



Deburring Mill >>>

60° & 90°

For both front and back deburring and threading applications.

P M K N H

▶ **2 Angles : 60° / 90°**

- One holder can fit on both the 60° and 90° deburring inserts.

▶ **6 Cutting Flutes**

- provide higher feed rate, optimized performance and reduced cycle time.

▶ **Ø5mm
(.197")**

90° insert



60° insert



Features >>>

▶ **Deburring Mill 60°**

- Front & back deburring in one operation.
- Mini. deburring bore from Ø3.9 ~ Ø10mm (Ø .154" ~ .394").
- Also for thread milling application.
- Each insert has 6 flutes.
- Thanks for special insert geometry and Nine9 clamping system to provide high precision and accurate position.
- The smallest insert Ø5.0mm (.197") can do M6xP0.75 internal threading and deburring.
- For external different threading pitch can be done by NC programming.
For example: Ø10.0mm (.394") insert can do external, threading pitch from P1.25 to P2.0mm (.049" to .079), save your tool inventory.

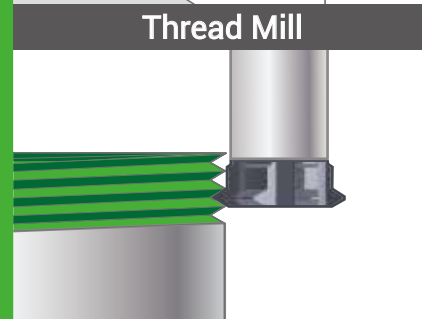
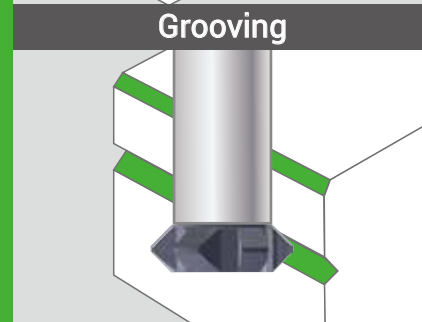
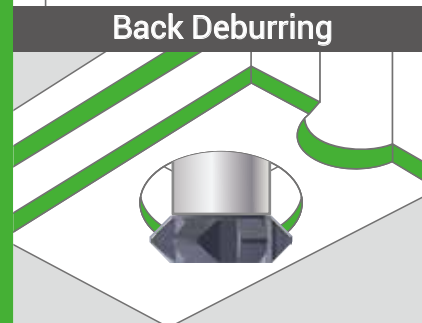
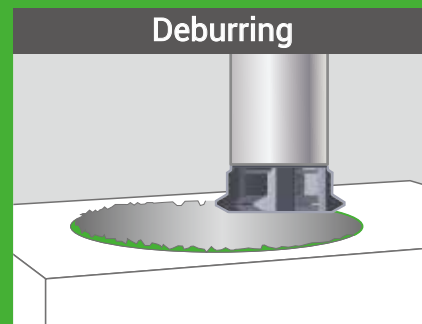
▶ **Deburring Mill 90°**

- For front & back deburring, grooving is also possible.
- Mini. deburring bore from Ø3.9 ~ Ø10mm (Ø .154" ~ .394").
- Each insert has 6 flutes.





Applications

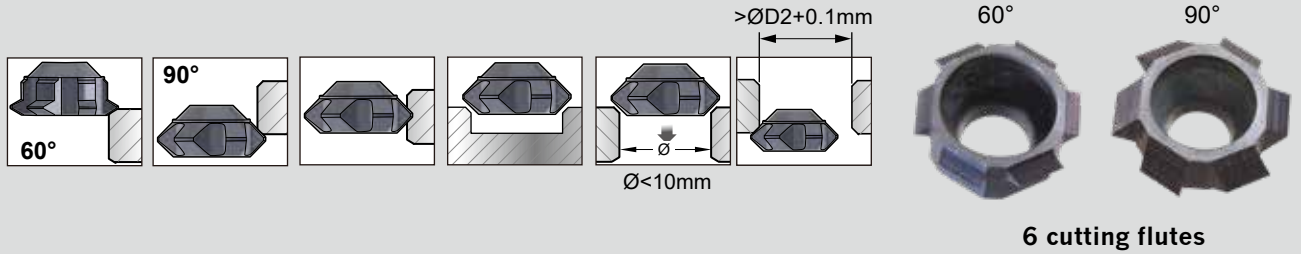


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- Specialized on narrow space below 10mm (.394") by indexable inserts.
- 6 cutting flutes, higher feed rate, good for hardened steel up to HRC60.

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Deburring Mill 60° & 90°



► Inserts >>

NC2032: • TiAIN coating provides longer tool life.

- For all kinds of steel < 60 HRC, carbon steel, alloy steel and cast iron.

XP9000: • High positive geometry and sharp edge produces excellent surface finish.

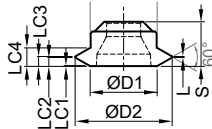
- For non-ferrous material such as aluminum, titanium, brass, copper and long cutting chip metal.

► 60° deburring mill

- For front and back deburring.
- Also for threading application.



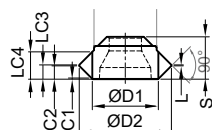
Parts No.	Coating	Grade	ØD1	ØD2	L	LC1	LC2	LC3	LC4	S	Plunge 0.1C		
											min. hole	max. hole	
R06005-05006-32	TiAIN	K20F	3.9 (.154")	5.0 (.197")	0.06 (.002")	0.03 (.001")	0.34 (.013")	0.40 (.016")	0.72 (.028")	2.45 (.097")	4.1 (.161")	4.8 (.189")	
R06005-05006-00	Uncoated												
R06005-05010-32	TiAIN		3.9 (.154")	5.0 (.197")	0.1 (.004")	0.03 (.001")	0.34 (.013")	0.44 (.017")	0.76 (.030")	2.45 (.097")	4.1 (.161")	4.8 (.189")	
R06005-05010-00	Uncoated												
R06007-06810-32	TiAIN		5.5 (.217")	6.8 (.268")	0.1 (.004")	0.03 (.001")	0.40 (.016")	0.50 (.020")	0.87 (.034")	3.25 (.128")	5.7 (.224")	6.6 (.260")	
R06007-06810-00	Uncoated												
R06010-08510-32	TiAIN		6.9 (.272")	8.5 (.335")	0.1 (.004")	0.03 (.001")	0.49 (.019")	0.59 (.023")	1.05 (.041")	4.60 (.181")	7.1 (.280")	8.3 (.327")	
R06010-08510-00	Uncoated												
R06010-10010-32	TiAIN		6.9 (.272")	10.0 (.394")	0.1 (.004")	0.03 (.001")	0.92 (.036")	1.02 (.040")	1.91 (.075")	4.60 (.181")	7.1 (.280")	9.8 (.386")	
R06010-10010-00	Uncoated												



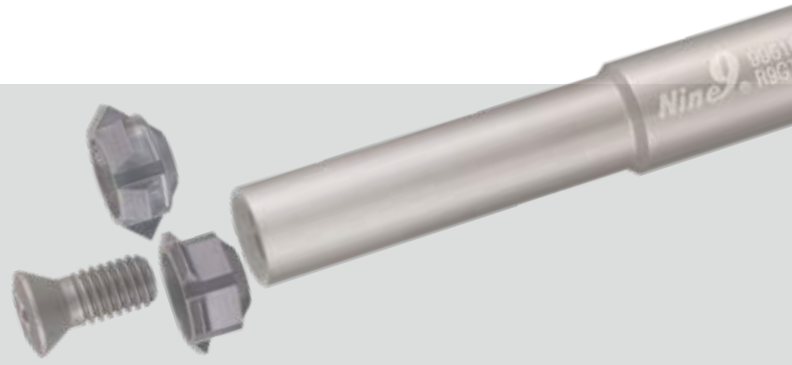
► 90° deburring mill

- Front & back deburring in one operation.

Parts No.	Coating	Grade	ØD1	ØD2	L	LC1	LC2	LC3	LC4	S	Plunge 0.1C		
											min. hole	max. hole	
R09005-05060-32	TiAIN	K20F	3.9 (.154")	5.0 (.197")	0.6 (.024")	0.05 (.002")	0.6 (.024")	1.2 (.047")	1.75 (.069")	2.45 (.097")	4.1 (.161")	4.8 (.189")	
R09005-05060-00	Uncoated												
R09007-07020-32	TiAIN		5.1 (.201")	7.0 (.276")	0.2 (.008")	0.05 (.002")	1.0 (.039")	1.2 (.047")	2.15 (.085")	3.25 (.128")	5.3 (.209")	6.8 (.268")	
R09007-07020-00	Uncoated												
R09010-10010-32	TiAIN		7.2 (.283")	10.0 (.394")	0.1 (.004")	0.05 (.002")	1.45 (.057")	1.55 (.061")	2.95 (.116")	4.60 (.181")	7.4 (.291")	9.8 (.386")	
R09010-10010-00	Uncoated												

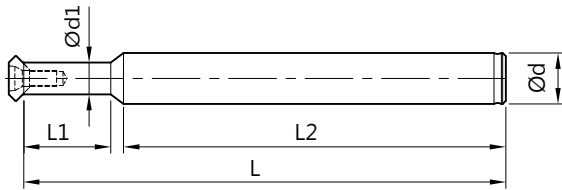


Deburring Mill 60° & 90°



► Holder >>

- Made of hardened high alloy steel.
- For both 60° and 90° deburring inserts.



Parts No.	Type	Shank	Ød	Ød1	L1	L2	L	Insert Type	Screw	Key
99626-CR05-06-039	BC06-CR05-039				4.0 (.157")	33 (1.299")	39 (1.535")			
99626-CR05-06-045	BC06-CR05-045	Steel	6 (.236")	3.5 (.138")	10 (.394")	33 (1.299")	45 (1.772")	Rxxx05	NS-20045 0.6Nm	NK-T6
99626-CR05-06-051	BC06-CR05-051				16 (.630")	33 (1.299")	51 (2.008")			
99626-CR05-06-051W	BC06-CR05-051W	Carbide			16 (.630")	33 (1.299")	51 (2.008")			
99626-CR07-06-041	BC06-CR07-041				6.0 (.236")	33 (1.299")	41 (1.614")			
99626-CR07-06-049	BC06-CR07-049	Steel	6 (.236")	5.0 (.197")	14 (.551")	33 (1.299")	49 (1.929")	Rxxx07	NS-25060 0.9Nm	NK-T7
99626-CR07-06-057	BC06-CR07-057				22 (.866")	33 (1.299")	57 (2.244")			
99626-CR07-06-057W	BC06-CR07-057W	Carbide			22 (.866")	33 (1.299")	57 (2.244")			
99626-CR10-08-049	BC08-CR10-049				7.0 (.276")	40 (1.575")	49 (1.929")			
99626-CR10-08-059	BC08-CR10-059	Steel	8 (.315")	6.8 (.268")	17 (.669")	40 (1.575")	59 (2.323")	Rxxx10	NS-35080 2.5Nm	NK-T15
99626-CR10-08-069	BC08-CR10-069				27 (1.063")	40 (1.575")	69 (2.717")			
99626-CR10-08-084W	BC08-CR10-084W	Carbide			27 (1.063")	55 (2.165")	84 (3.307")			

► Cutting Data >>

60° & 90° deburring mill for deburring

	Workpiece material	SFM	Feed rate (inch / tooth)	Grade of insert
P	Carbon steel	390 ~ 820	.00020" ~ .00472"	NC2032
	Alloy steel	330 ~ 660	.00020" ~ .00394"	NC2032
M	Stainless steel	200 ~ 500	.00020" ~ .00394"	NC2032
K	Cast iron	265 ~ 590	.00020" ~ .00394"	NC2032
N	Non-ferrous metal	500 ~ 1640	.00020" ~ .00590"	XP9000
H	Hardened steel < HRC60	130 ~ 330	.00020" ~ .00197"	NC2032

60° deburring mill for thread milling

	Workpiece material	SFM	Feed rate (inch / tooth)	Grade of insert
P	Carbon steel	260 ~ 500	.00008" ~ .00051"	NC2032
	Alloy steel	200 ~ 390	.00008" ~ .00040"	NC2032
M	Stainless steel	165 ~ 330	.00008" ~ .00040"	NC2032
K	Cast iron	165 ~ 330	.00008" ~ .00040"	NC2032
N	Non-ferrous metal	330 ~ 1050	.00008" ~ .00051"	XP9000
H	Hardened steel < HRC60	100 ~ 200	.00008" ~ .00031"	NC2032

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Deburring Mill