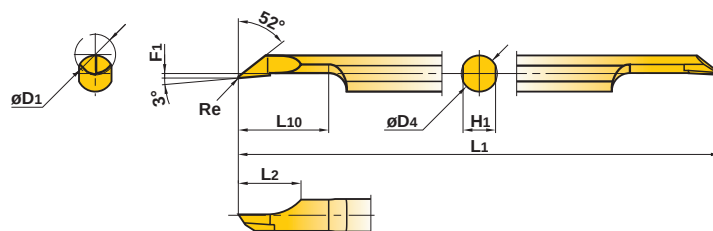


CR

For internal copying



Right hand tool only.

Order Number	Stock		Breaker	Min. Cutting Diameter D1	Dimensions (mm)						
	Micro Grain	Coated			Re	D4	L1	L10	L2	F1	H1
	TF15	VP15TF									
CR03RS-01	●	●	without	3.5	0.1	3	50	8	6	0.15	2.7
03RS-01B	●	●	with	3.5	0.1	3	50	8	6	0.15	2.7
04RS-01	●	●	without	4.5	0.1	4	60	10	7	0.15	3.6
04RS-01B	●	●	with	4.5	0.1	4	60	10	7	0.15	3.6
05RS-01	●	●	without	5.5	0.1	5	70	12	8	0.15	4.5
05RS-01B	●	●	with	5.5	0.1	5	70	12	8	0.15	4.5

BORING

RECOMMENDED CUTTING CONDITIONS

Work Material		Micro-Mini Twin CB				Micro-Mini Twin CR		
		Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	l/d	Cutting Speed (m/min)	Feed (mm/rev)	
							03RS/04RS	05RS
P	Carbon Steel, Alloy Steel 180–350HB	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5	80 (40–120)	0.02 (0.01–0.03)	0.03 (0.01–0.05)
M	Stainless Steel ≤200HB	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5	80 (40–120)	0.02 (0.01–0.03)	0.03 (0.01–0.05)
K	Cast Iron ≤350MPa	80 (40–120)	0.03 (0.01–0.05)	0.2 (0.1–0.3)	3–5	80 (40–120)	0.03 (0.01–0.05)	0.03 (0.01–0.05)
N	Non-Ferrous Material (Aluminium, Brass etc.)	120 (80–160)	0.05 (0.01–0.08)	0.3 (0.1–0.5)	3–5	120 (80–160)	0.03 (0.01–0.05)	0.05 (0.01–0.08)

(Note 1) Recommend wet machining.

(Note 2) The recommended tool overhang of CR type is L10+2mm.