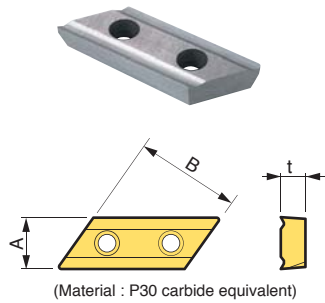


《 Insert 》



ZX coated insert for steel

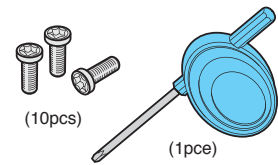
TiN & AlN super multi-layer coating on tough carbide. Extended tool life and excellent surface finish avoiding built-up edge are achieved.

Model		A	B	t
Coated	Non-coated			
CW1206A(ZX)	CW1206A	6.35	12.7	2.7
CW1909A(ZX)	CW1909A	9.525	19.05	4.5
CW3115A(ZX)	CW3115A	15.875	31.75	7.0

1. Insert is available from 1 pce.

Insert set is available in packs of 10 pcs.
Please add "S" before each model number when ordering.
《 Example 》 **SCW1206A(ZX)**

《 Insert clamping screw set 》



Insert size	Set model	Wrench
CW12	S2S-B	FLR-13S
CW19	S3S	FLR-20S
CW31	S5S	FLR-28S

1. 10 pcs. of screws and 1 pce. of wrench are included.
(Wrench only is also available.)

■ Recommended cutting conditions

Model	Max. chamfer	Chamfering	General steel		Stainless steel		Cast iron		Aluminum	
			V	f	V	f	V	f	V	f
ST20-C5/85A-40 NEW	※2mm	Plunge cutting	50	0.1	30	0.08	40	0.1	80	0.1
		Side cutting	80	0.15	60	0.1	50	0.15	100	0.2
ST20-C0525C	C2	Plunge cutting	50	0.1	30	0.08	40	0.1	80	0.1
		Side cutting	80	0.15	60	0.1	50	0.15	100	0.15
ST25-C1040C	C3	Plunge cutting	90	0.15	40	0.12	60	0.15	100	0.2
ST25-C1434C-60 NEW	※3mm	Side cutting	120	0.3	60	0.2	90	0.3	150	0.3
ST32-C1652C-30 NEW			120	0.3	60	0.18	90	0.25	150	0.3
ST32-C3060C	C4	Plunge cutting	120	0.3	60	0.18	90	0.25	150	0.3
ST32-C3050C-60 NEW	※4mm	Side cutting	150	0.45	60	0.3	120	0.6	200	0.6
ST32-C4565C-60 NEW			150	0.45	60	0.36	120	0.6	240	0.6
ST42-C5085C-30 NEW	C4	Side cutting	150	0.4	80	0.25	120	0.35	180	0.4
ST42-C50100C			150	0.45	60	0.36	120	0.6	240	0.6

V: Cutting speed (m/min) f: Feed per revolution (mm/rev.)

1. Cutting condition is the same for both non-coated and coated inserts.
Coated insert provides better surface finish in extended period.
2. Reduce cutting speed if a larger chamfer than the max. amount shown in the table is required.

3. Peck feed is necessary in case cutting chips are too long in plunge cutting.
4. High rigidity toolholder is recommended, such as BIG HMC or MEGA-D chuck.
5. Max. chamfering amount with * in Universal Type and 30° & 60° Types indicates the chamfering length of the longer side.

**Extensive chamfering range
C-CUTTER 45° Type**

Reduced number of tool holders and machining time by wide chamfering range.



1 cutter covers
Ø5 - Ø25
1 cutter covers
Ø10 - Ø40
1 cutter covers
Ø30 - Ø60
1 cutter covers
Ø50 - Ø100

**Ultra high feed chamfer mill
C-CUTTER mini**

4 inserts, small diameter and new coating achieve ultra high feed rate.



Front & back chamfering

World's smallest
Inscribed circle
Ø3.97

World smallest
Ø3.97 hex insert

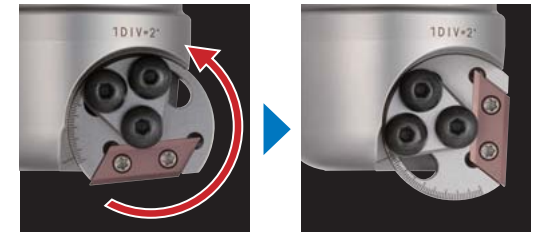


C-CUTTER

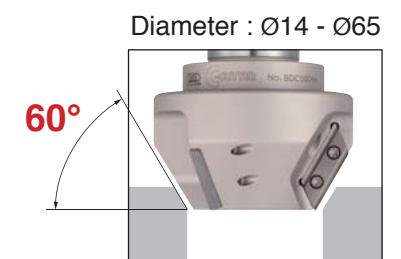
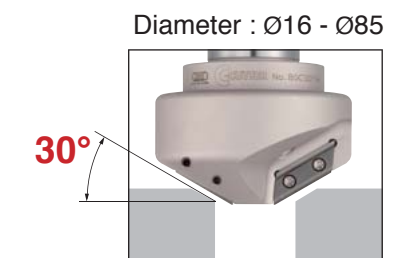
CATALOG No. EXm328



● Easy angle adjustment with a hex key.



New chamfering angles available from C-CUTTER series!!



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JQA-QMA11602
AWAJI No.1 Factory
JQA-QM3913
FA Dept.

CATALOG No. EXm328-1110-1

Subject to technical changes by further developments.

BIG DAISHOWA SEIKI CO LTD

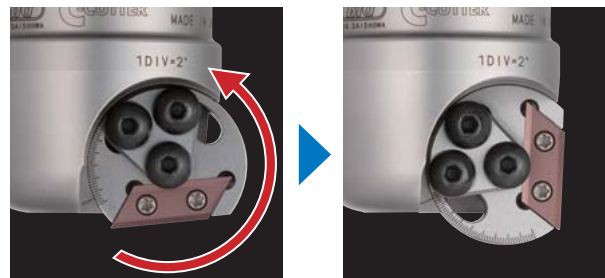
UNIVERSAL

Chamfering angle from 5° to 85° with one cutter.



C-CUTTER Universal Type

Universal cartridge for any angle



● Easy angle adjustment from 5° to 85° with a hex key.

Rotate the Angle Adjuster with a hex key and revolve the Cartridge to achieve the target angle. Scale on the Cartridge eases the adjustment.

Model **ST20-C5 / 85A-40**

Cartridge

Angle Adjuster

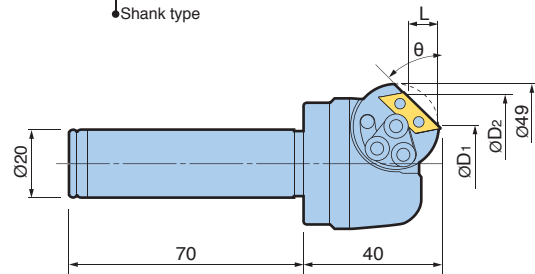
● Model description

ST20 - C 5 / 85 A -40

Chamfering angle

C-Cutter

Shank type



Insert : CW1206A

[Chamfering range]

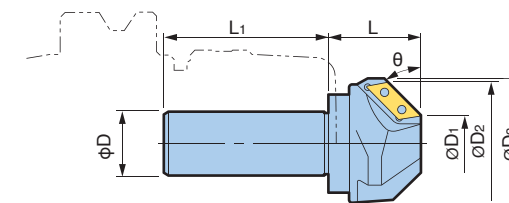
Angle θ	Smallest hole dia. ϕD_1	Largest chamfering dia. ϕD_2	L
5°	5.5	33.5	1.2
10°	7.3	34.7	2.4
15°	9.0	36.2	3.6
20°	11.2	37.4	4.7
25°	13.0	38.6	5.9
30°	15.2	39.6	7.0
35°	17.4	40.5	8.0
40°	19.6	41.2	9.0
45°	21.8	41.8	10.0
50°	24.0	42.2	10.8
55°	26.4	42.4	11.4
60°	28.5	42.5	12.1
65°	30.7	42.4	12.5
70°	32.9	42.1	12.6
75°	34.9	41.7	12.7
80°	36.9	41.1	11.9
85°	38.8	40.3	8.6

Chamfering range and L dimensions are reference figures.

30° & 60°

One C-CUTTER covers wide chamfering range!

C-CUTTER 30° & 60° Types



● Model description

ST32 - C 16 52 C -30

Shank type
C-Cutter
Smallest hole dia.
Largest chamfering dia.
Coolant nozzle
Angle (blank for 45°)

Angle θ	Model	ϕD	Smallest hole dia. ϕD_1	Largest chamfering dia. ϕD_2	Body dia. ϕD_3	L	L ₁	No. of insert	Insert
30°	ST32-C1652C-30 <small>NEW</small>	32	16	52	68	48	80	2	CW1909A
	ST42-C5085C-30 <small>NEW</small>	42	50	85	96	52	80	3	CW1206A
45°	ST20-C0525C	20	5	25	33	25	48	1	CW1909A
	ST25-C1040C	25	10	40	45	35	58	2	CW1909A
	ST32-C3060C	32	30	60	65	45	80	3	CW3115A
60°	ST42-C50100C	42	50	100	106	70	80	3	CW3115A
	ST25-C1434C-60 <small>NEW</small>	25	14	34	39	37	58	2	CW1909A
	ST32-C3050C-60 <small>NEW</small>	32	30	50	54	45	80	3	CW1909A
	ST32-C4565C-60 <small>NEW</small>	32	45	65	69	50	80	3	CW1909A

1. Inserts are ordered separately.

2. Insert clamping key and screws are included.

3. CK shank type is available for 45° models.

Coolant nozzles (30°, 45° & 60° types)

Adjustable nozzles direct coolant to cutting point. Excellent surface finish is obtained by sharp cutting edge and secure coolant supply. Especially effective in chamfering materials difficult to cut or easy to create built-up edge.



Double-screwed insert

Parallelogram shaped long inserts are securely clamped with double screws for stable chamfering.



Reduced number of cutters and machining time

The wide chamfering range saves on the number of toolholders required and thus tool changing times. Effective use of magazine pots and shorter machining times are achievable.

