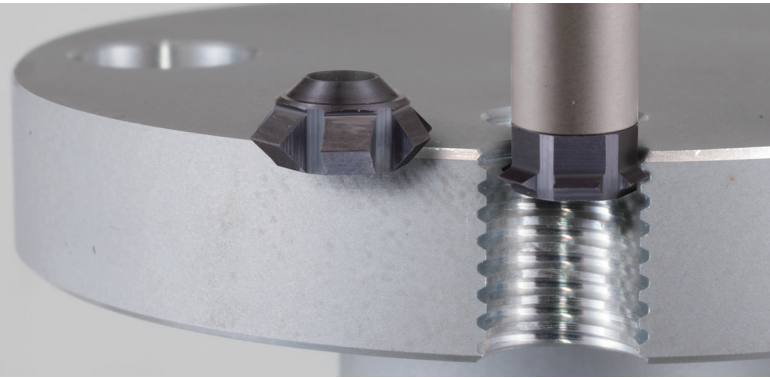


# 60° / 90°

## Deburring Mill from front and back deburring

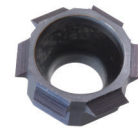
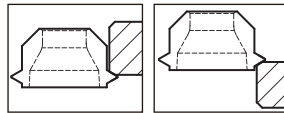


### ► Insert

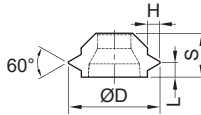
#### NC2032:

- Good for machining high alloy steel, hardened steel up to HRC50
- 6 cutting flutes, high feed rate, fully ground cutting edge
- No secondary burr formation.

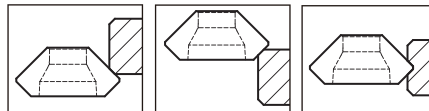
### 60° Deburring Mill



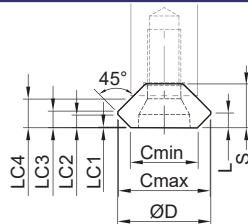
Parts No.	Coating	Grade	ØD	H	L	S	Thread Size	
							Internal	External
R9GT0502-B60-NC2032	TiAlN	K20F	5.0	0.6	0.6	2.45	M6xP0.75	M4xP0.7
R9GT0502-A60-NC2032	TiAlN	K20F	5.0	0.6	0.6	2.45	M6xP1.0	M5xP0.8
R9GT0703-A60-NC2032	TiAlN	K20F	6.8	0.7	0.6	3.25	M8xP1.0 M8xP1.25	M6xP1.0
R9GT1004-A60-NC2032	TiAlN	K20F	8.5	0.85	0.9	4.6	M10xP1.0 M10xP1.25 M10xP1.5	M6xP1.0
R9GT1004-B60-NC2032	TiAlN	K20F	10.0	1.6	1.5	4.6	M12xP1.75 M14xP2.0 M16xP2.0 -12UNC / UNF	M8xP1.25 M10xP1.5 M12xP1.75 M16xP2.0



### 90° Deburring Mill



Parts No.	Coating	Grade	ØD	C	Cmin Ø	Cmax Ø	L	LC1	LC2	LC3	LC4	S
R9GT0502-090-NC2032	TiAlN	K20F	5	0.5	3.9	4.9	0.9	0.05	0.55	1.25	1.75	2.45
R9GT0703-090-NC2032	TiAlN	K20F	7	0.9	5.1	6.9	1.1	0.05	0.95	1.25	2.15	3.25
R9GT1004-090-NC2032	TiAlN	K20F	10	1.3	7.2	9.8	1.5	0.05	1.35	1.65	2.95	4.60

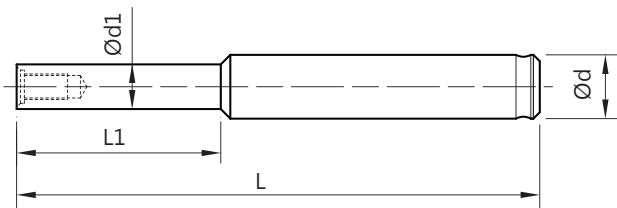


P M K N H

NEW  
ITEM

## ► Holder

- Made of hardened high alloy steel.



Parts No.	Type	Ød	Ød1	L1	L	Insert Type	Screw	Key
99616-CR05-05	BC05-M2.0	5	3.5	16	41	R9GT0502	NS-20045 0.6Nm	NK-T6
99616-CR07-06	BC06-M2.5	6	5.0	21.65	49.65	R9GT0703	NS-25060 0.9Nm	NK-T7
99616-CR10-08	BC08-M3.5	8	6.8	26.40	66.40	R9GT1004	NS-35080 2.5Nm	NK-T15

## Cutting Data

### 60° Deburring Mill

Workpiece material	Vc (m/min.)	Feed rate (mm / tooth)
<b>P</b> Carbon steel	80 ~ 150	0.002 ~ 0.013
<b>P</b> Alloy steel	60 ~ 120	0.002 ~ 0.01
<b>M</b> Stainless steel	50 ~ 100	0.002 ~ 0.01
<b>K</b> Casting iron	50 ~ 100	0.002 ~ 0.01
<b>N</b> Al, and non-ferrous metal	100 ~ 300	0.002 ~ 0.013
<b>H</b> Hardened steel < 50 HRC	30 ~ 60	0.002 ~ 0.008

### 90° Deburring Mill

Workpiece material	Vc (m/min.)	Feed rate (mm / tooth)
<b>P</b> Carbon steel	120 ~ 250	0.005 ~ 0.12
<b>P</b> Alloy steel	100 ~ 200	0.005 ~ 0.10
<b>M</b> Stainless steel	60 ~ 150	0.005 ~ 0.10
<b>K</b> Casting iron	80 ~ 180	0.005 ~ 0.10
<b>N</b> Al, and non-ferrous metal	150 ~ 500	0.005 ~ 0.15
<b>H</b> Hardened steel < 50 HRC	40 ~ 100	0.005 ~ 0.05