

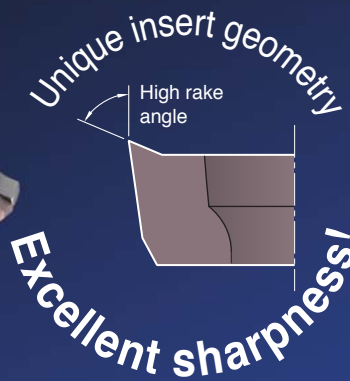
NEW PRODUCTS

Automated R-chamfering



■ Front & back chamfering are available!

■ 4 inserts multiply feed rate!

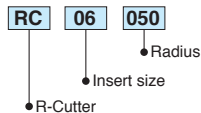


High rake angle reduces cutting resistance and minimizes the generation of burrs.



4 corners

● Model description



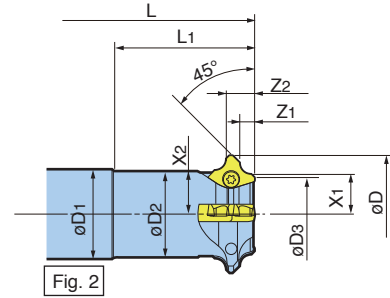
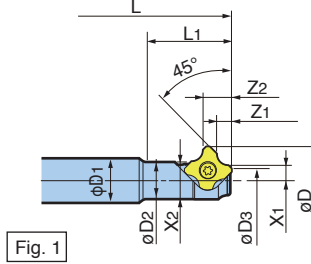
Type	Insert model	Radius
RC06	RC06050 ACP300	R0.5
	RC06100 ACP300	R1.0
	RC06150 ACP300	R1.5
	RC06200 ACP300	R2.0
RC12	RC12100 ACP300	R1.0
	RC12200 ACP300	R2.0
	RC12300 ACP300	R3.0
	RC12400 ACP300	R4.0

1. Inserts are available in packet of 10 pcs.
2. Material is coated carbide.

Workpiece material	Cutting speed (mm/min)	Feed rate (mm/tooth)	Coolant
Structural, carbon or alloy steel	100-350	0.05-0.2	Dry
Prehardened steel less than HRC40	60-80	0.05-0.1	Wet
Stainless steel	100-250	0.08-0.2	Dry / Wet
Cast iron	100-350	0.05-0.25	Dry
Aluminum	100-800	0.05-0.25	Dry / Wet

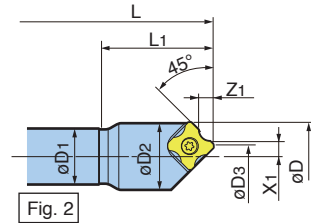
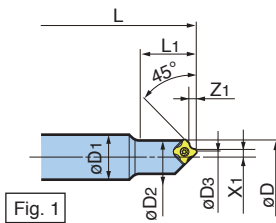
1. The table is a reference to determine cutting conditions. It should be adjusted according to the condition of the machine tool and workpiece.

2. Wet cutting is generally recommended to obtain good surface quality.
3. In case of built-up edge occurs cutting aluminum and stainless steel, use soluble oil.



Front & back R-chamfering

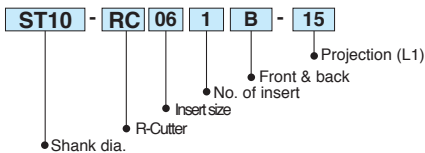
Model	Fig.	øD	øD1	øD2	øD3	L	L1	No. of insert	R	X1	Z1	X2	Z2	Insert model
ST10-RC061B-15	1	12.3	10	6.6	4.4	78	15	1	0.5	3.61	1.93	4.30	5.58	RC06...
									1	3.35	2.18	4.04	5.33	
									1.5	3.09	2.43	3.78	5.08	
									2	2.83	2.68	3.52	4.83	
ST16-RC121B-30	1	24.4	16	13.3	8.6	103	30	1	1	7.17	3.79	8.56	11.22	RC12...
									2	6.65	4.29	8.03	10.72	
									3	6.13	4.79	7.51	10.22	
									4	5.60	5.29	6.99	9.72	
ST16-RC064B-30	2	21	16	15.2	13.2	101	30	4	0.5	7.89	1.93	8.59	5.78	RC06...
									1	7.64	2.18	8.34	5.53	
									1.5	7.39	2.43	8.09	5.28	
									2	7.13	2.68	7.84	5.03	
ST32-RC124B-50	2	42	32	30.8	26.3	141	50	4	1	15.85	3.79	17.26	11.63	RC12...
									2	15.33	4.29	16.75	11.13	
									3	14.83	4.79	16.24	10.63	
									4	14.31	5.29	15.73	10.13	



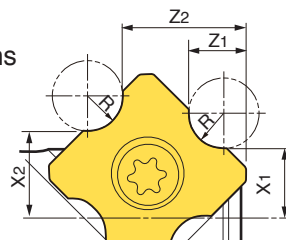
Front R-chamfering

Model	Fig.	øD	øD1	øD2	øD3	L	L1	No. of insert	R	X1	Z1	Insert model
ST16-RC061-20	1	12.3	16	11.9	4.5	94	20	1	0.5	3.61	1.93	RC06...
									1	3.35	2.18	
									1.5	3.09	2.43	
									2	2.83	2.68	
ST20-RC121-40	2	24.4	20	23.8	8.9	121	40	1	1	7.17	3.79	RC12...
									2	6.65	4.29	
									3	6.13	4.79	
									4	5.60	5.29	

Model description



R-dimensions



BIG DAISHOWA SEIKI CO LTD

Takaramachi 5-2, Higashiosakashi
 Osaka 579-8025 JAPAN
 Phone : (+81)-72-982-8277 Fax : (+81)-72-982-8370
<http://www.big-daishowa.com> E-mail: export@big-net.ne.jp



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