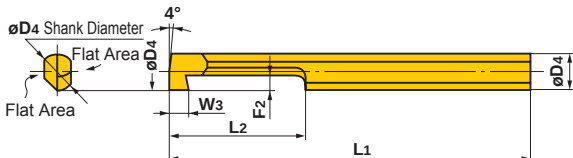


MICRO-MINI

- Solid carbide type with min. cutting diameter 3.2mm.
- l/d is 5 times the diameter.
- Insert can be ground to suit the application.
- Suitable for a wide range of tooling including threading and grooving.

MICRO-MINI STANDARD (SOLID CARBIDE BORING BAR)

Order Number	Stock	Dimensions (mm)				Min. Cutting Diameter (mm)	Max. Groove Depth F2 (mm)	Geometry
	Micro Grain Carbide							
	TF15	W3	D4	L1	L2			
C03FR-BLS	★	2.0	3	80	15	3.2	1.0	
C04FR-BLS	★	2.5	4	80	20	4.2	1.5	
C05HR-BLS	★	3.0	5	100	25	5.2	2.0	

Right hand tool only.

RECOMMENDED CUTTING CONDITIONS

	Work Material	Cutting Speed (m/min)	Feed (mm/rev)	Depth of Cut (mm)	Excrescence Quantity (l/d)	Edge Condition	
						Corner Radius or C ★	Honing ★
P	Carbon Steel · Alloy Steel 180~280HB	40 (30~50)	0.05 (—0.1)	0.2 (0.1~0.3)	5	0.1~0.5	0.01~0.05
M	Stainless Steel ≤200HB	40 (30~50)	0.05 (—0.1)	0.2 (0.1~0.3)	5	≤0.4	0~0.03
K	Cast Iron ≤350MPa	40 (30~50)	0.05 (—0.05)	0.2 (0.1~0.3)	5	0.1~0.5	0.01~0.05
N	Non-Ferrous Metal	80 (60~100)	0.05 (—0.1)	0.3 (0.1~0.5)	5	0.1~0.5	0~0.03

★ Cutting edge is not honed. Please hone according to the workpiece before machining.

GRINDING THE CUTTING EDGE OF MICRO-MINI

● MICRO-MINI can be used for boring and grooving as it is. But, it can also be reground as shown below.

● For shaping and regrounding, use diamond whetstone approximately #250—#400. Please grind according to application using the figure below as a reference.

Application	Boring	Grooving	Threading
Grinding Examples	