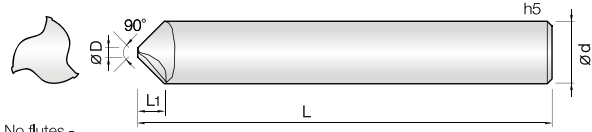


3CHA

3 Flutes 90 ° Chamfering Cutter



No flutes -
in the bottom



D Size	D Tolerance
Ø0.8 ~ 2	+0 ~ -0.02 mm

2CHA / 3CHA Cutting Condition

• RPM : rev./min • Feed : mm/min

Material	Carbon Steels		Alloy Steels		Hardened Steels	
	~ 225 HB		225 ~ 325 HB		35~ 40HRC	
Outside Diameter	RPM	FEED	RPM	FEED	RPM	FEED
Ø3	4,200	70	3,000	55	2,500	40
Ø4	3,000	60	2,500	45	1,800	35
Ø6	2,000	40	1,500	35	1,200	25
Ø8	1,500	35	1,200	30	900	25
Ø10	1,200	35	1,000	25	900	20
Ø12	1,000	30	850	25	600	20

Depth of Cut	<p>Ap : 0.1d Ap : Axial Depth</p>
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- The parameters on the table is based on 2 flutes. To change the number of flutes, refer to the same diameter of other parameter s and then adjust it.
- Use this table for your reference. Adjust the parameters depending on your machining geometry, machining purpose and CNC.
- Air blow, water-soluble oil, or oil mist is recommended.