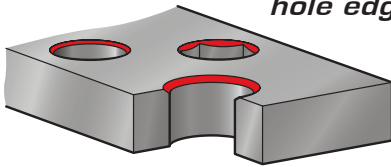
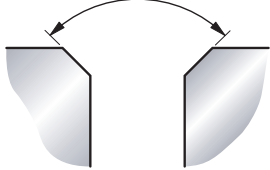


Inner Devices

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



60°, 82°, 90° and 120°



Inner Devices

Without cutting blade ⚠

Hole diameter to chamfer	Model	Attach.	A	B	C 60°/90°	Type of cone pilot					
						Standard	CRN		Standard		
						60° Ref.	90° Ref.	60° Ref.	90° Ref.	82° Ref.	120° Ref.
4 to 17	2 - 18	Ø 10 MK 1	Ø 18	Ø 26	64/55	01-030 01-035	01-010 01-015	1W030B 1W035B	1W010B 1W015B	01-050	01-080
5 to 41	2 - 42	Ø 10/16	Ø 42	Ø 65	108/85	01-120	01-095	1W120B	1W095B	01-150	01-191
		Ø 12.7				01-125	01-100	1W125B	1W100B		
		MK 1				01-115	01-090	1W115B	1W090B		
		MK 2				01-116	01-091	1W116B	1W091B		
		MK 3				01-117	01-092	1W117B	1W092B		
		weldon Ø19					01-093				
21 to 59	20 - 60	MK 2	Ø 60	Ø 70	106/94	01-215	01-210				
42 to 77	40 - 80	MK 2	Ø 80	Ø 90	114/100	01-230	01-225				
		MK 3				01-231	01-226				
62 to 97	60 - 100	MK 3	Ø 100	Ø 110	104		01-241				
82 to 117	80 - 120	MK 3	Ø 120	Ø 130	104		01-256				

HSS blades

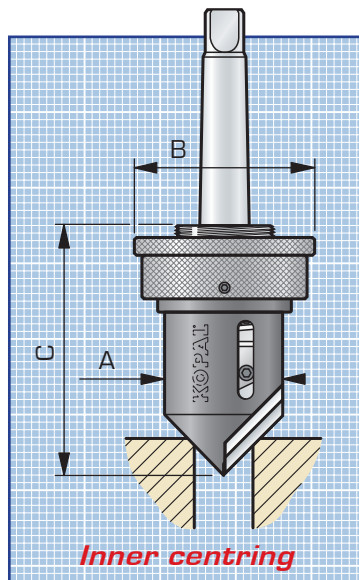
0°, 14°, 20° and 25° cutting angle

TIN coating HSS blades

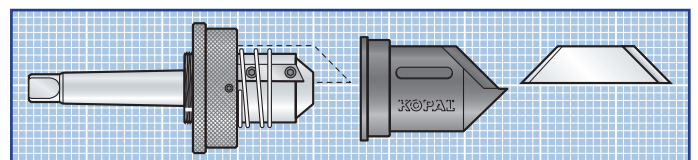
20° cutting angle

Carbide blade

0° cutting angle



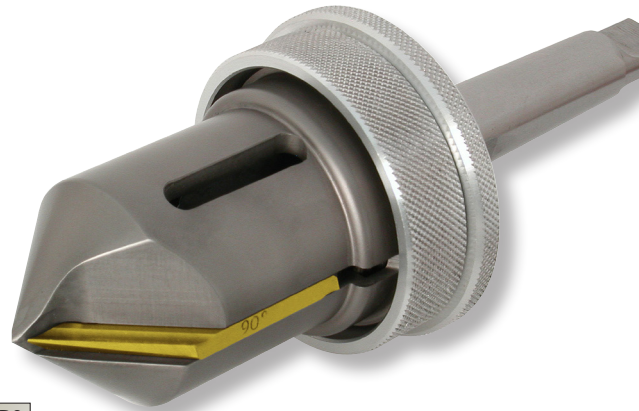
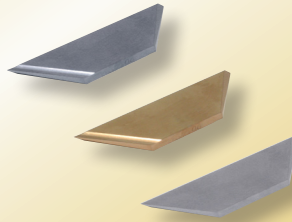
Inner compact devices available



Inner Devices

Cutting blades

- **HSS blade - 0° to 25°**
for most usual materials
- **TIN coating HSS blade - 20°**
for materials difficult to machine :
Stainless steel, Inconel, Titanium
- **Carbide blade - 0°**
for hard materials



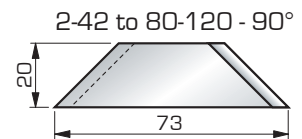
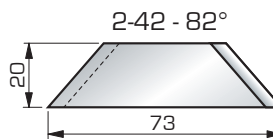
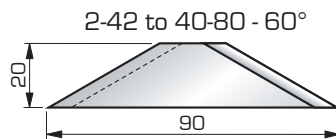
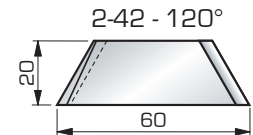
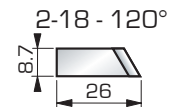
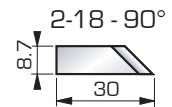
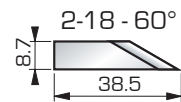
Blade for inner chamfering device

0° cutting angle for devices :	Ch.60°	Ch.90°	Ch.82°	Ch.120°	Ch.60°	Ch.90°
	HSS				Carbide	
2 - 18	01-303	01-323		01-334		
2 - 42	01-343	01-353	01-336	01-364		
20 - 60 to 80 - 120	01-363	01-373			01-341	01-351

14° cutting angle for devices :	Ch.60°	Ch.90°	Ch.82°	Ch.120°
	HSS			
2 - 18	01-305	01-320		01-335
2 - 42	01-340	01-350	01-345	01-360
20 - 60 to 80 - 120	01-365	01-370		

20° cutting angle for devices :	Ch.60°	Ch.90°	Ch.82°	Ch.120°	Ch.60°	Ch.90°
	HSS				TIN	
2 - 18	01-308	01-328		01-338	1T305B	1T320B
2 - 42	01-348	01-358	01-342	01-368		
20 - 60 to 80 - 120	01-368	01-378			1T340B	1T350B

25° cutting angle for devices :	Ch.60°	Ch.90°	Ch.82°	Ch.120°
	HSS			
2 - 18	01-309	01-329		01-339
2 - 42	01-349	01-359	01-344	01-369
20 - 60 to 80 - 120	01-369	01-379		



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.

example : 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