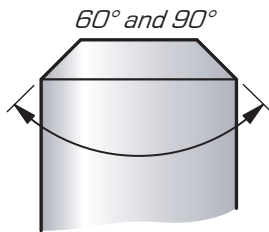
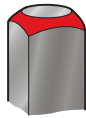
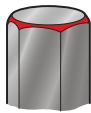


Outer Devices

Chanfreint toutes extrémités

de tubes et de barres cylindriques

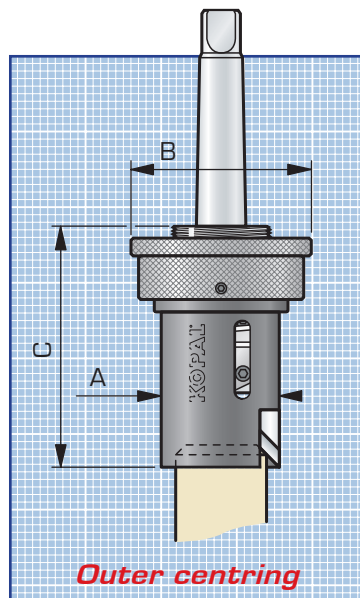
ou polygonales



Outer Devices

Without cutting blade ⚠

Diameter to chamfer	Model	Attach.	A	B	C 60°/90°	Type of cone pilot			
						Standard		CRN	
						60° Ref.	90° Ref.	60° Ref.	90° Ref.
4 to 17	2 - 18	Ø 10 MK 1	Ø 18	Ø 26	54	02-020	02-010	2W020B	2W010B
						02-025	02-015	2W025B	2W015B
4 to 37	2 - 36	Ø 10/16 MK 2	Ø 42	Ø 65	105/85	02-055	02-035	2W055B	2W035B
						02-050	02-030	2W050B	2W030B
10 to 45	10 - 46	Ø 10/16 MK 2	Ø 48	Ø 65	109/85	02-110	02-095		
						02-105	02-090		
21 to 57	20 - 60	MK 2	Ø 60	Ø 70	108/85	02-140	02-135		
41 to 77	40 - 80	MK 2 MK 3	Ø 80	Ø 90	118/95	02-155	02-150		
						02-156	02-151		
60 to 97	60 - 100	MK 3	Ø 100	Ø 110	107		02-166		
80 to 117	80 - 120	MK 3	Ø 120	Ø 130	110		02-181		



HSS blades

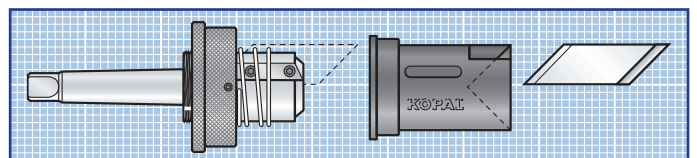
0°, 14°, 20° and 25° cutting angle

TIN coating HSS blades

20° cutting angle

Carbide blade

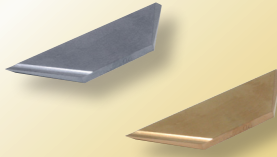
0° cutting angle



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



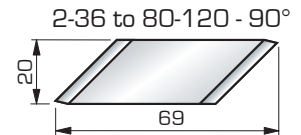
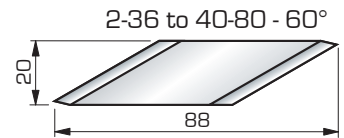
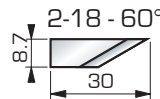
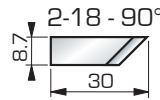
Blade for outer chamfering device

0° cutting angle for devices :	Ch.60° HSS	Ch.90° HSS
2 - 18	02-303	02-304
2 - 36 to 20 - 120	02-317	02-312

14° cutting angle for devices :	Ch.60° HSS	Ch.90° HSS
2 - 18	02-305	02-300
2 - 36 to 20 - 120	02-315	02-310

20° cutting angle for devices :	Ch.60° HSS	Ch.90° HSS	Ch.60° TIN	Ch.90° TIN
2 - 18	02-308	02-302	2T305B	2T300B
2 - 36 to 20 - 120	02-318	02-313	2T315B	2T310B

25° cutting angle for devices :	Ch.60° HSS	Ch.90° HSS
2 - 18	02-307	02-306
2 - 36 to 20 - 120	02-319	02-314



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

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

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.

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