



BRILLIANT CORNERING PRODUCES BEAUTIFUL CURVES!

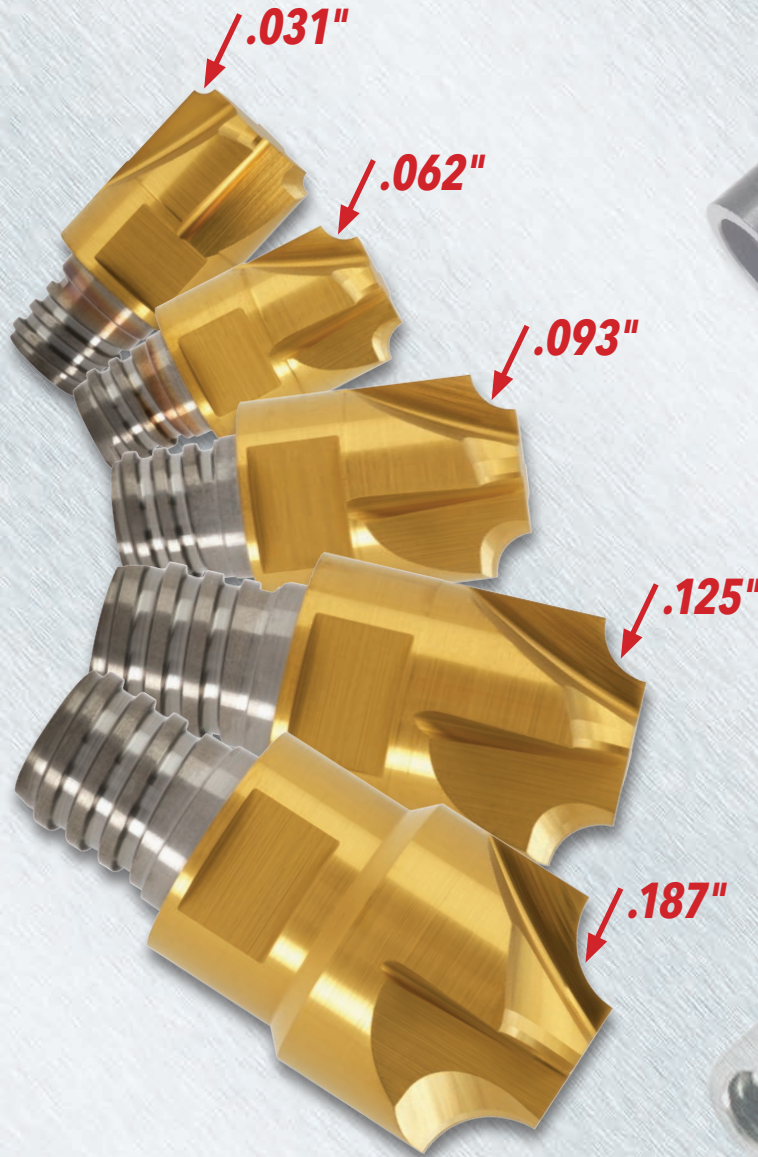
Tip Style:
Corner Round

Tip Repeatability:
± .001

Available Adaptions:
T06, T08, T10

Radius Options:

.031"
.062"
.093"
.125"
.187"



**NEW
PRODUCT
ANNOUNCEMENT
2017**

General Features:

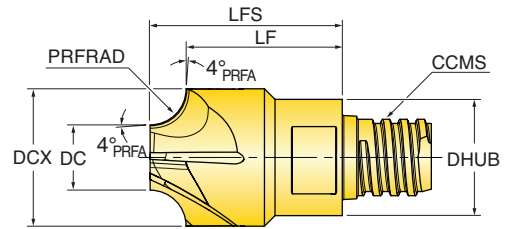
- Ideal for finish work of aerospace materials....eliminate hand work!
- Tips repeat within +/- .001. No need to touch off when indexing the tip off the shank.
- 4 degree flares off the radius form promote smooth blends....no mismatch lines!
- 200% feed rate acceleration with 4 flutes.

CHIP SURFER™ SERIES 47R

SOLID CARBIDE CORNER ROUNDING TIP - 4 FLUTE





Corner Rounding



| Cutter Number | DC Cutting Diameter | DCX Cutting Diameter Max. | PRFRAD Profile Radius | ZEFF Effective Flutes | LF Functional Length | LFS Functional Length Secondary | CCMS Connection Code | DHUB Hub Diameter |
|----------------|---------------------|---------------------------|-----------------------|-----------------------|----------------------|---------------------------------|----------------------|-------------------|
| 47R-3605T6RA03 | 0.298 | 0.362 | .031 | 4 | 0.468 | 0.50 | T06 | .369 |
| 47R-3505T6RA06 | 0.234 | 0.357 | .062 | 4 | 0.438 | 0.50 | T06 | .369 |
| 47R-4806T8RA09 | 0.295 | 0.480 | .093 | 4 | 0.547 | 0.64 | T08 | .485 |
| 47R-6008TRRA12 | 0.351 | 0.601 | .125 | 4 | 0.685 | 0.81 | T10 | .605 |
| 47R-7110TRRA18 | 0.343 | 0.715 | .187 | 4 | 0.813 | 1.00 | T10 | .605 |

When assembling, be sure tip is seated firmly on shank with no gap.
 No lubricant on adaption.
 Wrenches sold seperately.

CHIP SURFER™ HARDWARE

| |  Wrench |  Optional Torque Driver | CCMS Connection Code | Torque Value |
|----------------|---|---|----------------------|--------------|
| 47R-3605T6RA03 | WS-0029 | DT-90-08 | T06 | 90in/lbs |
| 47R-3505T6RA06 | WS-0029 | DT-90-08 | T06 | 90in/lbs |
| 47R-4806T8RA09 | WS-0030 | DT-130-10 | T08 | 130in/lbs |
| 47R-6008TRRA12 | WS-0044 | DT-250-13 | T10 | 250in/lbs |
| 47R-7110TRRA18 | WS-0044 | DT-250-13 | T10 | 250in/lbs |

| Material | | Brinnell Hardness | SFM | Feed per Tooth | Coolant |
|-----------------|-------------------------------|-------------------|---------|----------------|----------------------------------|
| Cast Iron | Gray | 150-250 | 450-700 | .002-.005 | NO |
| | Nodular | 150-250 | 400-600 | .002-.004 | |
| Steel | Low Carbon 1018, 8620 | 150-250 | 350-600 | .002-.004 | NO |
| | High Carbon F-6180 | 250-400 | | | |
| | Alloyed Steel 4140, 4340 | 150-300 | | | |
| | Tool Steel A-6, D-1, D2 | Up to 300 | 300-500 | | |
| Stainless Steel | 300 Series, 304, 316 | - | 250-500 | .002-.004 | May not be needed at high speeds |
| | 400 Series, 15-5 PH | Up to 320 | | | YES |
| | 13-8 PH | - | | | YES |
| Nickel Alloys | Inconel, Hastelloy, Waspalloy | - | 75-125 | .002-.004 | YES |
| Titanium | 6AL-4V | - | 125-200 | .002-.004 | YES |

Note: Feed and speed recommendations are starting operating parameters. They are only guidelines from which further optimization should take place. Operating parameters are influenced by many machining variables. These variables may cause for reductions in feeds and speed or dramatic increases. Additionally, DOC and WOC may need to be revised to optimize the tools performance.