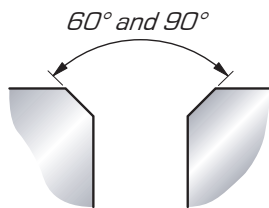
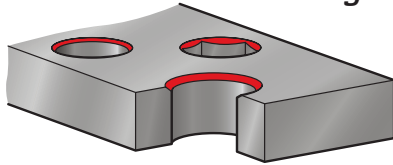


Inner compact Devices

Chamfers any cylindrical, polygonal, or interrupted hole edges at 90°.



SLIM LINE
compact devices



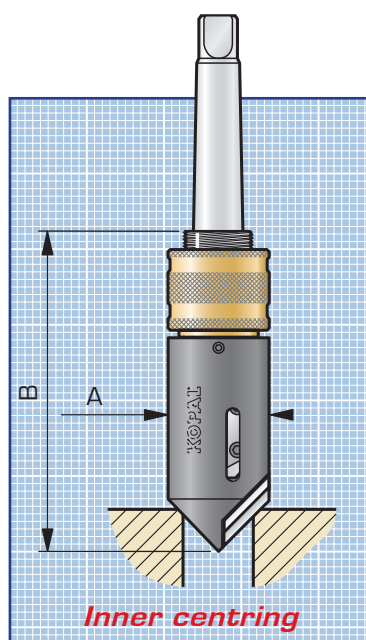
Inner Devices - SLIM LINE

Without cutting blade ⚠

Hole diameter to chamfer	Model	Attach.	A	B 60°/90°
4 to 17	2 - 18	Ø 10 6 WS 6.35	Ø 19.5	78/68
11 to 30	10 - 30	MK 1 MK 2 Ø 12	Ø 32	112/100
5 to 40	4 - 42	MK 2 Weldon Ø 20 Ø 12.7	Ø 44	135

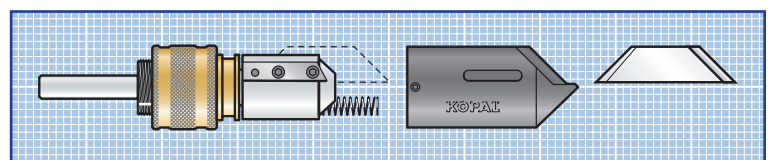
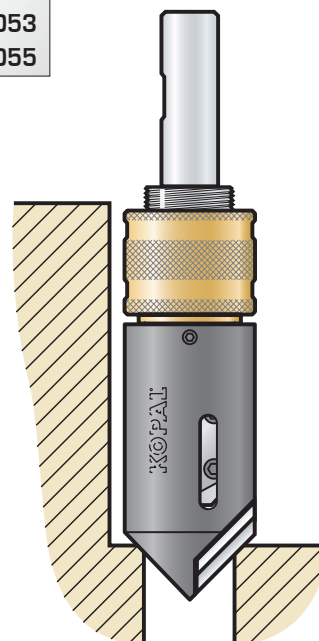
Standard

60° Ref.	90° Ref.
03-015	03-010 03-011
03-035	03-020
03-036	03-021
03-040	03-025
	03-051
	03-053
	03-055



HSS blades
0°, 14°, 20° and
25° cutting angle

Carbide blade
0° cutting angle

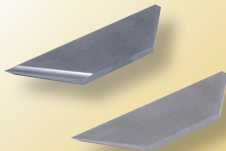


Inner compact Devices

Cutting blades

● **HSS blade - 0° to 25°**
for most usual materials

● **Carbide blade - 0°**
for hard materials



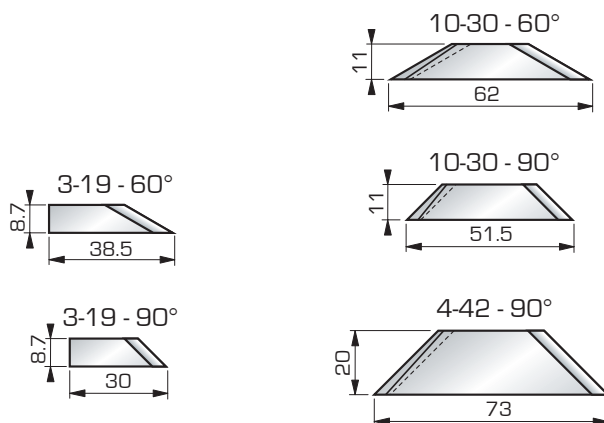
Blade for inner chamfering device *Slim Line*

0° cutting angle for devices :	Ch.60° HSS	Ch.90° HSS	Ch.90° Carbide
3 - 19	03-312	03-322	
10 - 30	03-302	03-321	
4 - 42		03-352	01-351

14° cutting angle for devices :	Ch.60° HSS	Ch.90° HSS
3 - 19	03-310	03-320
10 - 30	03-305	03-300
4 - 42		03-350

20° cutting angle for devices :	Ch.60° HSS	Ch.90° HSS
3 - 19	03-313	03-323
10 - 30	03-308	03-328
4 - 42		03-358

25° cutting angle for devices :	Ch.60° HSS	Ch.90° HSS
3 - 19	03-314	03-324
10 - 30	03-309	03-329
4 - 42		03-359



Lubricate with cutting fluid or soluble oil to ensure long life for the blade's cutting edge and slow down erosion of the pilot cone.

Recommended cutting speed

between 10 and 20 m/min.

exemple : Ø 10 mm	320 to 640 rpm
Ø 15 mm	210 to 420 rpm
Ø 20 mm	160 to 320 rpm
Ø 30 mm	110 to 220 rpm
Ø 40 mm	80 to 160 rpm
Ø 60 mm	55 to 110 rpm

$$Rpm = \frac{\text{cutting speed} \times 1000}{\text{Diameter} \times 3.14}$$

Material	Brass Bronze Cast iron Heat-resistant stainless steel	Steel Special bronze Perspex	Soft steel Copper AU 4 G Plastic Stainless steel	Aluminium Soft iron Sheet metal
Cutting angle	0° HSS Carbure	14° HSS	20° HSS	25° HSS