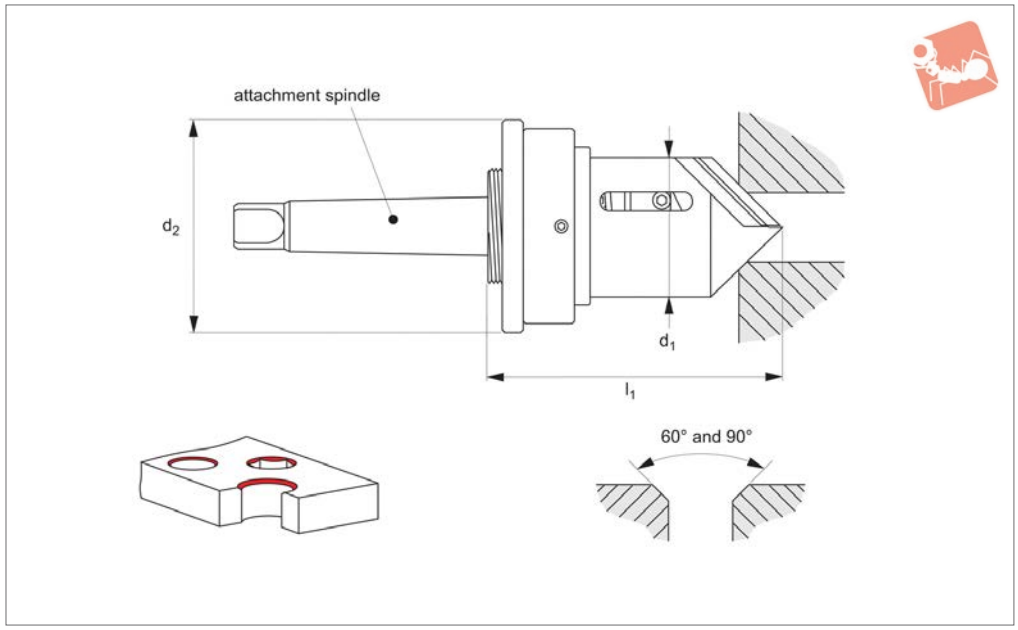
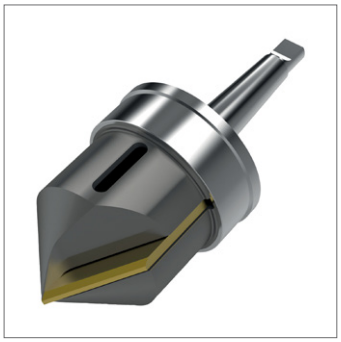




91000

Material

Standard pilot cone type:
Supplied with standard HSS blade of 14. cutting angle.
CRN pilot cone type:
Supplied with HSS TIN coated blade of 20. cutting angle.

Technical Notes

Consists of four main elements;
1. Body and drill attachment spindle.
2. Pilot cone - unique to the desired chamfer, provides full support during cutting and ensures concentric chamfer.
3. Blades - 1 x HSS blade at 14.cutting angle supplied.
4. Blade adjustment lock nut.
The CRN pilot cone type version gives better results for harder materials and/or larger batches as these have a higher hardness rating and lower friction characteristics.

Tips

Used to achieve high quality concentric chamfering quickly and easily, without risk of damage/cutting into workpiece.
Recommended cutting speed= 10 - 20 m/min. For hand drill chamfering tool we recommend a cutting speed of 3 - 40 rpm.
Available with attachment spindles to suit most pillar drills, CNCs or hand drills.
Chamfer angle quoted is inclusive angle.

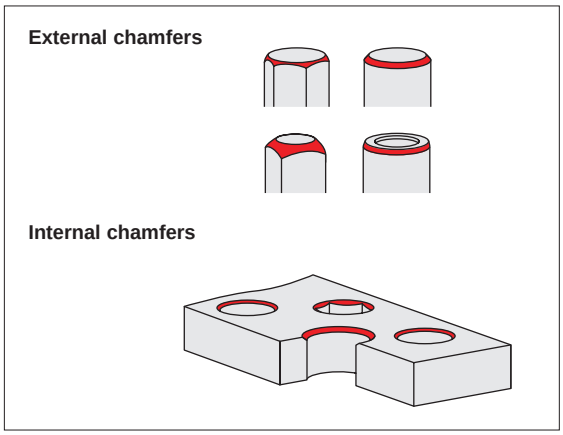
Important Notes

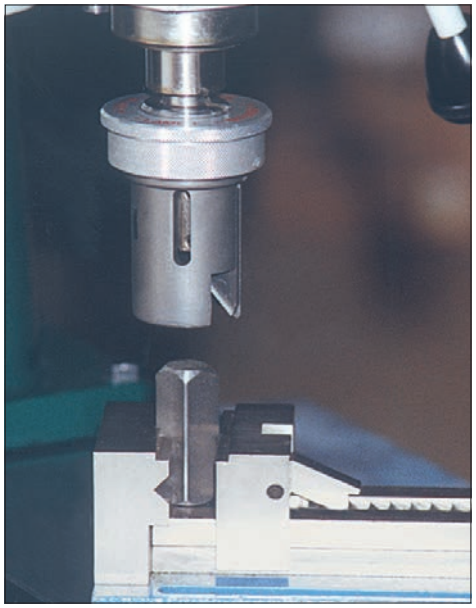
To extend the life of the blade and pilot cone we recommend lubrication with cutting fluid or soluble oil.
On initial set-up, make minor height adjustment of pilot cone via the blade adjustment lock nut to ensure best possible positioning.

Order No.	Pilot cone type	Chamfer dia. min.|max.	Inc. chamfer angle °	Attachment spindle	d_1	d_2	l_1
91000.W1860-1	Standard	4-17	60°	Ø10	18	26	64
91000.W1890-1	Standard	4-17	90°	Ø10	18	26	55
91000.W4260-1	Standard	5-41	60°	Ø10/Ø16	42	65	108
91000.W4290-1	Standard	5-41	90°	Ø10/Ø16	42	65	85
91000.W4260-2	Standard	5-41	60°	CM2	42	65	108
91000.W4290-2	Standard	5-41	90°	CM2	42	65	85
91000.W6060-2	Standard	21-59	60°	CM2	60	70	106
91000.W6090-2	Standard	21-59	90°	CM2	60	70	94
91000.W8060-2	Standard	42-77	60°	CM2	80	90	114
91000.W8090-2	Standard	42-77	90°	CM2	80	90	100
91000.W8190-3	Standard	62-97	90°	CM3	100	110	104
91000.W8290-3	Standard	82-117	90°	CM3	120	130	104
91000.W1860-19	CRN	4-17	60°	Ø10	18	26	64
91000.W1890-19	CRN	4-17	90°	Ø10	18	26	55
91000.W4260-19	CRN	5-41	60°	Ø10/Ø16	42	65	108
91000.W4290-19	CRN	5-41	90°	Ø10/Ø16	42	65	85
91000.W4260-29	CRN	5-41	60°	CM2	42	65	108
91000.W4290-29	CRN	5-41	90°	CM2	42	65	85

Inner Chamfering Tools
for drill attachment

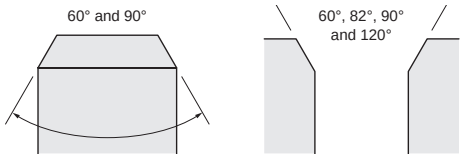
Wixroyd chamfering tools are mainly used as drill extensions to add high quality, consistent inner and outer chamfers. The chamfer angles achievable on a wide range of metals are between 60° to 120° inclusive.

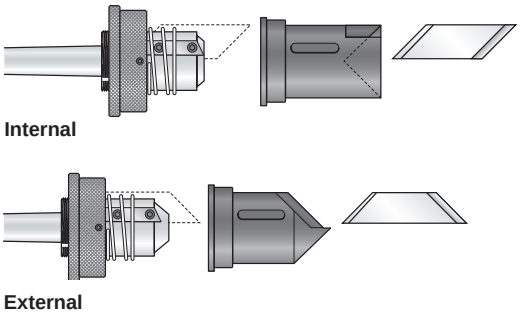




Construction

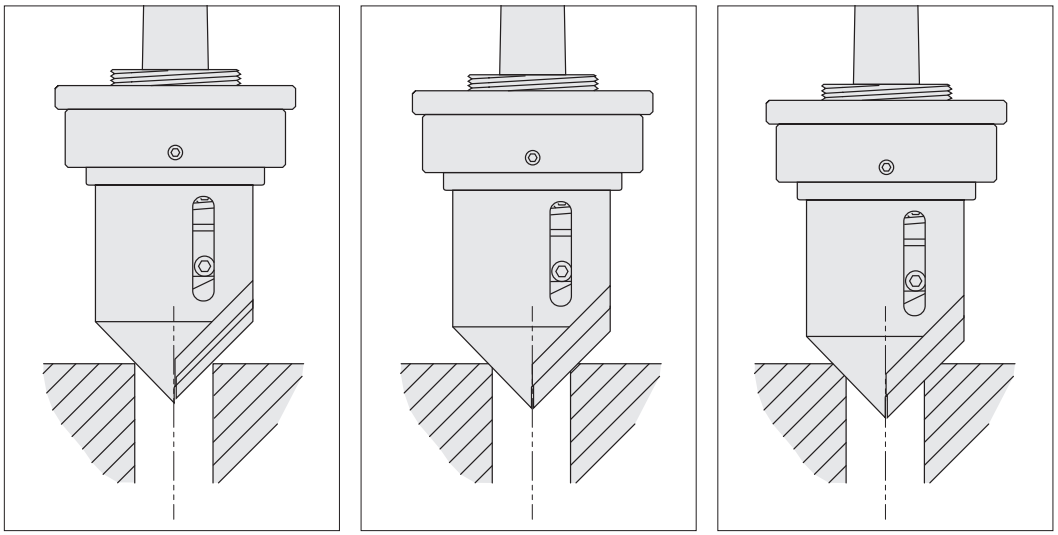
- Concentric chamfers.
- Excellent surface finish.
- Reduces risk of cutting into the workpiece.
- Controlled machining torque.





Chamfering tools consist of three main elements: an attachment spindle, pilot cone and cutting blade.

A variety of spindle attachments are available from CM1 to CM3 inclusive.



Our chamfer tools act by gradually shaving material away from a right angled corner to create a transitional, angled edge between two planes.

Example: with a blade protrusion of 0,1mm the device will make 10 revolutions to cut 1mm.

1 **When the chamfer tools spindle is lowered, it's pilot cone firstly centres the workpiece before retracting to allow the blade to come into contact with the material and start cutting of the chamfer.**

2 **Adjusting the output of the blade controls the thickness of the chip count NOT the value or angle of the chamfer e.g. with a blade protrusion of 0,1mm the chamfering tool requires 10 revolutions to cut 1mm of the chamfer.**

3 **Concentric chamfer achieved.**