

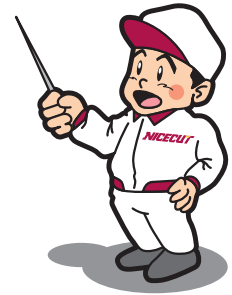
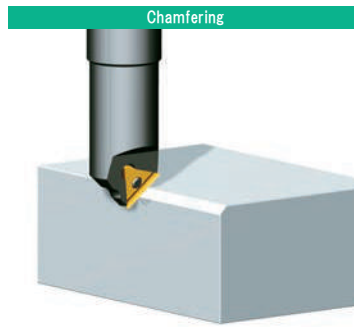
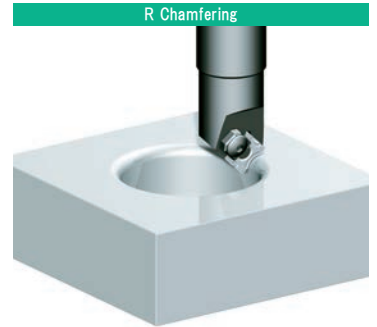
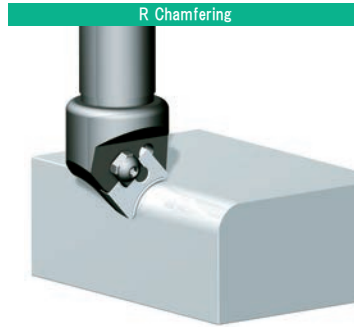
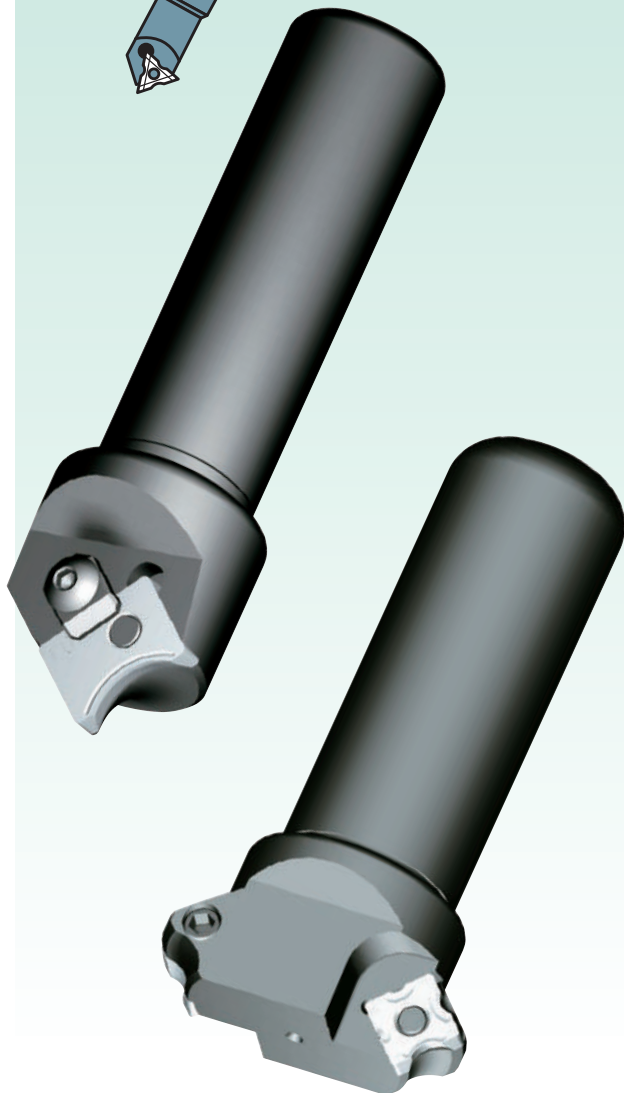
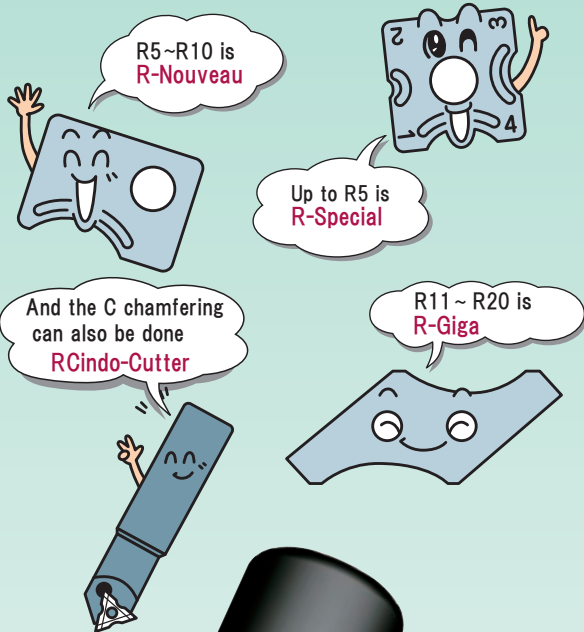
ALCANTARA



Vol.24
PRODUCTS GUIDE

Easy Radius change !!

● Various Radius chamfering can be made by just exchanging Inserts



Processing Example (RCindo-Cutter)

[Periphery R3 Chamfering process]

- Body: CR25-05T
- Insert: T32GSR-3R NK2020
- Material Bakelite
- Rotational speed 4,000r.p.m.
- Table feed 800 / min

Result

Good discharge of chips, surface accuracy also good Results came out.

Processing Example (R-Special Jr.)

[R5 Chamfering process of $\phi 20$ hole Result]

- Body: NK25-05R
- Insert: N43GXR-5R NK2020
- Material S45C
- Rotational speed 2,500r.p.m.
- Table feed 400/min

Result

Surface Accuracy is good when the processing was made without rough cutting

Processing Example (R-Nouveau Jr.)

[Periphery R10 Chamfering process]

- Body: NK25-10R
- Insert: N54GCR-10R NK2020
- Material Aluminum
- Rotational speed 4,000r.p.m.
- Table feed 800/min

Result

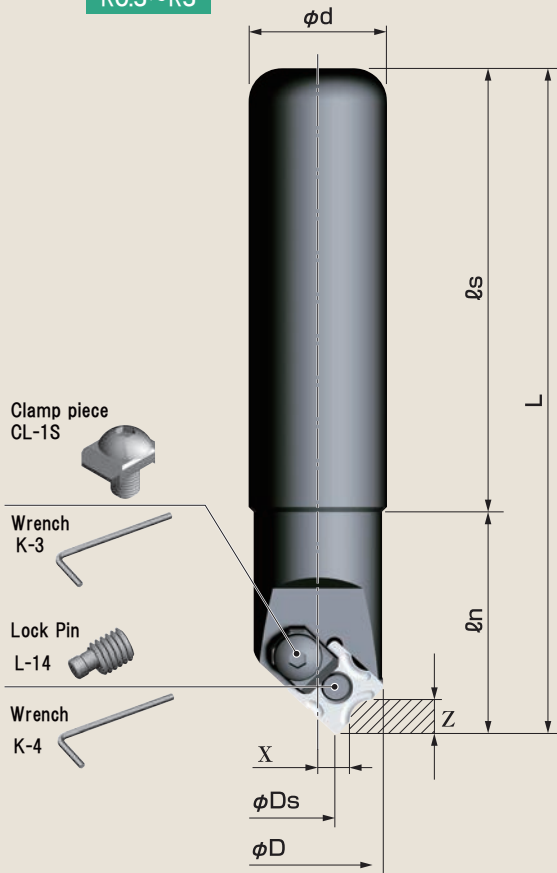
Surface Accuracy is good when the processing was made without rough cutting

⚠ When mounting inserts, please do not take reverse tightening !
 Poor accuracy or breakage of insert may be occurred due to the Eccentricity looking mechanism

1 R-Special Jr.

1Blade

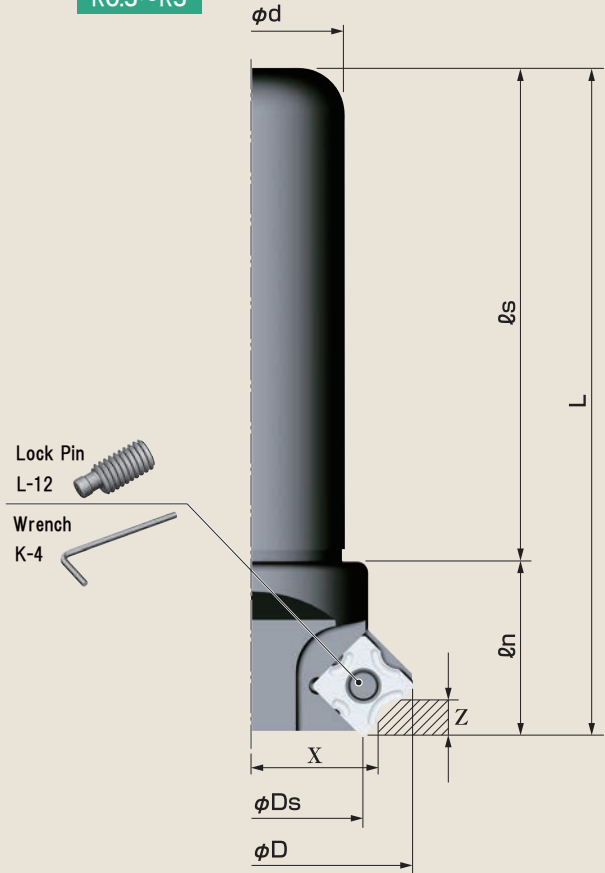
R0.5~R5



2 R-Special

3Blade

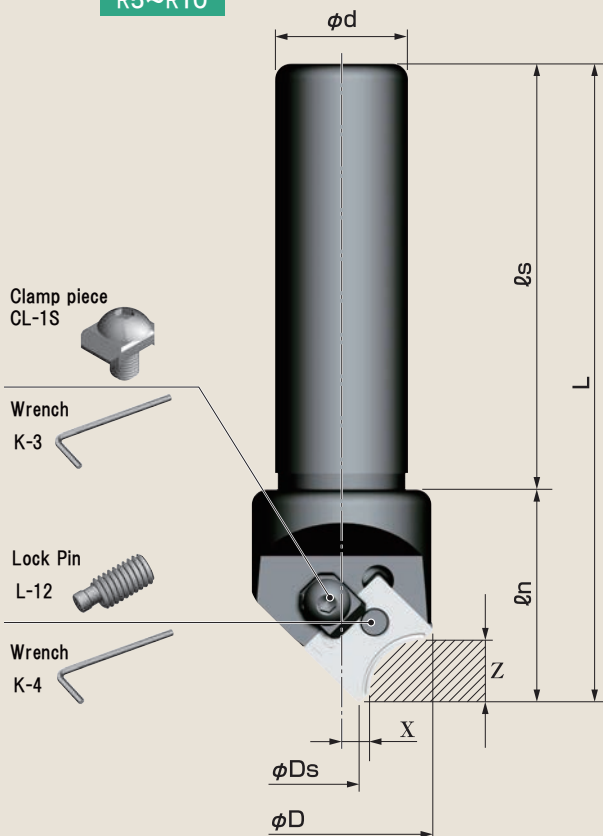
R0.5~R5



3 R-Nouveau Jr.

1Blade

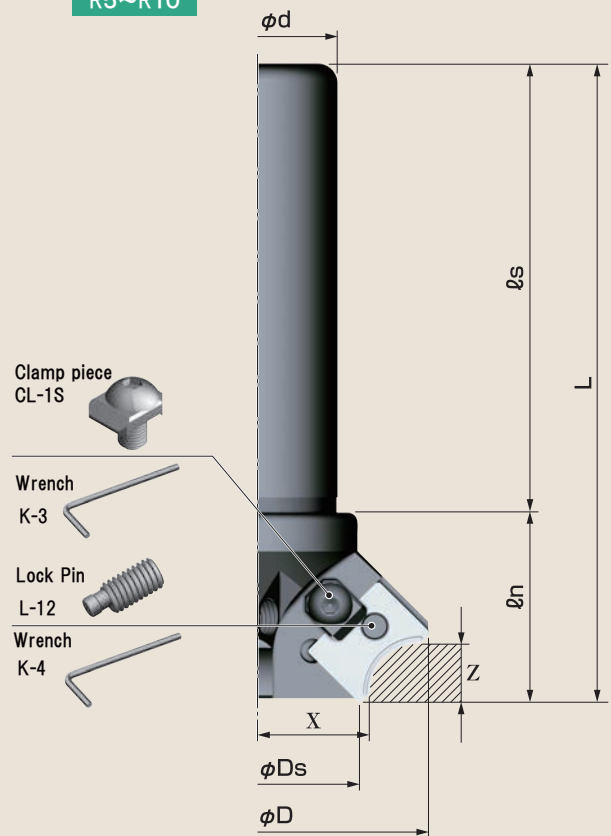
R5~R10



4 R-Nouveau

3Blade

R5~R10

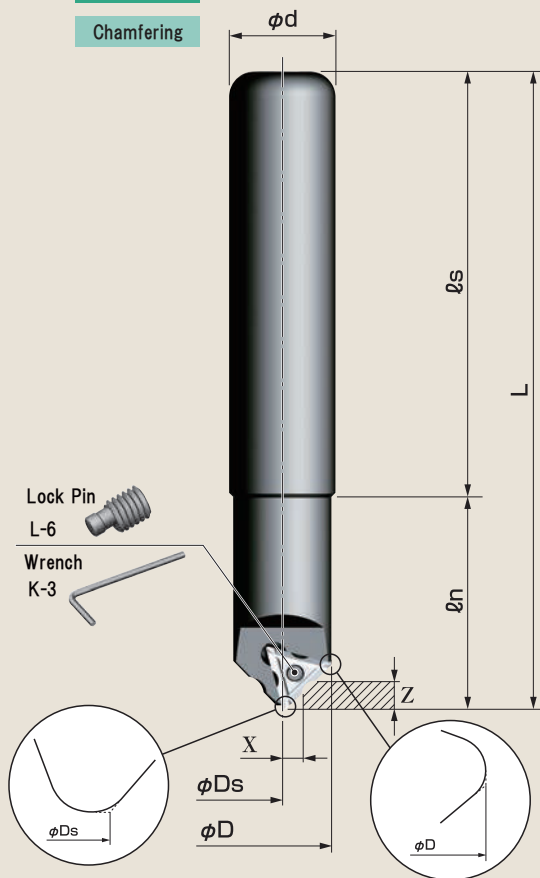


5 RCindo-Cutter

1Blade

R1~R3

Chamfering



6 R-Giga

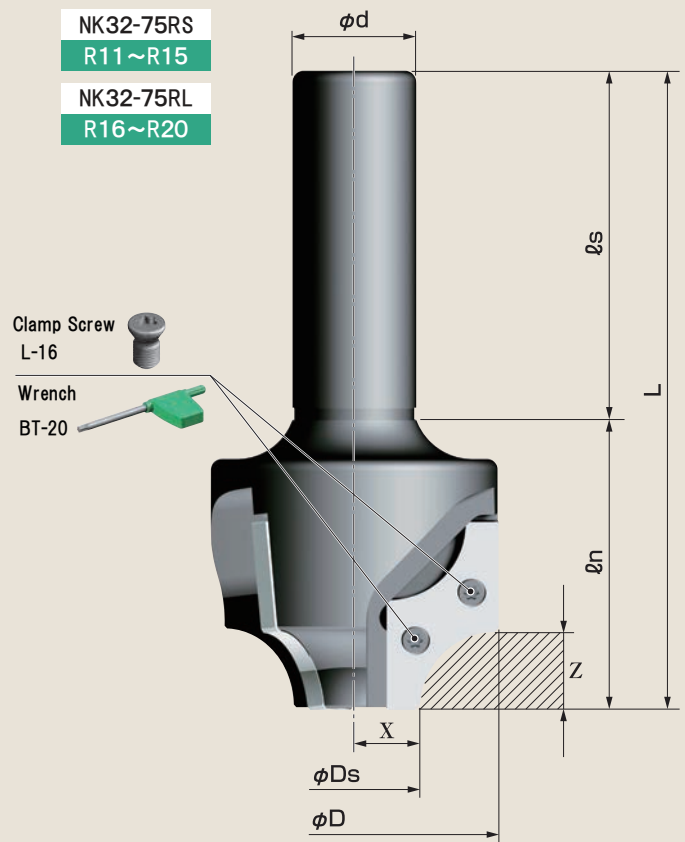
3Blade

NK32-75RS

R11~R15

NK32-75RL

R16~R20

This is not standard production model.
Please check the delivery time when ordering

Body

Product name	Model No.	Fig.	Blades	Dimensions (mm)						Inserts
				ϕD	ϕD_s	ϕd	L	ℓs	ℓn	
R-Special Jr.	NK20-05R	①	1	25	8.4	20	120	80	40	N43GXR
	NK25-05R	①	1	25	8.4	25	120	80	40	N43GXR
R-Special	NK20-40R-3	②	3	56	39.3	20	115	85	30	N43GXR
	NK25-40R-3	②	3	56	39.3	25	115	85	30	N43GXR
	NK32-40R-3	②	3	56	39.3	32	115	85	30	N43GXR
R-Nouveau Jr.	NK20-10R	③	1	35.4	8.9	20	120	80	40	N54GCR
	NK25-10R	③	1	35.4	8.9	25	120	80	40	N54GCR
R-Nouveau	NK25-70R	④	3	69.2	42.3	25	130	90	40	N54GCR
	NK32-70R	④	3	69.2	42.3	32	130	90	40	N54GCR
	NK32-70RL	④	3	69.2	42.3	32	200	150	50	N54GCR
RCindo-Cutter	CR25-05T	⑤	1	25	3.8	25	150	100	50	T32GSR / T32MOR / TT32GUR
R-Giga	NK32-75RS	⑥	3	75.5	35	32	165	90	75	XNEW3004-11R~15R
	NK32-75RL	⑥	.3	75.5	35	32	165	90	75	XNEW3004 16R~20R

※ Inset is not supplied as standard accessory. Please order separately.

※ Clamp screw, lock pin and wrench are supplied as standard accessory.



When mounting insert, please do not take reverse tightening.

Due to the eccentricity looking mechanism, poor accuracy or breakage of insert may be occurred

When replacing insert, please confirm whether you have been taking reserve tightening or not.



Cutting conditions to P.37
Insert details to P.38



※ Please refer to P.18. on C chamfering cutting condition

Cutting Conditions

R-Special Jr./R-Special					R-Nouveau Jr./R-Nouveau			RCindo-Cutter		R-Giga		
N43GXR					N54GCR			T32GSR		XNEW3004		
Material	Material Model	NK2001	NK1010	NK2020	NK6060	Material Model	NK2020	NK6060	Material Model	NK2020	Material Model	NK2020
	Feed Per Blade (fz)	Cutting speed (m / min)				Feed Per Blade (fz)	Cutting Speed (m / min)		Feed Per Blade (fz)	Cutting speed (m / min)	Feed Per Blade (fz)	Cutting Speed (m / min)
General Steel	0.1~0.2	100~250		100~200		0.1~0.3	100~250		0.08~0.2	150~200	0.1~0.3	100~250
Alloy Steel	0.1~0.2	100~250		100~200	150~200	0.1~0.3	100~250	150~250	0.08~0.2	150~200	0.1~0.3	100~250
Stainless Steel	0.1~0.2			80~160	150~200	0.1~0.25	80~160	150~250	0.08~0.2	120~180	0.1~0.25	80~160
Aluminum,Resin,Brass	0.1~0.3		150~300	150~300		0.1~0.3	150~400		0.08~0.3	200~800	0.1~0.3	150~400
Castings	0.1~0.3	80~150 ※FCD	80~150	80~150		0.1~0.3	80~200		0.08~0.2	150~200	0.1~0.3	80~200

- According to the shape of work, clamp condition and large or small chamfering amount, the cutting condition will have to be adjusted.
- Yellow marked condition is recommended for the material listed
- In case of chamfering process of Stainless steel, kindly take down cutting

X-axis - Z-axis position

Example: In the case of R Nouveau Jr.



Setting numerical values

Product name	Processing R	X-axis position (mm)	Z-axis position (mm)
R-Special Jr.	R0.5	8.05	4.42
	R0.75	7.93	4.55
	R1	7.80	4.67
	R1.5	7.55	4.92
	R2	7.30	5.17
	R2.5	7.06	5.42
	R3	6.81	5.67
	R3.5	6.56	5.91
	R4	6.31	6.16
	R4.5	6.06	6.41
R-Special	R5	5.82	6.66
	R0.5	23.54	4.42
	R0.75	23.42	4.54
	R1	23.29	4.66
	R1.5	23.04	4.91
	R2	22.79	5.16
	R2.5	22.54	5.41
	R3	22.29	5.66
	R3.5	22.04	5.91
	R4	21.78	6.16
R-Nouveau Jr.	R4.5	21.53	6.41
	R5	21.28	6.65
	R5	6.00	6.70
	R6	5.41	7.21
	R7	5.64	8.42
	R8	6.00	9.65
R-Nouveau	R9	5.41	10.16
	R10	6.00	11.62
	R5	22.80	6.80
	R6	22.25	7.32
RCindo-Cutter	R7	22.49	8.56
	R8	22.80	9.80
	R9	22.25	10.32
	R10	22.80	11.80
R-Giga	R1	6.40	5.81
	R2	5.90	6.30
	R3	5.40	6.78
	R11	17.50	11.77
	R12	17.50	12.70
	R13	17.50	13.63
	R14	17.50	14.56
	R15	17.50	15.48
	R16	17.50	16.41
	R17	17.50	17.34
R18	17.50	18.27	
R19	17.50	19.20	
R20	17.50	20.12	

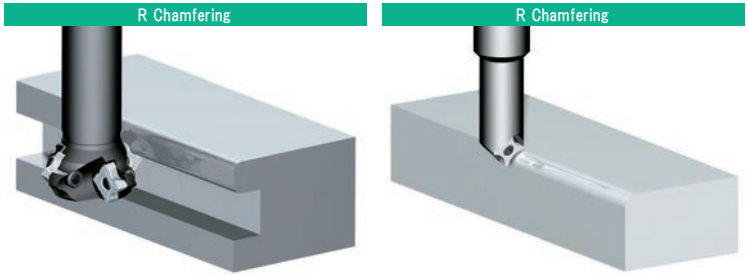
● numeric value might get some errors, please acknowledge.

Insert ※ Please refer to P-18 on C Chamfering cutting condition

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
● R-Special Jr./R-Special/R-Bit Ryanmcut-R(RR25-48N) (N43GXR) (N43GXR Semistandard Insert) ※ R0.5~R3.5 insert can be used for R Bit ※ Semi standard Insert have no breaker	N43GXR NK2001	Cermet	R1·2·3·4	None	4	3/12
	N43GXR NK1010	Carbide K10	R1·2·3·4	None	4	3/12
	N43GXR NK2020	Carbide M20	R1·2·3·4	None	4	3/12
	N43GXR NK6060	Carbide M20	R1·2·3·4	TiAlN	4	3/12
	N43GXR-1R NK2001	Cermet	The Same R Each corner	None	4	3/12
	N43GXR-2R NK2001	Cermet	The Same R Each corner	None	4	3/12
	N43GXR-3R NK2001	Cermet	The Same R Each corner	None	4	3/12
	N43GXR-4R NK2001	Cermet	The Same R Each corner	None	4	3/12
	N43GXR-1R NK2020	Carbide M20	The Same R Each corner	None	4	3/12
	N43GXR-2R NK2020	Carbide M20	The Same R Each corner	None	4	3/12
	N43GXR-3R NK2020	Carbide M20	The Same R Each corner	None	4	3/12
	N43GXR-4R NK2020	Carbide M20	The Same R Each corner	None	4	3/12
	N43GXR-1R NK6060	Carbide M20	The Same R Each corner	TiAlN	4	3/12
	N43GXR-2R NK6060	Carbide M20	The Same R Each corner	TiAlN	4	3/12
	N43GXR-3R NK6060	Carbide M20	The Same R Each corner	TiAlN	4	3/12
	N43GXR-4R NK6060	Carbide M20	The Same R Each corner	TiAlN	4	3/12
	N43GXR-0.5R NK2020	Carbide M20	The Same R Each corner	None	4	3/12
	N43GXR-0.75R NK2020	Carbide M20	The Same R Each corner	None	4	3/12
	N43GXR-1.5R NK2020	Carbide M20	The Same R Each corner	None	4	3/12
	N43GXR-2.5R NK2020	Carbide M20	The Same R Each corner	None	4	3/12
N43GXR-3.5R NK2020	Carbide M20	The Same R Each corner	None	4	3/12	
N43GXR-4.5R NK2020	Carbide M20	The Same R Each corner	None	4	3/12	
N43GXR-5R NK2020	Carbide M20	The Same R Each corner	None	4	3/12	
● R-Nouveau/R-Nouveau Jr./10R-bit (N54GCR) (N54GCR Semistandard Insert) ※ Semi standard Insert have no breaker	N54GCR-5R NK2020	Carbide M20		None	1	3
	N54GCR-8R NK2020	Carbide M20		None	1	3
	N54GCR-10R NK2020	Carbide M20		None	1	3
	N54GCR-5R NK6060	Carbide M20		TiAlN	1	3
	N54GCR-8R NK6060	Carbide M20		TiAlN	1	3
	N54GCR-10R NK6060	Carbide M20		TiAlN	1	3
	N54GCR-6R NK2020	Carbide M20		None	1	3
	N54GCR-7R NK2020	Carbide M20		None	1	3
	N54GCR-9R NK2020	Carbide M20		None	1	3
● RCIndo-Cutter (T32GSR) 	T32GSR-1R NK2020	Carbide M20		None	3	3
	T32GSR-2R NK2020	Carbide M20		None	3	3
	T32GSR-3R NK2020	Carbide M20		None	3	3
● R-Giga (XNEW3004) 	XNEW3004-11R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-12R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-13R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-14R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-15R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-16R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-17R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-18R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-19R NK2020	Carbide M20	Honing edge	None	2	3
	XNEW3004-20R NK2020	Carbide M20	Honing edge	None	2	3

Possible Front / Reverse R-Chamfering and C-Chamfering process !

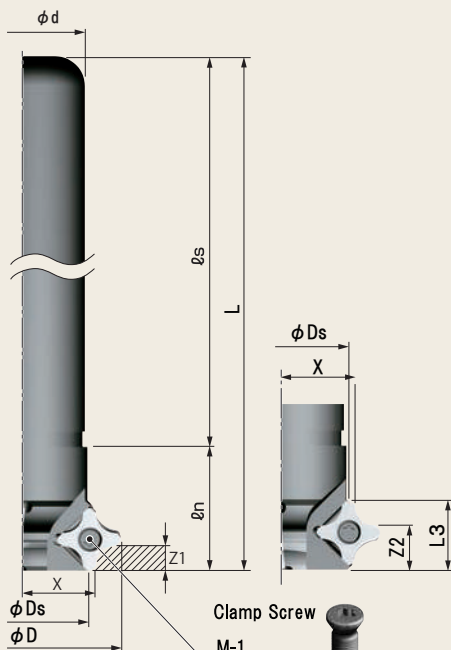
- Reverse and Front Chamfering process ensured by changing insert
※ Mini R is for front only
- 8 corners of inserts can be usable.
※ RR25-48N is 4 corners only



1 Ryanmencut-R (RR16-30S/RR25-40S)

2Blade 4Blade

R1~R5



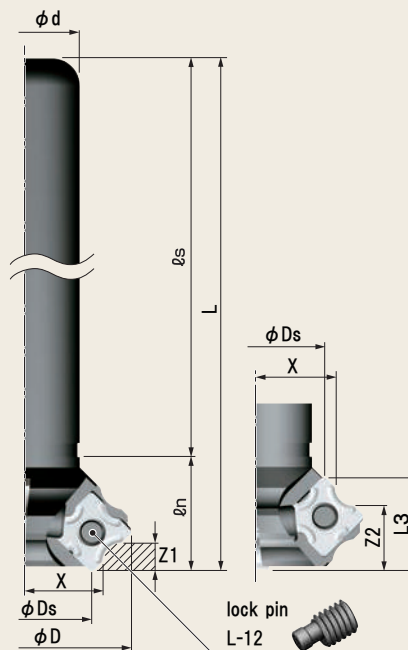
Clamp Screw M-1

Wrench MA-1

2 Ryanmencut-R (RR25-48N)

4Blade

R0.5~R5



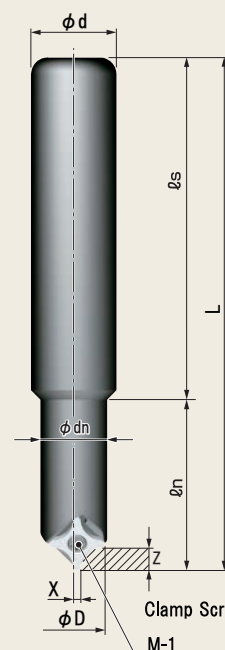
lock pin L-12

Wrench K-4

3 Mini-R (R1~R5)

1Blade

R1~R5



Clamp Screw M-1

Wrench MA-1

Body

Product Name	Model. No.	Fig.	blades	Dimensions (mm)								Inserts
				ϕD	ϕD_s	ϕd	ϕdn	L	ϕs	ϕn	L3	
Ryanmencut-R	RR16-30S-4R	①	2	30	17.9	16		200	175	25	16	SNEQ090308 / S32MOZ / S32GUR
	RR16-30S-5R	①	2	30	17.9	16		200	175	25	16	SNEQ090308 / S32MOZ / S32GUR
	RR25-40S-4R	①	4	40	27.8	25		200	175	25	16	SNEQ090308 / S32MOZ / S32GUR
	RR25-40S-5R	①	4	40	27.8	25		200	175	25	16	SNEQ090308 / S32MOZ / S32GUR
	RR25-48N	②	4	48	31.3	25		200	175	25	20.5	N43GXR / N43MOZ / N43GUR
Mini-R	MR20-16S	③	1	16		20	15.6	120	80	40		SNEQ090308 / S32MOZ / S32GUR

※ Insert is not supplied as standard accessory. Please order separately.
※ Lock pin, clamp screw, and wrench are supplied standard accessories

SNEQ090308- □ The RM, Please use.
SNEQ090308- □ RY, You can not use.

Cutting Conditions

Ryanmencut-R(RR16-30S-RR25-40S) / Mini-R SNEQ090308 / S32MOZ / S32GUR		
Material	Feed per blade (fz)	Cutting speed (m/min)
General Steel	0.05~0.2	100~150
Alloy Steel	0.05~0.2	100~150
Stainless Steel	0.05~0.2	80~120
Aluminum, Resin, Brass	0.08~0.25	150~400
Cast Steel	0.05~0.2	100~150

Ryanmencut-R(RR25-48N) N43GXR / N43MOZ / N43GUR					
Material	Material Model	NK2001	NK1010	NK2020	NK6060
	Feed per blade (fz)	Cutting speed (m/min)			
General Steel	0.1~0.2	100~250		100~200	
Alloy Steel	0.1~0.2	100~250		100~200	150~200
Stainless Steel	0.1~0.2			80~160	150~200
Aluminum, Resin, Brass	0.1~0.3		150~300	150~300	
Cast Steel	0.1~0.3	80~150 ※FCD	80~150	80~150	

- According to the shape, clamp condition and volume of chamfering amount the above cutting condition will have to be adjusted. For large amount chamfering, the rate will have to be reduced
- For Stainless steel processing, please take down cut

Setting numerical values

Ryanmencut-R(RR16-30S-RR25-40S)/ Mini-R									
Model.No.	Processing R	RR16-30S			RR25-40S			MR20-16S	
		X-axis position (mm)	Z1-axis position (mm)	Z2-axis position (mm)	X-axis position (mm)	Z1-axis position (mm)	Z2-axis position (mm)	X-axis position (mm)	Z-axis position (mm)
SNEQ090308-1RM	1R	11.44	3.55	12.45	16.42	3.55	12.45	4.46	3.46
SNEQ090308-2RM	2R	10.94	4.04	11.96	15.92	4.04	11.96	3.99	3.94
SNEQ090308-3RM	3R	10.45	4.54	11.46	15.42	4.54	11.46	3.53	4.43
SNEQ090308-4RM	4R	9.95	5.04	10.96	14.92	5.04	10.96	3.09	4.91
SNEQ090308-5RM	5R	9.46	5.50	10.5	14.42	5.5	10.5	2.67	5.40
SNEQ090308-XRM	1·2·3·4R	See above	See above	See above	See above	See above	See above	Can not be used	Can not be used

Ryanmencut-R(RR25-48N)			
Processing R	RR25-48N		
	X-axis position (mm)	Z1-axis position (mm)	Z2-axis position (mm)
R0.5	19.55	4.42	16.08
R0.75	19.42	4.54	15.96
R1	19.30	4.66	15.84
R1.5	19.05	4.91	15.59
R2	18.80	5.16	15.34
R2.5	18.55	5.41	15.09
R3	18.29	5.66	14.84
R3.5	18.04	5.91	14.59
R4	17.79	6.16	14.34
R4.5	17.54	6.41	14.09
R5	17.29	6.65	13.85

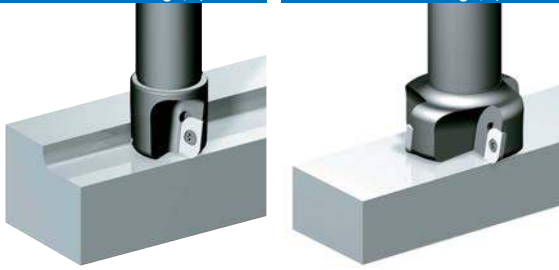
● Numeric value might get some errors, please acknowledge.

Insert Ryanmencut-R(RR16-30S-RR25-40S)/ Mini-R

Fig.	Model.No.	Material	Blade Shape	Coating	Use Corner Number	Number 1 Case Input	
<p>● Ryanmencut-R(RR25-48N)</p> <p>(N43GXR)</p> <p>(N43GXR Semistandard Insert)</p> <p>※ R0.5~R3.5 insert can be used for R Bit ※ Semi standard Insert have no breaker</p>	N43GXR NK2001	Cermet	R1·2·3·4	None	4	3/12	
	N43GXR NK1010	Carbide K10	R1·2·3·4	None	4	3/12	
	N43GXR NK2020	Carbide M20	R1·2·3·4	None	4	3/12	
	N43GXR NK6060	Carbide M20	R1·2·3·4	TiAlN	4	3/12	
	N43GXR-1R NK2001	Cermet	The Same R Each corner	None	4	3/12	
	N43GXR-2R NK2001	Cermet	The Same R Each corner	None	4	3/12	
	N43GXR-3R NK2001	Cermet	The Same R Each corner	None	4	3/12	
	N43GXR-4R NK2001	Cermet	The Same R Each corner	None	4	3/12	
	N43GXR-1R NK2020	Carbide M20	The Same R Each corner	None	4	3/12	
	N43GXR-2R NK2020	Carbide M20	The Same R Each corner	None	4	3/12	
	N43GXR-3R NK2020	Carbide M20	The Same R Each corner	None	4	3/12	
	N43GXR-4R NK2020	Carbide M20	The Same R Each corner	None	4	3/12	
	N43GXR-1R NK6060	Carbide M20	The Same R Each corner	TiAlN	4	3/12	
	N43GXR-2R NK6060	Carbide M20	The Same R Each corner	TiAlN	4	3/12	
	N43GXR-3R NK6060	Carbide M20	The Same R Each corner	TiAlN	4	3/12	
	N43GXR-4R NK6060	Carbide M20	The Same R Each corner	TiAlN	4	3/12	
	<p>● Ryanmencut-R(RR16-30S-RR25-40S)</p> <p>● Mini-R ※ XRM Can not be used</p> <p>(SNEQ090308-□RM)</p> <p>(8 Corner)</p>	SNEQ090308-1RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
		SNEQ090308-2RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
		SNEQ090308-3RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
		SNEQ090308-4RM ZA20N	Carbide M20	The Same R Each corner	None	8	12
SNEQ090308-5RM ZA20N		Carbide M20	The Same R Each corner	None	8	12	
SNEQ090308-XRM ZA20N		Carbide M20	R1·2·3·4	None	8	12	
※ can not be used to mini-R.							
<p>● Ryanmencut-R(RR16-30S-RR25-40S)</p> <p>● Mini-R</p> <p>(S32MOZ)</p> <p>(Except nose R)</p> <p>(S32GUR)</p> <p>(Except nose R)</p>		S32MOZ NK2001	Cermet	Honing edge	None	8	12
		S32MOZ NK2050	Cermet	Honing edge	None	8	12
		NEW S32MOZ AB01F	Cermet	Honing edge	AlCrN	8	12
	S32MOZ NK1010	Carbide K10	Sharp edge	None	8	12	
	S32MOZ NK2020	Carbide M20	Honing edge	None	8	12	
	S32MOZ NK3030	Carbide M20	Honing edge	TiN	8	12	
	S32MOZ NK6060	Carbide M20	Honing edge	TiAlN	8	12	
	S32MOZ AC15T	Fine particles Carbide	Honing edge	AlCrN	8	12	
	S32GUR NK2001	Cermet	Honing edge	None	8	12	
	S32GUR NK1010	Carbide K10	Sharp edge	None	8	12	
S32GUR NK2020	Carbide M20	Honing edge	None	8	12		
S32GUR NK3030	Carbide M20	Honing edge	TiN	8	12		
S32GUR NK5050	Carbide K10	Sharp edge	TiN	8	12		
S32GUR NK6060	Carbide M20	Honing edge	TiAlN	8	12		
S32GUR NK8080	Carbide K10	Sharp edge	TiAlN	8	12		

Shoulder Milling (R)

Shoulder Milling (R)



R0.5~R5
Sumicco

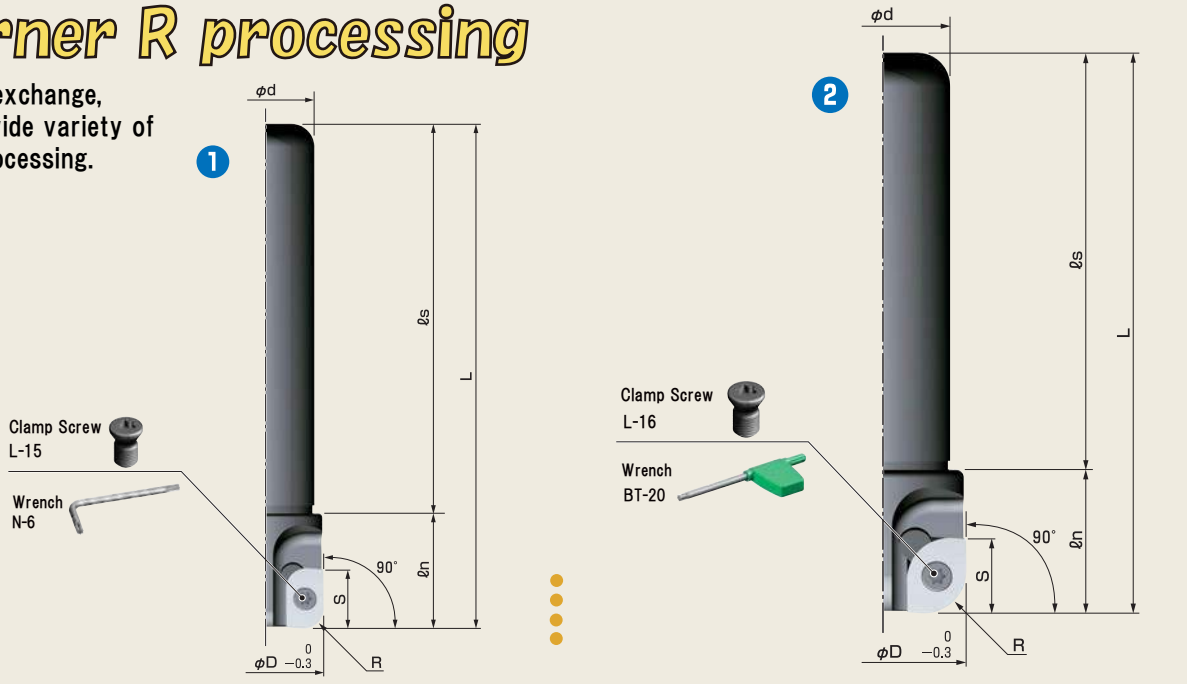


R5~R10
Dekasumi



!! Corner R processing

- by the chip exchange, It allows a wide variety of Corner R processing.



Body

Product name	Model No.	Fig.	blades	Dimensions (mm)						Inserts	Weight (g)
				φD	φd	L	ℓs	ℓn	S		
Sumicco	SK25-30ASR	①	2	30	25	130	100	30	15	A52GNR-0.5 R~2.5R	478
	SK25-30ASRL	①	2	30	25	200	170	30	15	A52GNR-0.5 R~2.5R	748
	SK25-30ALR	①	2	30	25	130	100	30	15	A52GNR-2.5 R~5R	474
	SK25-30ALRL	①	2	30	25	200	170	30	15	A52GNR-2.5 R~5R	746
	SK32-60ASR	①	4	60	32	105	80	25	15	A52GNR-0.5 R~2.5R	798
	SK32-60ASRL	①	4	60	32	175	150	25	15	A52GNR-0.5 R~2.5R	1,240
	SK32-60ALR	①	4	60	32	105	80	25	15	A52GNR-2.5 R~5R	784
	SK32-60ALRL	①	4	60	32	175	150	25	15	A52GNR-2.5 R~5R	1,240
	SK32-80ASR	①	4	80	32	105	80	25	15	A52GNR-0.5 R~2.5R	1,100
	SK32-80ASRL	①	4	80	32	175	150	25	15	A52GNR-0.5 R~2.5R	1,560
	SK32-80ALR	①	4	80	32	105	80	25	15	A52GNR-2.5 R~5R	1,120
SK32-80ALRL	①	4	80	32	175	150	25	15	A52GNR-2.5 R~5R	1,550	
Dekasumi	DC32-40ASR	②	2	40	32	135.0	100	35.0	18.1	ADEW19T3-5R~7R	820
	DC32-40ASRL	②	2	40	32	185.0	150	35.0	18.1	ADEW19T3-5R~7R	1,140
	DC32-40ALR	②	2	40	32	134.6	100	34.6	17.6	ADEW19T3-8R~10R	813
	DC32-40ALRL	②	2	40	32	184.6	150	34.6	17.6	ADEW19T3-8R~10R	1,140

※ Insert is not equipped as standard accessories. Please order separately
 ※ Clamp screw, and wrench are supplied as standard accessories

Cutting Conditions

Material	Sumicco		
	Material Model	NK1010	NK2020
General Steel	Feed per blade (fz)	Cutting speed (m / min)	
Alloy Steel	0.1~0.2	100~150	
Stainless Steel	0.1~0.2	80~120	
Aluminum, Resin,	0.1~0.3	250~600	
Castings	0.1~0.2	80~150	

Material	Dekasumi			
	Material Model	NK1010	NK2020	NK6060
General Steel	Feed per blade (fz)	Cutting speed (m / min)		
Alloy Steel	0.1~0.2	100~150		
Stainless Steel	0.1~0.2	80~120		
Aluminum, Resin,	0.1~0.3	250~600		
Castings	0.1~0.2	80~150		

● Work shape, clamping state, tool protrusion length, please adjust the conditions by cutting amount
 ● You have been to the workpiece by recommended Insert.

● Work shape, clamping state, tool protrusion length, please adjust the conditions by cutting amount
 ● You have been to the workpiece by recommended Insert.

φ 30
φ 60
φ 80
Sumicco

φ 40
Dekasumi

2Blade
Sumicco
Dekasumi

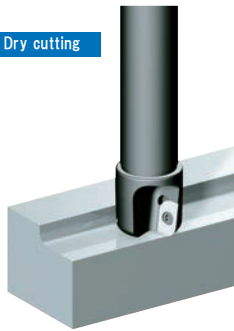
4Blade
Sumicco

Processing Example Sumicco

[Shoulder Milling (R3)]

- Body : SK25-30ALR
- Insert : A52GNR-3R NK2020
- Material.....SKD11
- Work length.....200mm
- Rotation Speed...1,600r.p.m
- Feed (X-axis)....320mm/min
- Down cut air blow
- Cutting Oil....None

Dry cutting



Result

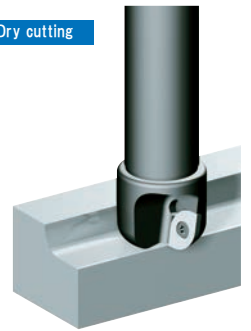
Good!
No secondary burrs and
no chattering process

Processing Example Dekasumi

[Shoulder Milling (R10)]

- Body : DC32-40ALR
- Insert : ADEW 19T3-R NK2020
- Material.....S50C
- Rotation Speed...1,500r.p.m
- Feed (X-axis)....450mm/min
- Cutting Depth....11mm
- Cutting Oil....None

Dry cutting



Result

Good!
No secondary burrs and
no chattering process

⚠ Cautions



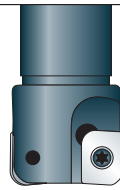
Sumicco

ASR Type(R0.5~R2.5)



Sumicco

ALR Type(R2.5~R5)



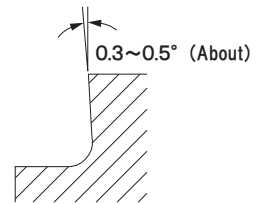
Dekasumi

ASR Type(R5~R7)



Dekasumi

ALR Type(R8~R10)



(Sumicco-Dekasumi are common.)

● Please choose the body to match the Insert to be used.

● The peripheral cutting edge have about 0.3~0.5° back taper (Sumicco and Dekasumi are same)

Insert

Fig.	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box																						
Sumicco ※ R0.5 l stocks in size. (A52GNR) 	A52GNR-0.5R NK1010	Carbide K10	Sharp edge	None	2	12																						
	A52GNR-1R NK1010																											
	A52GNR-1.5R NK1010																											
	A52GNR-2R NK1010																											
	A52GNR-2.5R NK1010																											
	A52GNR-3R NK1010																											
	A52GNR-3.5R NK1010																											
	A52GNR-4R NK1010																											
	A52GNR-4.5R NK1010																											
	A52GNR-5R NK1010																											
Sumicco Blade length of the Insert (l except nose R) <table border="1"> <thead> <tr> <th>Model.No.</th> <th>A</th> </tr> </thead> <tbody> <tr><td>0.5R</td><td>15</td></tr> <tr><td>1R</td><td>14.4</td></tr> <tr><td>1.5R</td><td>13.9</td></tr> <tr><td>2R</td><td>13.3</td></tr> <tr><td>2.5R</td><td>12.8</td></tr> <tr><td>3R</td><td>12.2</td></tr> <tr><td>3.5R</td><td>11.7</td></tr> <tr><td>4R</td><td>11.1</td></tr> <tr><td>4.5R</td><td>10.5</td></tr> <tr><td>5R</td><td>10</td></tr> </tbody> </table>	Model.No.	A	0.5R	15	1R	14.4	1.5R	13.9	2R	13.3	2.5R	12.8	3R	12.2	3.5R	11.7	4R	11.1	4.5R	10.5	5R	10	A52GNR-0.5R NK2020	Carbide M20	Honing edge	None	2	12
	Model.No.	A																										
	0.5R	15																										
	1R	14.4																										
	1.5R	13.9																										
	2R	13.3																										
	2.5R	12.8																										
	3R	12.2																										
	3.5R	11.7																										
	4R	11.1																										
4.5R	10.5																											
5R	10																											
A52GNR-1R NK2020																												
A52GNR-1.5R NK2020																												
A52GNR-2R NK2020																												
A52GNR-2.5R NK2020																												
A52GNR-3R NK2020																												
A52GNR-3.5R NK2020																												
A52GNR-4R NK2020																												
A52GNR-4.5R NK2020																												
A52GNR-5R NK2020																												
Dekasumi ※ R1 l stocks in size. (ADEW19T3) 	ADEW19T3-5R NK1010	Carbide K10	Sharp edge	None	2	4																						
	ADEW19T3-6R NK1010																											
	ADEW19T3-7R NK1010																											
	ADEW19T3-8R NK1010																											
	ADEW19T3-9R NK1010																											
	ADEW19T3-10R NK1010																											
	ADEW19T3-5R NK2020						Carbide M20	Honing edge	None	2	4																	
	ADEW19T3-6R NK2020																											
	ADEW19T3-7R NK2020																											
	ADEW19T3-8R NK2020																											
ADEW19T3-9R NK2020																												
ADEW19T3-10R NK2020																												
ADEW19T3-5R NK6060	Carbide M20	Honing edge	TiAlN	2	4																							
ADEW19T3-6R NK6060																												
ADEW19T3-7R NK6060																												
ADEW19T3-8R NK6060																												
ADEW19T3-9R NK6060																												
ADEW19T3-10R NK6060																												

Product Number notation example simple order

- ① Base Aluminum Body
- ② Processing diameter $\phi 200\text{mm}$
- ③ Blades 6Blade
- ④ Arm NS type
- ⑤ Base Color RED

In the case of, please notation as described below with reference to the ①~⑤ of "Easy Order" below.

- ① Base
- ② Processing diameter
- ③ Blades
- ④ Arm
- ⑤ Base color



Product model number, "KK200-6NS-RD ※ This item only We will stock. It will be."

※ In the case of base only, please put the last A product model number.

① Base : Please choose the body type.

Model number notation ①..... Steel Body is "NK", aluminum body will be "KK".

Steel Body (NK type)	Aluminum body (KK type)
It's more commonly used for is, it will be the low-cost steel body.	It weighs 1/3 compared to steel cutters and are available at lower horsepower machines Aluminum body type.

② Processing diameter (ϕ): Please choose the processing diameter from between the $\phi 120\sim 500$.

Model number notation ②..... It will be 120-500.

③ Blade number : Please choose the number of blade from the 3-36 sheets.

※ blade number you can send quickly a lot made and feed speed.

Model number notation ③..... It will be 3-36.

④ Arm : Please choose the Arm type.

Model number notation ④..... It becomes the "NS" or "PS" or "NT".

NS type	PS type	NT type
FujiGen chattering is hardly out by its own negative-positive method, it can be a good cut into thin processing. Insert both sides is possible economic use of the "face processing Negachippu" is → [S type]	The "face processing Pojichippu" that enables optimum cutting in stainless by new materials and coating Inserts → [P Type]	The "shoulder processing" and → [T type]

⑤ Base Color: Please choose only the aluminum Body Color.

※ Steel body color is only black.



Model number notation ⑤..... Steel Body is "BK"
Aluminum body will be "GL" or "SV" or "RD" or "BL" or "BK".

According to the machining and the size of the customer's necessity will be provided!

Conventional nice cut series that had been our patronage (arbor type)
It becomes the order system, now that it can be widely available.

A combination of the diameter and number of blades
You can order We wish you the customer. According to the machining and the
size of the customer's necessity will be provided!

Weight Table

Steel Body					
Body type	Steel Body				
Cutter diameter	φ 120~φ 140	φ 150~φ 190	φ 200~φ 240	φ 250~φ 290	φ 300~φ 340
Cutter height (L)	45		60		70
Arbor diameter	25.4		38.1	50.8	47.625
Number of blades					
3	2.6kg	7.1kg	11.2kg	19.3kg	28.7kg
4	2.6kg	7.1kg	11.2kg	19.4kg	28.7kg
5	2.6kg	7.1kg	11.2kg	19.4kg	28.7kg
6	2.6kg	7.1kg	11.3kg	19.4kg	28.7kg
7	2.6kg	7.1kg	11.3kg	19.4kg	28.7kg
8	2.6kg	7.1kg	11.3kg	19.4kg	28.8kg
9	2.7kg	7.1kg	11.3kg	19.4kg	28.8kg
10		7.1kg	11.3kg	19.4kg	28.8kg
11		7.1kg	11.3kg	19.4kg	28.8kg
12		7.2kg	11.3kg	19.5kg	28.8kg
13			11.3kg	19.5kg	28.8kg
14			11.4kg	19.5kg	28.8kg
15			11.4kg	19.5kg	28.8kg
16				19.5kg	28.8kg
17				19.5kg	28.9kg
18				19.5kg	28.9kg
19				19.5kg	28.9kg
20				19.6kg	28.9kg
21				19.6kg	28.9kg
22					28.9kg
23					28.9kg
24					28.9kg

Aluminum body					
Body type	Aluminum body				
Cutter diameter	φ 120~φ 140	φ 150~φ 190	φ 200~φ 240	φ 250~φ 290	φ 300~φ 340
Cutter height (L)	45		60		70
Arbor diameter	25.4		38.1	50.8	47.625
Number of blades					
3	1.0kg	2.6kg	4.1kg	7.0kg	10.4kg
4	1.1kg	2.7kg	4.1kg	7.1kg	10.4kg
5	1.1kg	2.7kg	4.2kg	7.1kg	10.5kg
6	1.1kg	2.7kg	4.2kg	7.1kg	10.5kg
7	1.2kg	2.8kg	4.2kg	7.2kg	10.5kg
8	1.2kg	2.8kg	4.3kg	7.2kg	10.6kg
9	1.2kg	2.8kg	4.3kg	7.2kg	10.6kg
10		2.9kg	4.3kg	7.3kg	10.6kg
11		2.9kg	4.4kg	7.3kg	10.6kg
12		2.9kg	4.4kg	7.3kg	10.7kg
13			4.4kg	7.4kg	10.7kg
14			4.5kg	7.4kg	10.7kg
15			4.5kg	7.4kg	10.8kg
16				7.5kg	10.8kg
17				7.5kg	10.8kg
18				7.5kg	10.9kg
19				7.6kg	10.9kg
20				7.6kg	10.9kg
21				7.6kg	11.0kg
22					11.0kg
23					11.0kg
24					11.1kg

※Cutter diameter, it will can offer to φ 10 unit.

※Cutter diameter φ 350 more Arbor size and other will necessary separately estimates.

※Arbor diameter, it is determined by the cutter diameter, the Company in accordance with the face mill arbor A type.

※ Depending on the cutter diameter, there are times when it is not possible to put a Number of blades of hope.

※ If you have any questions, please feel free to contact us. TEL. (06) 6911-3588



- can not be canceled after your order, please understand.
- for non-standard products, made to order products. Delivery times, each time please verify.



Cutting conditions to P.50
Insert for more information to P.51



<http://www.nicecut.co.jp/>

Resellers

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