

MILLING Chamfering

Quick guide .D122

CHAMFERSQUARE .D123

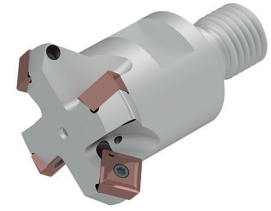
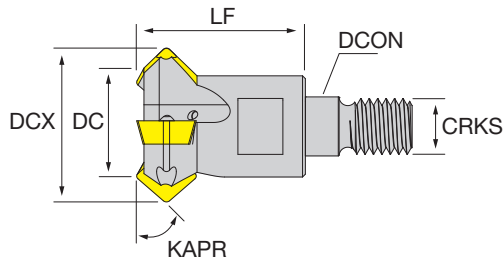
CHAMFERSQUARE	
	<input type="checkbox"/> D123
 	 SCREW-IN CYLINDRICAL
KAPR	45°
Insert sizes	05 / 07 / 09
APMX	4.2 / 6.34 / 8.2
Tool diameter	Ø12 - Ø32
Coolant holes	✓
Workpiece material	P M K N
No. of cutting edges	4
No. of geometries	2
Special features	-
Chamfering	✓
Machine load	■ ■ □ □ □
Strength	■ ■ ■ □ □
Precision	■ ■ ■ □ □
Finishing	■ ■ ■ □ □
Range	■ ■ ■ ■ □

NT-CHS45

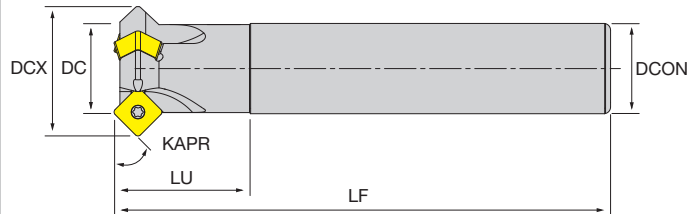
ChamferSquare

- Positive chamfering cutters for SP inserts
- All with coolant through
- Please select insert size according to your chamfer length
- Inserts could also be mounted on DRS drills

Screw-in



Cylindrical



Designation	DC	CICT	DCX	DCON	LF	LU	CRKS	WT			Stock
SCREW-IN											
NT-CHS45 D12/19-M06-Z3-05	12	3	19	6.5	20	-	M6	-			●
NT-CHS45 D16/22-M08-Z4-05	16	4	22	8.5	25	-	M8	-			●
NT-CHS45 D20/30-M10-Z3-07	20	3	30	10.5	30	-	M10	-			●
NT-CHS45 D25/37-M12-Z3-09	25	3	37	12.5	35	-	M12	-			●
NT-CHS45 D32/44-M16-Z4-09	32	4	44	17	40	-	M16	-			●
CYLINDRICAL SHANK											
NT-CHS45 D12/19-S12-Z3-05	12	3	19	12	80	20	-	-			●
NT-CHS45 D16/22-S16-Z4-05	16	4	22	16	100	25	-	-			●
NT-CHS45 D20/30-S20-Z3-07	20	3	30	20	110	30	-	-			●
NT-CHS45 D25/37-S25-Z3-09	25	3	37	25	120	35	-	-			●
NT-CHS45 D32/44-S32-Z4-09	32	4	44	32	130	40	-	-			●

★ 1st choice, ☆ suitable, ● stock standard, ◎ non-stock standard (no MOQ), ○ non-stock standard (MOQ), ▲ upcoming product, ▽ stock exhaustion

Spare parts	Insert screw	Flag wrench
NT-CHS45 D ₀₀ /00-000-Z ₀ -05	NT-ST20047T06	NT-FTB06
NT-CHS45 D ₀₀ /00-000-Z ₀ -07	NT-ST25060T07B	NT-FTB07
NT-CHS45 D ₀₀ /00-000-Z ₀ -09	NT-ST35051T15	NT-FTB15

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ISO 513	MATERIAL	HARDNESS HB	ae/DC	JP5530			JP8725			
				min	start	max	min	start	max	
P1 - P2	Free cutting steel and low carbon (ex. 1.0715/9 smn 28/avp, 1.0503/c45)	≤ 200	100%	100	140	180	100	150	200	
			30%	160	200	240	160	210	260	
			10%	220	240	260	220	250	280	
P3 - P4	Medium and high alloy steel (ex. 1.7225/42 CrMo 4, 1.3505/100 Cr 6)	200 ÷ 300	100%	80	120	160	90	130	170	
			30%	120	160	200	130	170	210	
			10%	180	200	220	190	210	230	
P5 - P6	High tensile strength and tool steel (ex. 1.2344/X 40 CrMoV 5 1/ORVAR, Hardox400®)	300 ÷ 400	100%	60	90	120	80	110	140	
			30%	100	130	160	120	150	180	
			10%	140	170	200	160	190	220	
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JP5530			JP9535			
				min	start	max	min	start	max	
P7	Ferritic and martensitic stainless steel (ex. 1.4021/X 20 Cr 13/AISI420)	≤ 200	100%	60	100	140	80	120	160	
			30%	80	130	180	100	150	200	
			10%	100	160	220	120	180	240	
P8	Precipitation hardening stainless steel (ex. 1.4548/X 5 CrNiCuNb 17 4/17-4-PH)	≤ 450	100%				60	90	120	
			30%				70	100	130	
			10%				80	110	140	
M1	Austenitic stainless steel (ex. 1.4305/X 10 CrNiS 18 9/AISI303)	> 200	100%	60	90	120	80	110	140	
			30%	80	120	160	100	140	180	
			10%	100	140	180	120	160	200	
M2 - M3	Austenitic and Duplex stainless steel (ex. 1.4401/X 5 CrNiMo 17 12 2/AISI316)		100%				70	100	130	
			30%				80	110	140	
				90	120	150				
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JU6520						
				min	start	max				
N1	Aluminium alloys ≤ Si 12% (ex. 3.4365/AlZn5.5MgCu/ERGA)		100%	300	400	500				
			30%	400	600	800				
			10%	500	800	1100				
N2	Aluminium alloys Si > 12% (ex. 3.2382/G-AlSi12)		100%	200	250	300				
			30%	300	350	400				
			10%	400	450	500				
ISO 513	MATERIAL	HARDNESS HB	ae/DC	JP9535						
				min	start	max				
S1 - S2 - S3	Fe/Ni/Co based heat resistant alloys (ex. Hastelloy, Inconel 625, Inconel 718)		100%	20	30	40				
			30%	30	40	50				
			10%	40	50	60				
S4 - S5	Titanium alloys (ex. TiAl2Sn4Zr2MoSi)		100%	40	50	60				
			30%	50	60	70				
			10%	60	70	80				

ae: radial depth of cut; DC: milling cutter diameter

Complete workpiece materials p. M1.

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DESIGNATION	ae/Dc	FEED RATE		
		fz (mm)		
		min	start	max
SPMX050204-GP	100%	0.08	0.13	0.18
	30%	0.10	0.16	0.22
	10%	0.12	0.19	0.26
SPMX07T308-GP	100%	0.10	0.16	0.22
	30%	0.12	0.20	0.28
	10%	0.14	0.24	0.34
SPMX090408-GP	100%	0.11	0.19	0.27
	30%	0.14	0.24	0.34
	10%	0.16	0.28	0.40
SPGX050204-AL	100%	0.06	0.10	0.14
	30%	0.08	0.13	0.18
	10%	0.09	0.15	0.21
SPGX07T308-AL	100%	0.08	0.13	0.18
	30%	0.10	0.16	0.22
	10%	0.12	0.19	0.26
SPGX090408-AL	100%	0.10	0.16	0.22
	30%	0.12	0.19	0.26
	10%	0.14	0.23	0.32