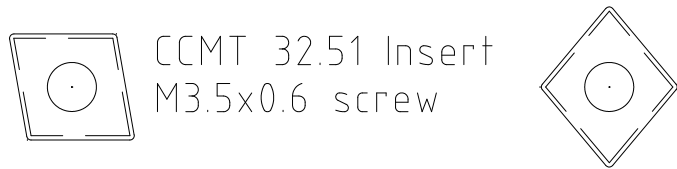


CCMT Champfer Tool (Lathe)
 Craig Durland
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Uses the unused edges of a CCMT insert
 Provides three cutting edges



CCMT 32.51 Insert
 M3.5x0.6 screw

- 1) Mount on rotary table
 Table set on zero, align shank on X (or Y)
- 2) Slot to (0,0) along center line
- 3) Mill the rest of the pocket
 - A) The shoulders are $\pm 50^\circ$,
 remember the endmill width
 - or
 - B) Rotate to 320° and cut along Y
 Rotate to 310° and cut along X
- 4) Check with insert & screw
 before unmounting shank
 The shoulders may need to move back

Cut pocket with 1/8" endmill

