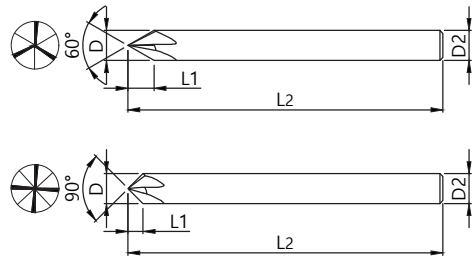


CFT---W

CHAMFER TOOL



- Excellent wear resistance by applied to TiAlN coating
- Reinforcing the tool hardness and the surface roughness by applied to multiple straight type flutes
- Suitable for Chamfering work

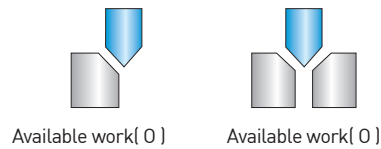


p.550

TOLERANCE

	D	SHANK DIA.
ALL SIZES	+0.01mm	h6

EDP No	D	θ	L ₁	L ₂	D ₂	Z
CFT0660W	6	60°	5.1	50	6	3
CFT0690W	6	90°	3	50	6	3
CFT0860W	8	60°	6.9	60	8	3
CFT0890W	8	90°	4	60	8	3
CFT1060W	10	60°	8.6	70	10	4
CFT1090W	10	90°	5	70	10	4
CFT1260W	12	60°	10.3	75	12	4
CFT1290W	12	90°	6	75	12	4



Applicable Working Material

Carbon Steels ~ HB225	Alloy Steels HB225~325	Prehardened Steels HRc30~50	Heat Treated Steels		Copper	Graphite	Cast Iron ~FCD400, Aluminum 500	Stainless Steels
			SKD61 ~HRc55	SKD11 ~HRc55				
○	○	○			○		○	○

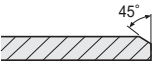
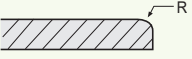
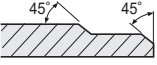
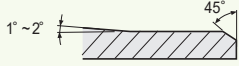
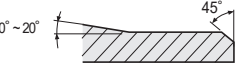
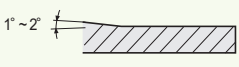
○ : GOOD ◎ : EXCELLENT

[CFT, CCT, CCF series]

▶ Metric

WORKPIECE DIAMETER(mm)	CARBON STEELS		ALLOY STEELS		PREHARDENED STEELS	
	RPM	FEED	RPM	FEED	RPM	FEED
2	3,400-7,000	70-100	2,600-5,200	50-90	2,000-4,000	40-60
3	2,700 - 5,300	60-85	2,100-4,200	45-70	1,600-3,200	35-50
4	2,000 - 4,000	50-70	1,600-3,200	40-55	1,200-2,400	30-40
5	1,700 - 3,400	45-60	1,400-2,600	35-50	1,000-2,000	26-35
6	1,300 - 2,700	40-50	1,100-2,100	30-40	800-1,600	22-30
7	1,150-2,400	35-45	950-1,900	28-37	700-1,400	21-28
8	1,000-2,000	30-40	800-1,600	26-34	600-1,200	20-25
9	900-1,800	30-40	700-1,450	24-32	550-1,100	18-23
10	800-1,600	30-37	600-1,300	23-29	500-1,000	17-22
11	750-1,450	30-37	550-1,200	22-28	450-900	16-21
12	700-1,300	28-35	500-1,100	21-27	400-800	16-20

[The Effect of Chamfer]

TWIST DIRECTION	CHARACTERISTICS
	If the work piece is caught by sharp blade edge, dent occurs on the machined surface. It is applied to chucking reamer, etc.
	Guide edge was rounded. The ground surface is excellent but round machining is difficult and it may deteriorate the machined surface.
	It is 2 blade-type. Chip is produced in 2 stages and it provides good results. But regrinding is difficult.
	The guide part of second stage of cutting edge is 1~2°. Cutting edge blade is long and life is limited. It provides good results on finish machining
	The guide part of second stage is 10~20. It is very economical as the length of blade is short and utilized length is long
	It is used for finish machining. It is applied to hand reamer.

[Recommendation of Cutting Conditions in Reamer]

MATERIAL	WORKPIECE		DIAMETER(mm)	CUTTING CONDITIONS	
	TENSILE STRENGTH(Kg/mm ²)	HARDNESS(HB)		V (m/min)	fn (mm/rev)
CARBON STEELS ALLOY STEELS	~ 100		~10	8 ~ 12	0.15 ~ 0.25
			10~25 25~40		0.20 ~ 0.40 0.30 ~ 0.50
STEEL CASTINGS	100 ~ 140		~10	6 ~ 10	0.12 ~ 0.20
			10~25 25~40		0.15 ~ 0.30 0.20 ~ 0.40
STEEL CASTINGS	40 ~ 50		~10	8 ~ 12	0.15 ~ 0.25
			10~25 25~40		0.20 ~ 0.40 0.30 ~ 0.50
CAST IRON	50 ~ 70		~10	6 ~ 10	0.12 ~ 0.20
			10~25 25~40		0.15 ~ 0.30 0.20 ~ 0.40
CAST IRON	~ 200		~10	8 ~ 15	0.20 ~ 0.30
			10~25 25~40		0.30 ~ 0.50 0.40 ~ 0.70
ALUMINUM ALLOYS	200 ~		~10	6 ~ 12	0.15 ~ 0.25
			10~25 25~40		0.20 ~ 0.40 0.30 ~ 0.50
ALUMINUM ALLOYS			~10	15 ~ 25	0.20 ~ 0.30
			10~25 25~40		20 ~30

[The Effect of Twist Angle]

TWIST DIRECTION	CHARACTERISTICS
Straight blade (twist angle is 0°)	• Surface is generally poor except cast iron.
Right twist blade	• Excellent machinability and easy to discharge chip • Applicable work piece range is wide. • Excellent for high hardness work piece
Left twist blade	• Excellent surface roughness for work piece of aluminium alloys, copper, and copper alloys • It is good for machining soft materials