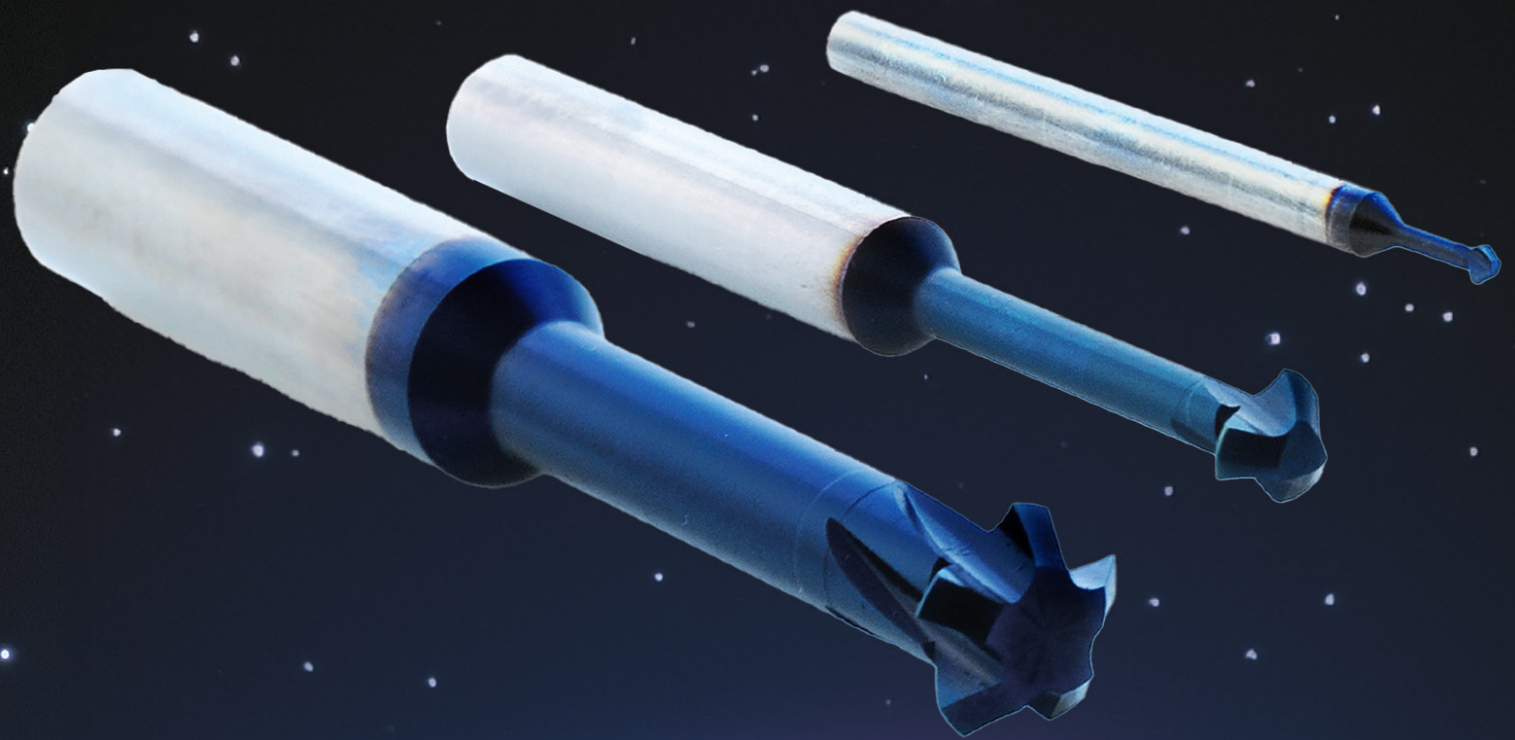




HARRY HERSBACH  
TOOLS BV

specialist in machining tools

2024



**COMBIDEX**®

solid solutions to improve your business

# MINI CHAMFER MILL

THREADING

MILLING

THREAD MILLING

TURNING

DRILLING

GROOVING & PARTING

**Combidex**

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# INDEX MINI CHAMFER MILL

## MINI CHAMFER MILL

1.1	MINI CHAMFER   INFORMATION	4
1.2	MINI CHAMFER   ORDERING CODES	5
1.3	MINI CHAMFER   90° & LONG REACH 90°	6
1.4	MINI CHAMFER   60° & 150°	7
1.5	MINI CHAMFER   DOVETAIL 45°	8
1.6	MINI CHAMFER   CUTTING DATA	9

## 1.1 MINI CHAMFERER | Information

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### MINI CHAMFERER

Combidex Mini Chamfer and Countersink

#### Carbide grade: FXFL8

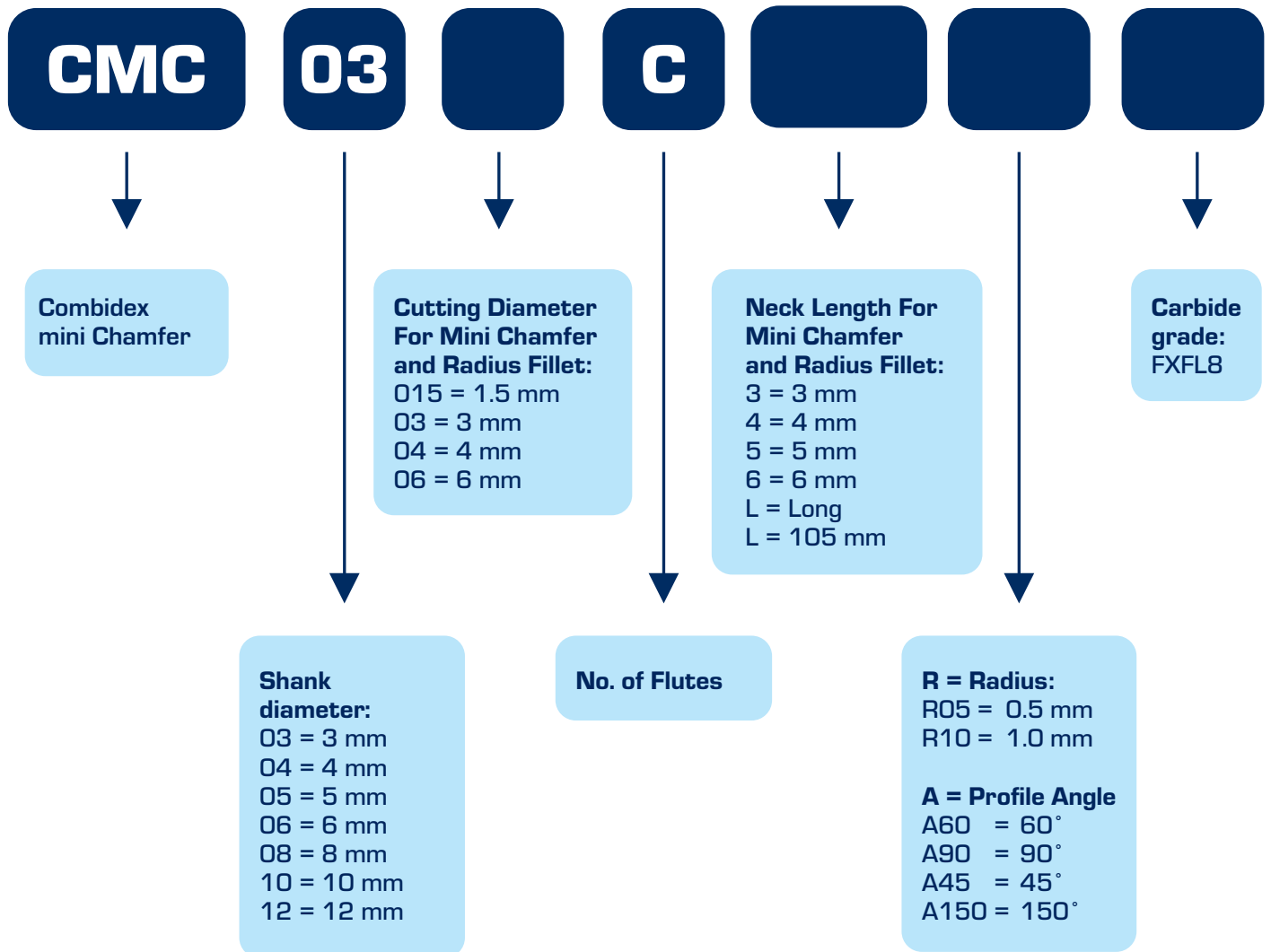
Sub-micron grade with advanced PVD triple coating (ISO K10-K20). Extremely high heat resistant and smooth cutting operation, for high performance and normal machining condition. General purpose for all materials.

#### Advantages

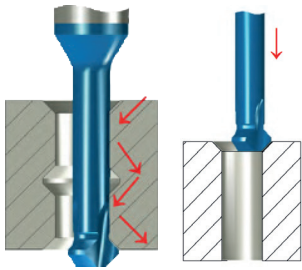
- Optimal for deburring, back chamfering and grooving.
- Double side cutting.
- Spiral flute allows smooth cutting action.



## 1.2 MINI CHAMFER | Ordering codes



# 1.3 MINI CHAMFER | 90° & LONG REACH 90°



Grade	P	M	K	N	S	H
FXFL8	●	●	●	○	●	≤50 HRc

## 90°

Ordering code	DCON	DC	LF	APMX	PL	Y°	No. of Flutes	OAL
CMC 03015 C3 A90	3	1.5	3.8	0.3	0.4	90°	3	39
CMC 0302 C5 A90	3	2.0	5.0	0.4	0.5	90°	3	39
CMC 03025 C6 A90	3	2.5	6.3	0.5	0.6	90°	3	39
CMC 0303 C7 A90	3	3.0	7.5	0.6	0.7	90°	3	39
CMC 04035 C9 A90	4	3.5	8.8	0.7	0.8	90°	3	51
CMC 0404 C10 A90	4	4.0	10.0	0.8	0.9	90°	3	51
CMC 05045 C11 A90	5	4.5	11.3	1.0	1.1	90°	3	51
CMC 0505 C12 A90	5	5.0	12.5	1.1	1.2	90°	3	51
CMC 06055 C13 A90	6	5.5	13.8	1.2	1.3	90°	3	51
CMC 0606 C15 A90	6	6.0	15.0	1.5	1.6	90°	3	51

## LONG REACH 90°

Ordering code	DCON	DC	LF	APMX	PL	Y°	No. of Flutes	OAL
CMC 0303 C12 A90	3	3.0	12.0	0.6	0.7	90°	3	39
CMC 04035 C14 A90	4	3.5	14.0	0.7	0.8	90°	3	51
CMC 0404 C16 A90	4	4.0	16.0	0.8	0.9	90°	3	51
CMC 0404 C16L A90	4	4.0	16.0	0.8	0.9	90°	3	105
CMC 05045 C18 A90	5	4.5	18.0	1.0	1.1	90°	3	51
CMC 0505 C20 A90	5	5.0	20.0	1.1	1.2	90°	3	51
CMC 0505 C20L A90	5	5.0	20.0	1.1	1.2	90°	3	105
CMC 06055 C22 A90	6	5.5	22.0	1.2	1.3	90°	3	58
CMC 0606 C24 A90	6	6.0	24.0	1.5	1.6	90°	3	58
CMC 0606 C24L A90	6	6.0	24.0	1.5	1.6	90°	3	105
CMC 0808 D28 A90	8	8.0	28.0	1.6	1.7	90°	4	64
CMC 0808 D28L A90	8	8.0	28.0	1.6	1.7	90°	4	105
CMC 1010 E35 A90	10	10.0	35.0	1.8	1.9	90°	5	73
CMC 1212 F42 A90	12	12.0	42.0	2.1	2.2	90°	6	84

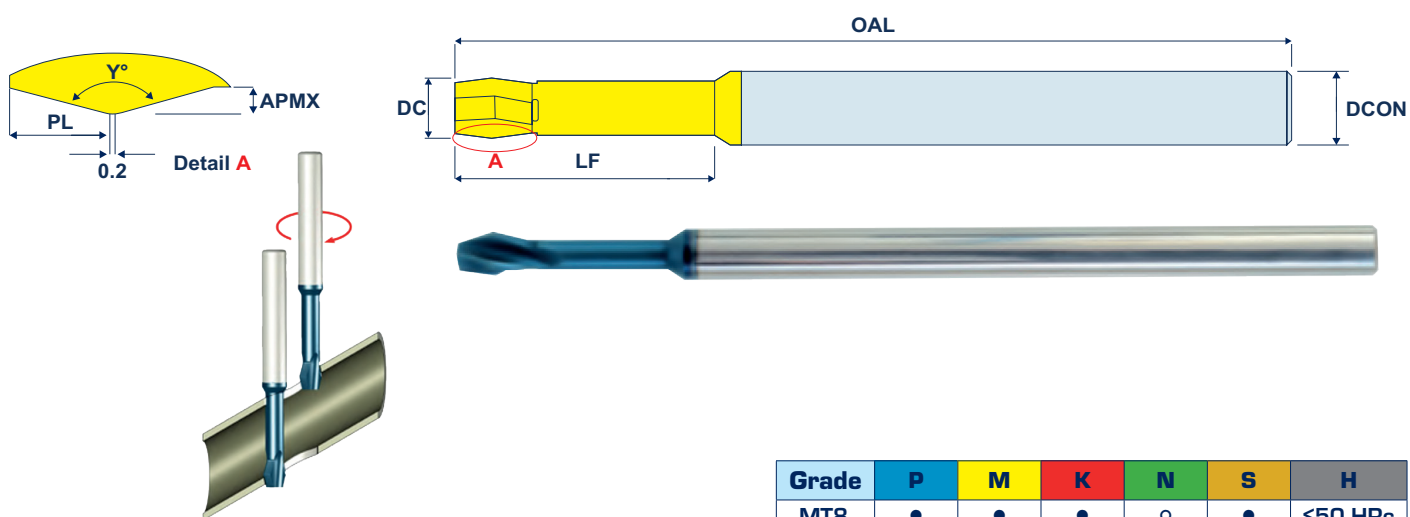
Order example: CMC 0302 C5 A90 FXFL8



# 1.4 MINI CHAMFER | 60° & 150°

## 60°

Ordering code	DCON	DC	LF	APMX	PL	Y°	No. of Flutes	OAL
CMC 0302 C5 A60	3	2.0	5.0	0.4	0.3	60°	3	39
CMC 0303 C7 A60	3	3.0	7.5	0.6	0.3	60°	3	39
CMC 04035 C9 A60	4	3.5	8.8	0.7	0.5	60°	3	51
CMC 0404 C10 A60	4	4.0	10.0	0.8	0.5	60°	3	51
CMC 05045 C11 A60	5	4.5	11.3	1.0	0.6	60°	3	51
CMC 0505 C12 A60	5	5.0	12.5	1.1	0.7	60°	3	51



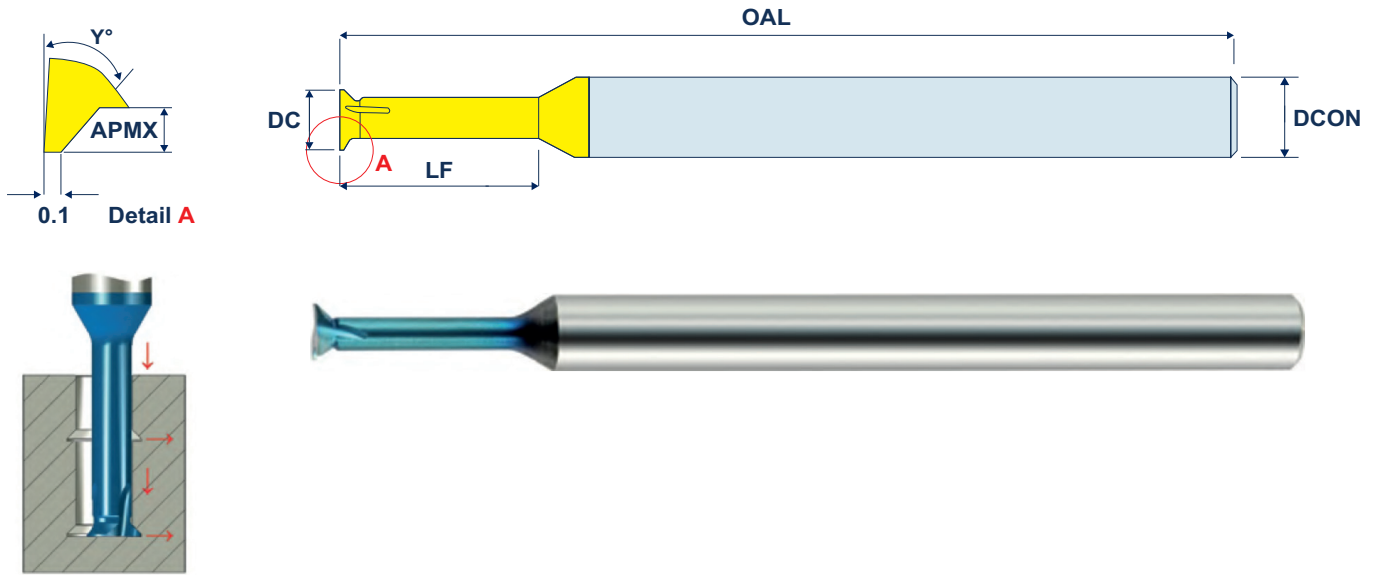
Grade	P	M	K	N	S	H
MT8	●	●	●	○	●	≤50 HRc

## 150°

Ordering code	DCON	DC	LF	APMX	PL	Y°	No. of Flutes	OAL
CMC 0303 C12 A150	3	3.0	12.0	0.6	2.2	150°	3	39
CMC 0404 C16 A150	4	4.0	16.0	0.8	3.0	150°	3	51
CMC 0404 C16L A150	4	4.0	16.0	0.8	3.0	150°	3	105
CMC 0505 C20 A150	5	5.0	20.0	1.0	3.8	150°	3	51
CMC 0505 C20L A150	5	5.0	20.0	1.0	3.8	150°	3	105
CMC 0606 C24 A150	6	6.0	24.0	1.0	3.8	150°	3	58
CMC 0606 C24L A150	6	6.0	24.0	1.0	3.8	150°	3	105
CMC 0808 C28 A150	8	8.0	28.0	1.0	3.8	150°	3	64
CMC 0808 C28L A150	8	8.0	28.0	1.0	3.8	150°	3	105

Order example: CMC 0303 C12 A150 FXFL8

# 1.5 MINI CHAMFER | Dovetail 45°



## Dovetail 45°

Grade	P	M	K	N	S	H
FXFL8	•	•	•	○	•	≤50 HRc

Ordering code	DCON	DC	LF	APMX	Y°	No. of Flutes	OAL
CMC 03015 C4 A45	3	1.5	4.5	0.3	45°	3	39
CMC 0302 C6 A45	3	2.0	6.0	0.4	45°	3	39
CMC 03025 C7 A45	3	2.5	7.5	0.5	45°	3	39
CMC 0303 C12 A45	3	3.0	12.0	0.6	45°	3	39
CMC 04035 C14 A45	4	3.5	14.0	0.7	45°	3	51
CMC 0404 C16 A45	4	4.0	16.0	0.8	45°	3	51
CMC 05045 C18 A45	5	4.5	18.0	1.0	45°	3	51
CMC 0505 C20 A45	5	5.0	20.0	1.1	45°	3	51
CMC 06055 C22 A45	6	5.5	22.0	1.2	45°	3	58
CMC 0606 C24 A45	6	6.0	24.0	1.5	45°	3	58

One side cutting

Order example: CMC 0303 C12 A45 FXFL8



# 1.6 MINI CHAMFER | Cutting data

ISO Standard	Material	Cutting Speed (m/min)	Feed mm/tooth Cutting Diameter=D												
			Ø1.5	Ø2	Ø3	Ø4	Ø5	Ø6	Ø7	Ø8	Ø9	Ø10	Ø12	Ø14	Ø16
<b>P</b>	LOW & MEDIUM CARBON STEELS <0.55%C	60 - 120	0.03	0.04	0.05	0.06	0.08	0.09	0.10	0.11	0.11	0.12	0.13	0.13	0.13
	HIGH CARBON STEELS ≥55%C	60 - 90	0.02	0.04	0.04	0.06	0.06	0.07	0.08	0.09	0.10	0.11	0.12	0.13	0.13
	ALLOY STEELS, TREATED STEELS	50 - 80	0.02	0.03	0.04	0.04	0.04	0.05	0.05	0.06	0.06	0.07	0.08	0.09	0.10
<b>M</b>	STAINLESS STEEL-FREE CUTTING	70 - 100	0.01	0.02	0.03	0.04	0.04	0.04	0.05	0.06	0.06	0.08	0.08	0.09	0.09
	STAINLESS STEEL-AUSTENITIC	60 - 90	0.01	0.02	0.03	0.04	0.04	0.04	0.05	0.06	0.06	0.08	0.08	0.09	0.09
	CAST STEELS	70 - 90	0.02	0.03	0.04	0.04	0.04	0.05	0.05	0.06	0.06	0.08	0.08	0.09	0.10
<b>K</b>	CAST IRON	40 - 80	0.03	0.04	0.05	0.06	0.08	0.09	0.10	0.11	0.11	0.12	0.13	0.13	0.13
	ALUMINIUM ≤12%SI, COPPER	100 - 200	0.03	0.04	0.05	0.06	0.08	0.09	0.10	0.11	0.11	0.12	0.13	0.13	0.13
<b>N</b>	ALUMINIUM >12%SI	60 - 140	0.02	0.02	0.03	0.04	0.04	0.04	0.05	0.06	0.07	0.08	0.09	0.10	0.10
	SYNTHETICS , DUROPLASTICS, THERMOPLASTICS	50 - 200	0.06	0.08	0.08	0.10	0.11	0.13	0.13	0.13	0.13	0.13	0.14	0.14	0.14
<b>S</b>	NICKEL ALLOYS, TITANIUM ALLOYS	20 - 40	0.02	0.02	0.03	0.03	0.04	0.04	0.04	0.05	0.05	0.06	0.06	0.06	0.06
<b>H</b>	HARDENED STEEL 45-50 HRC	60 - 70	0.02	0.03	0.04	0.04	0.04	0.04	0.05	0.06	0.06	0.06	0.07	0.08	0.08

**Combidex**

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