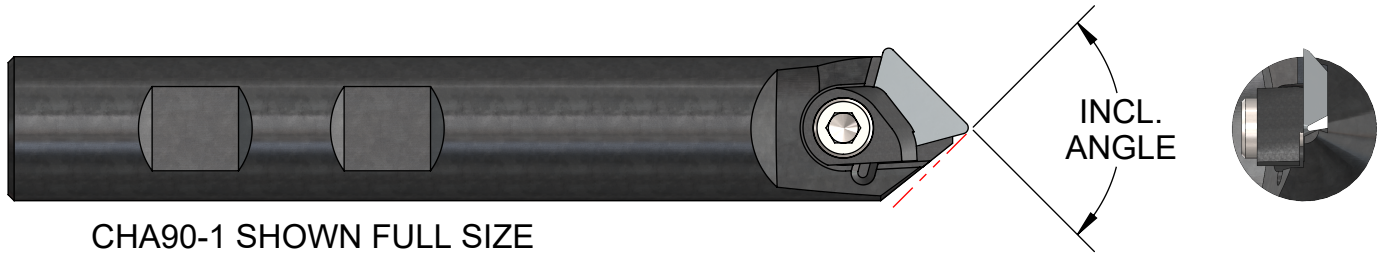


The Single Flute Chamfer Hogs



CHA90-1 SHOWN FULL SIZE

This cutter was developed in 1982 for spot drilling and chamfer milling small slots in non-ferrous part materials. If used prior to drilling in non-ferrous materials it performs well. If used as a countersink after the hole is drilled it is chatter prone.

It is not for use as a rotating cutter in ferrous materials since the (25°) relief angle is too weak. However, in the more rigid lathe environment it can be used successfully to spot drill holes in ferrous materials. We spot drill our Accu-Holds (4340) in CNC lathes at 900 RPM and .0005 IPR, with tool life of 200 holes per insert corner.

It should never be used in a drill press.

All five cutters are on 3/4" Ø shanks and have a 5.0 overall length

All Single Flute Chamfer-Hogs, including inserts, are **\$215.** ea.

Number	Included Angle	Maximum Chamfer Ø	Insert	Clamp	Insert Prices	
CHA90-1	90°	.800	TFG32-90	CL-4	TFG32-90	\$15.00
CHA82-1	82°	.730	TFG32-90	CL-4	TFG32-90T (TiN Coated)	\$17.25
CHA100-1	100°	.940	TFG32-90	CL-4	TD6P-120	\$22.50
CHA120-1	120°	1.00	TD6P-120	5-40		
CHA60-1*	60°	1.00	TFG32-90	CL-4M		

* Note: CHA60-1 is **not** center cut; it has .200 end cut Ø.

The CL-4 & CL-4M Clamps are **\$17.50** each, includes screw.

The 10-32 Socket Head Cap Screw is Industry Standard.

TFG32-90 and TD-6P are Industry Standard Inserts modified with a secondary facet near the point to prevent "heeling".



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