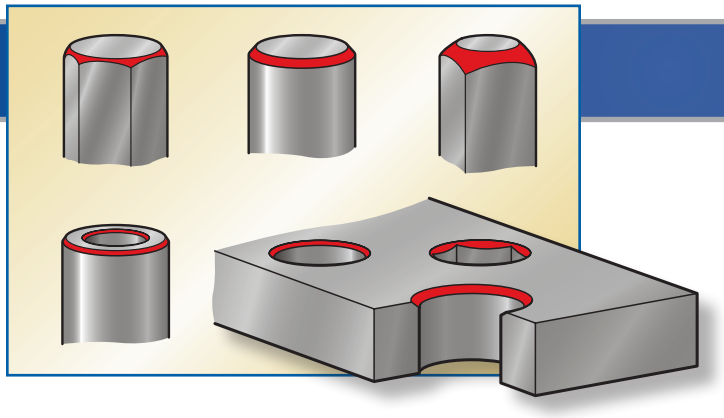
Principle



Chamfering devices mainly for drills

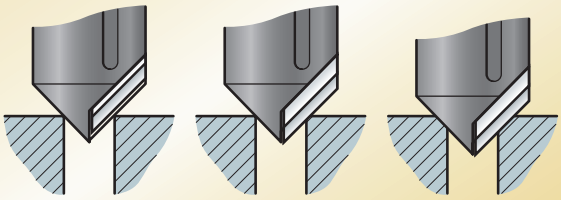
Système KOPAL ®

- **Concentric chamfer**
- **Excellent surface quality**
- **No risk of cutting into the workpiece**
- **Controlled machining torque**

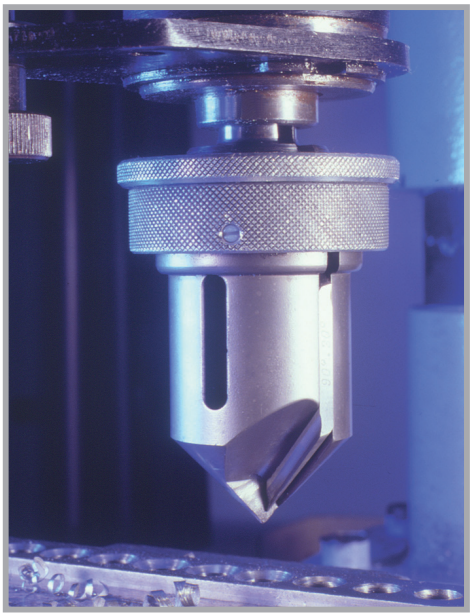
This devices works as a carpenter's plane.

The output adjusting of the blade controls the thickness of the chip and not the value of the chamfer.

Ex. : blade output of 0.1 mm
he device will make 10 turns
for cut 1 mm.



When the spindle is lowered, the pilot cone centres the workpiece, retracts and allows the blade to come out.

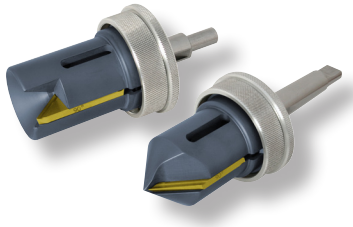


- ***Devices with standard treatment of pilot and HSS blade***

Suitable to most usual materials and small series.

- ***Devices with standard treatment of pilot and TIN coating HSS blade***

Suitable to materials difficult to machine. Stainless steel, Inconel, Titanium and small series.



- ***Devices with CRN treatment of pilot and TIN coating HSS blade***

Suitable to materials difficult to machine. Stainless steel, Inconel, Titanium and important series.

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

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

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.