

## 2 Flutes NON-COAT for Chamfering



Size  $\phi 3 \sim \phi 12$

# SV

Super  
MG

30°

Flatland

Shank Dia  
0/-0.005

Material Applications (★ Highly Recommended ● Recommended ○ Suggested)

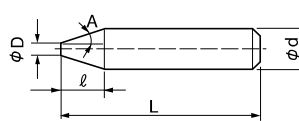
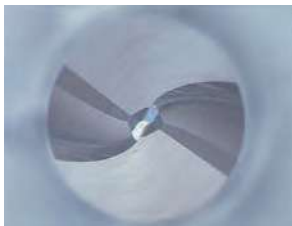
Work Material																	
Carbon Steels S45C S55C	Alloy Steels SK / SCM SUS	Prehardened Steels NAK HPM	Hardened Steels					Cast Iron	Aluminum Alloys	Graphite	Copper	Plastics	Glass Filled Plastics	Titanium Alloys	Heat Resistant Alloys	Cemented Carbide	Hard Brittle (Non-Metallic) Materials
			~ 50HRC	~ 55HRC	~ 60HRC	~ 65HRC	~ 70HRC										
●	●	●						○	○	○	○	○					

### Features

Spiral type chamfering cutter.

Half included angle  $45^\circ$ .

By applying a spiral peripheral cutting edge, burrs are greatly reduced when compared to a straight cutting edge design.



Total 6 models

Unit (mm)

Model Number	Tip Diameter $\phi D$	Length of Cut $\ell$	Overall Length L	Half Included Angle A	Shank Diameter $\phi d$	Suggested Retail Price ¥
SV 2030	0.8	1.1	40	$45^\circ$	3	13,000
SV 2040		1.6	45		4	14,000
SV 2060	1	2.5	50		6	15,750
SV 2080		3.5	60		8	19,250
SV 2100		4.5	70		10	27,500
SV 2120		5.5	75		12	32,230

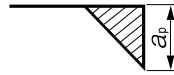
- φ3mm Shark V Series
- UDC-PCD Series
- CBN Series
- Square
- Long Neck Square
- Radius
- Long Neck Radius
- Taper Neck Radius
- Ball / Long Shank Ball
- Long Neck Ball
- Taper Neck Ball
- Taper
- Barrel
- Spiral V Cutter
- Drill
- Technical Data

## Milling Conditions for SV

WORK MATERIAL		CARBON STEELS S45C / S50C (~225HB)		ALLOY STEELS SK / SCM / SUS (225~325HB)		PREHARDENED STEELS HARDENED STEELS NAK / SKD (30~45HRC)	
Model Number	Shank Diameter (mm)	Spindle Speed (min <sup>-1</sup> )	Feed Rate (mm/min)	Spindle Speed (min <sup>-1</sup> )	Feed Rate (mm/min)	Spindle Speed (min <sup>-1</sup> )	Feed Rate (mm/min)
2030	3	2,700~5,300	59~86	2,100~4,200	46~67	1,600~3,200	35~51
2040	4	2,000~4,000	48~68	1,600~3,200	38~54	1,200~2,400	29~41
2060	6	1,300~2,700	36~49	1,100~2,100	31~42	800~1,600	22~30
2080	8	1,000~2,000	32~42	800~1,600	26~34	600~1,200	22~30
2100	10	800~1,600	30~37	640~1,300	23~29	600~1,200	17~22
2120	12	700~1,300	28~35	530~1,100	21~27	400~800	17~22

Milling Amount (mm)

$$a_p = 0.1D$$

 $a_p$  : Axial Depth (mm)


Note:

- The figures listed above are for nominal diameters. Adjust the speed and feed rate according to the correct diameter.
- Recommend slot milling with the tip flutes. Decrease the feed rate 50% from the milling parameters in this case.
- Recommend water soluble or oil coolant.

 Ø3mm Shank  
V Series
UDC-PCD  
SeriesCBN  
Series

Square

Square

Long Neck  
Square

Radius

Radius

Long Neck  
RadiusTaper Neck  
Radius

Ball

Ball / Long  
Shank BallLong Neck  
BallTaper Neck  
Ball

Taper

Taper

Barrel

Barrel

Spiral  
V CutterSpiral  
V Cutter

Drill

Drill

Technical Data

Technical Data