



Chamfering holder for small diameter
cross holes

NX Holder and diagonal holes Holder H Type



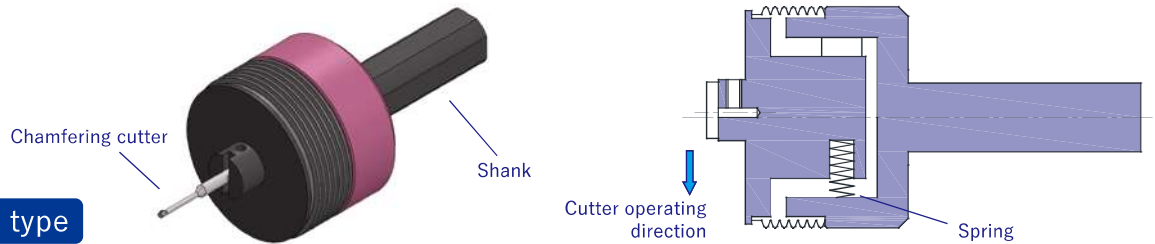
- ◆ Possible processed from both shaft hole and crossing holes
- ◆ Tool insertion is $\Phi 2.0\text{mm}$ ~, backside hole is $\Phi 0.1\text{mm}$ ~ target.
- ◆ Processing by rotating either target material or the holder
- ◆ A simple program that just moves the holder to the specified position
- ◆ There is a mechanism that the cutter follows the opening shape, so there is no required for tool compensation.

KREUZ Co.,LTD.

Chamfering cutter chases the shape

Deburring process is completed by passing through the processed part with holder which is inserted with the holder shaft and the center of the hole aligned while rotating holder or target material it self.

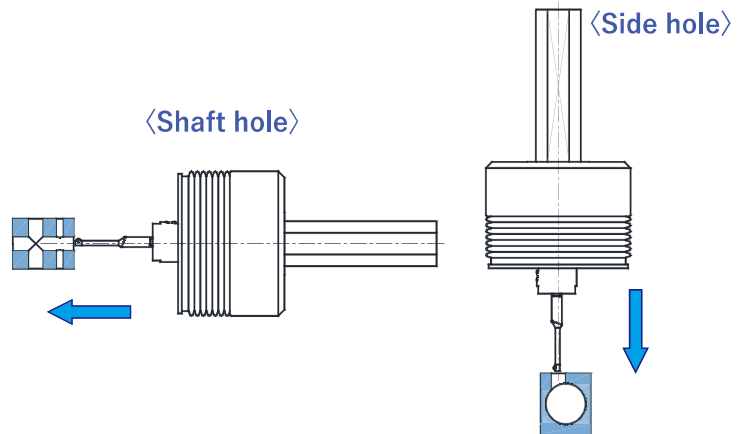
The cutter has a mechanism that always operates toward the center of the insertion hole, and even if there is a slight deviation in the hole position, chamfering is performed according to the shape of the opening.



NX Holder H type

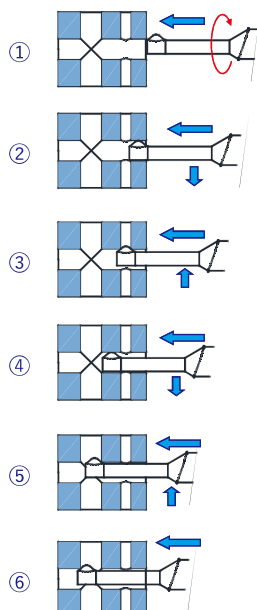
There are two types of approaching directions

There are two types of approaching directions. This can be used by rotating target work in NC lath and rotating tool in machining center and tapping machine.

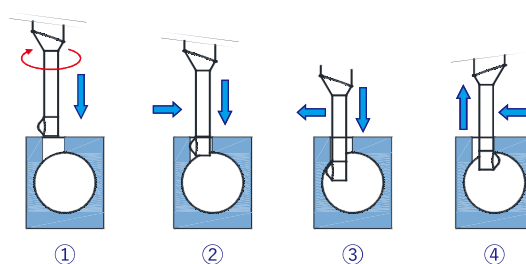


Easy program that let cutter pass through

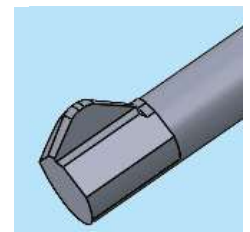
〈Processed from the shaft hole side〉



〈Processed from the side hole side〉



〈Blade enlargement〉



Deburring is completed simply by passing the processing part while rotating the chuck or tool spindle.

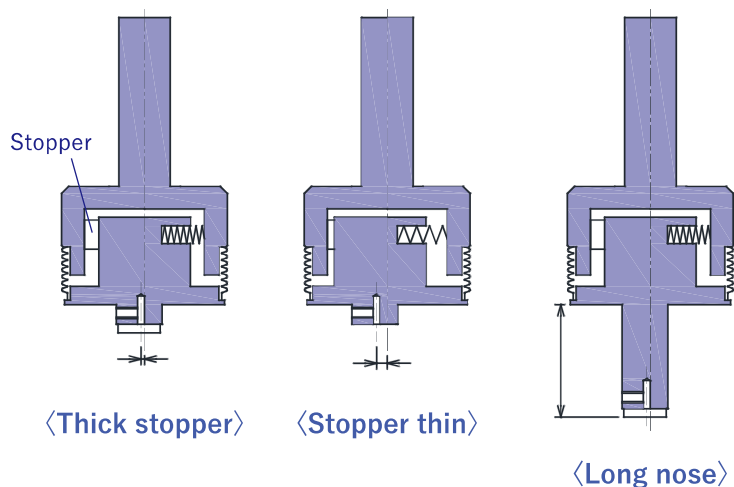
Depending on the opening shape of the machined part, 〈forward rotation only〉 or 〈forward rotation / ATC operation / reverse rotation〉 is required.

The cutter has a flank shape with a guide so that entrance or inner diameter surface are not scratched when inserted.

Tool insertion hole diameter is $\Phi 2.0\text{mm}$ ~

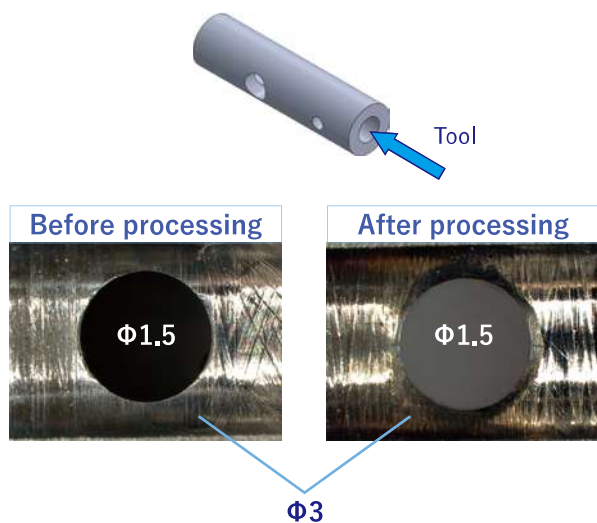
The minimum diameter of the insertion hole is $\Phi 2.0\text{ mm}$ in both the horizontal hole and shaft hole of machining directions, and the horizontal hole diameter when machining from the shaft hole is less than or equal to the insertion hole diameter. The chamfer cutter is specially designed according to the opening shape, depth, etc.,. It is available up to $\Phi 10$ by changing holder stopper and offset amount

It is also possible to change the shape of the tool attached area as a countermeasure against interference with jigs.

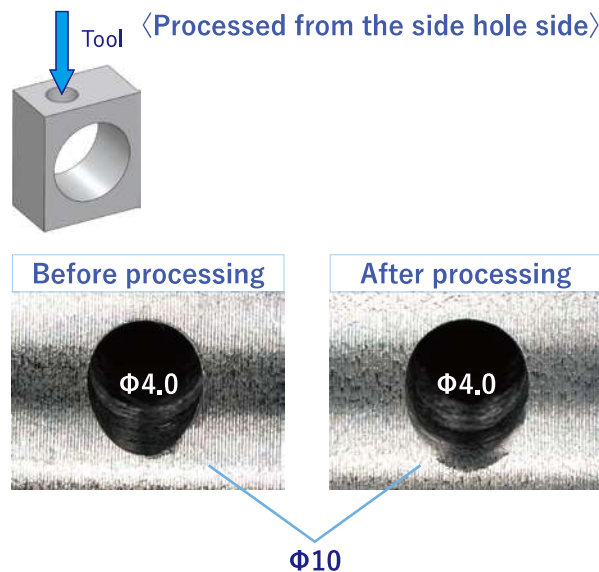


Processing example

〈Processed from the shaft hole side〉



〈Processed from the side hole side〉



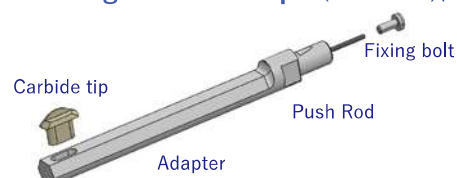
The chamfering cutter is specially designed according to the processing location.

- All chamfering cutters are specially designed to accommodate areas that the shape of the opening is not even, like a hole of the dlane board.
- Chamfering cutters for small diameters are manufactured from solid carbide. If the hole diameter is $\Phi 5$ or more, it will be a throw-away method using a carbide tip. It is easy to attach with holder by only changing screw.

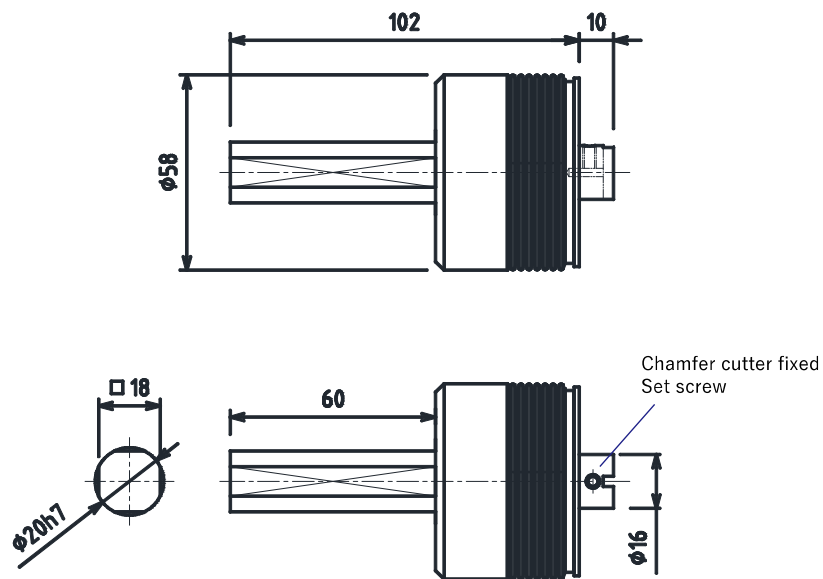
〈Chamfering cutter example($\Phi 3$ hole)〉



〈Chamfering cutter example($\Phi 6$ hole)〉



External view



The mounting shaft diameter of the chamfer cutter is $\Phi 4$ for small diameters and $\Phi 6$ for throwaway types.

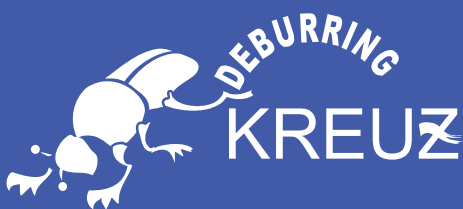
Attention

【About processing】

Depending on the shape of the cross hole, only forward rotation or forward / reverse rotation processing is required.
Please contact us for details.

【Recommended conditions of use】

- Recommended conditions of use
- Rotation feed: 0.1mm/rev or less



KREUZ Co.,Ltd

102-7 Jindoike, Noda-cho, Kariya, Aichi, 444-0803 JAPAN
TEL:+81-566-22-5263 FAX:+81-566-25-3339

※All rights reserved. 2021 KREUZ Co.,Ltd.
※Tool specifications are subject to change without notice.