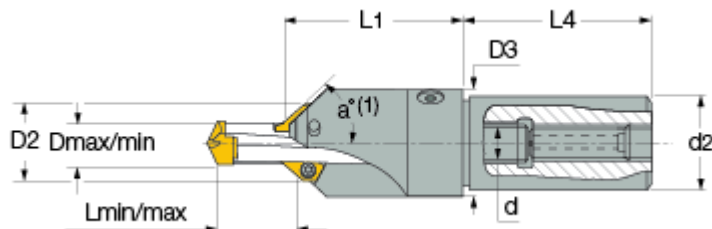




CHAMRING : Drill Holders used with UNISUMOCHAM or UNICHAMDRILL drills for drilling and chamfering in one operation.



(1) Chamfering angle (a°) is dependent on the chamfering insert being used.



Designation	D min	D max	L min	L max	L min	L max	L min	L max	d	D3	D2	L1	L4	d2
CHAMRING 080-WN20-06	7.50	8.40	18.8	26.3	14.0	23.0	30.3	42.3	8.00	25.00	18.80	47.4	50.0	20.00
CHAMRING 090-WN20-06	8.50	9.40	18.6	29.7	15.6	27.1	32.1	47.7	9.00	25.00	19.80	47.4	50.0	20.00
CHAMRING 100-WN32-09	9.50	10.40	27.5	32.7	14.3	28.3	42.0	52.7	10.00	38.00	24.90	67.3	60.0	32.00
CHAMRING 110-WN32-09	10.50	11.40	29.8	36.0	18.0	31.0	43.8	58.0	11.00	38.00	25.90	67.3	60.0	32.00
CHAMRING 120-WN32-09	11.50	12.40	30.3	39.1	19.2	35.2	46.3	63.1	12.00	38.00	26.90	67.3	60.0	32.00
CHAMRING 130-WN32-09	12.50	13.40	35.0	43.0	21.4	38.4	53.0	69.0	13.00	38.00	27.90	67.3	60.0	32.00
CHAMRING 140-WN32-09	13.50	14.40	28.7	45.4	21.5	41.5	53.7	73.4	14.00	38.00	28.40	67.3	60.0	32.00
CHAMRING 150-WN32-09	14.50	15.90	30.2	49.0	25.2	43.7	55.2	79.0	15.00	38.00	29.40	67.3	60.0	32.00
CHAMRING 160-WN32-09	16.00	16.90	33.0	57.0	26.3	49.3	65.0	89.0	16.00	38.00	30.40	67.3	60.0	32.00
CHAMRING 170-WN32-09	17.00	17.90	31.3	58.5	28.4	52.4	65.3	92.5	17.00	38.00	31.40	67.3	60.0	32.00
CHAMRING 180-WN32-09	18.00	18.90	34.0	61.0	31.0	57.0	70.0	97.0	18.00	38.00	32.40	67.3	60.0	32.00
CHAMRING 190-WN32-09	19.00	19.90	35.3	65.6	32.3	63.3	73.3	103.6	19.00	38.00	33.40	75.0	60.0	32.00
CHAMRING 200-WN32-09	20.00	20.90	46.1	74.6	36.6	67.1	86.1	114.6	20.00	38.00	34.40	75.0	60.0	32.00

Note: Point the cursor on each set of Lmin Lmax "!" signs to verify to which drill they refer
It is recommended to apply external coolant on the chamfering inserts. Reduce the recommended feed and speed of the drill being used by 50% when machining maximum chamfer size.

Lmin & Lmax dimensions are based on the 45° chamfering insert.