25	17.9	9.0	T22MOR

※ Inset is not supplied as standard accessory. Please order spearately.
※ Clamp screw wrench are supplied as standard accessory.

Cuttinng Conditions

Chamfering		
Material	Feed per blade (fz)	Cutting speed (m / min)
General Steel	0.05～0.2	100～150
Alloy Steel	0.05～0.2	100～150
Stainless Steel	0.05～0.2	80～120
Aluminum,Resin, Brass	0.08～0.25	150～400
Cast Steel	0.05～0.2	100～150

Side V Groove Processing		
Material	Feed per blade (fz)	Cutting speed (m / min)
General Steel	0.03～0.1	100～150
Alloy Steel	0.03～0.1	100～150
Stainless Steel	0.03～0.1	80～120
Aluminum,Resin, Brass	0.05～0.15	150～400
Cast Steel	0.03～0.1	100～150

- According to the shape of work, clamp condition and large or small chamfering amount, the cutting condition will have to be adjusted.
- In case of large amount chamfering process, please reduce the condition
- In case of chamfering process of Stainless steel, kindly take down cutting

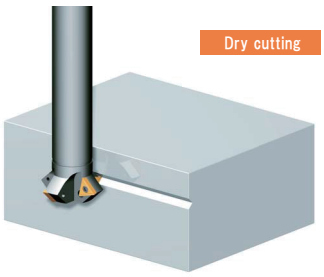
Processing Example

[Side V-grooving process]

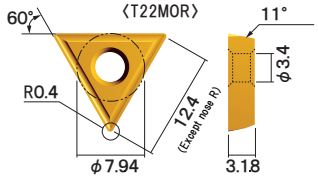
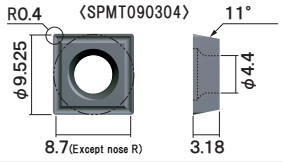
- Body : RV25-46T
- Insert : T22MOR NK5050
- Material ····· SUS304
- Rotation Speed ·· 800r,p,m
- Table feed ····· 160mm/min
- Cutting Depth ··· 2mm
- Cutting Oil ····· None

Result

Good!
Without secondary burrs and chattering



Insert

Figure	Model.No.	Material	Coating	Usable corner	Quantity per box
	T22MOR NK5050	Carbide M10	TiN	3	12
	SPMT090304 NK6060	Carbide M20	TiAℓN	4	12