



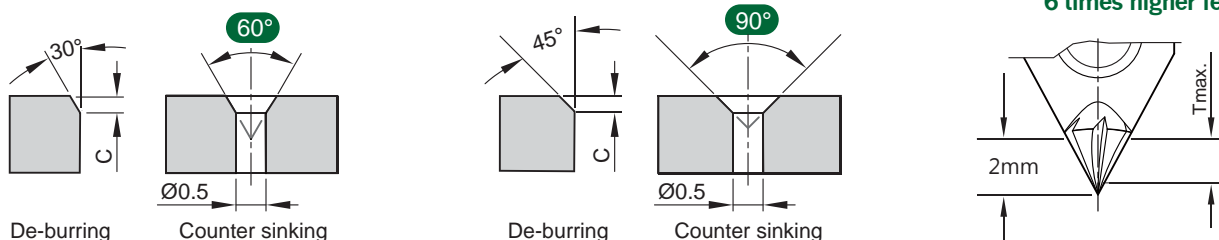
NC De-Burring

Patent Pending

High feed rate for high speed de-burring on CNC machines.
Indexable type ensure the relative position of de-burring.

Insert

- Smallest counter sink diameter $\varnothing 0.5$ mm.
- Ideal for fine hole de-burring.
- Each insert has one cutting edge.
- Using same tool holder of X060 engraving tool.
- Relative position of deburring depth and diameter are accurate.
- TiAlN coated carbide insert can stand very long life.



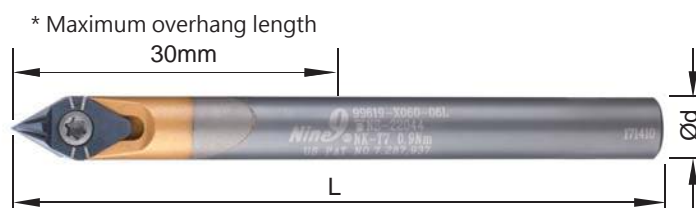
Code	Parts No.	Angle	Grade	Coating	C		Dimensions	T _{max.}
					C _{min.}	C _{max.}		
01X601	X060A60T6-NC2032	60°	K20F	TiAlN	0.1	1.0	L S Re	1.6
01X901	X060A90T6-NC2032	90°	K20F	TiAlN	0.1	1.2	L S Re	1.75

Holder

- ♦ Carbide shank is ground to h6 tolerance.
- ♦ Made of high alloy steel and brazed on a carbide shank. Provides high rigidity and anti-vibration.

Attention:

- ♦ Using high precision tool holder to make sure run out of tool shank is below 0.01 mm.
- ♦ High precision collect chuck, shrink fit chuck and hydraulic chuck are recommended.



Code	Part No.	L	Ød	Screw	Key
69X002	00-99619-X060-06L	60	6	NS-22044 0.9Nm	NK-T7

* For both of X060 engraving and de-burring insert.

Starter Kit

Code	Part No.	Shank Ø	Angle	Insert included	Content
69X202-X601	00-99619-X060-DB60-02K-32	6	60°	X060A60T6-NC2032	1 x Holder 1 x T7 Key 2 x inserts
69X202-X901	00-99619-X060-DB90-03K-32	6	90°	X060A90T6-NC2032	



Cutting Data

Work Material	V _c (m/min)	f (mm/rev.)
P Carbon Steel	100~250	(A _p 0.2~0.5mm) 0.03~0.08
Alloy Steel	80~200	
M Stainless Steel	60~120	(A _p 0.5~1.0mm)
K Cast iron	80~200	0.05~0.12
N Non-Ferrous Metal (Al, Cu)	100~300	(A _p 1.0~1.5mm)
S Ti, Ti-alloy	20~60	0.08~0.20

JIMMORÉ International Corp.

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