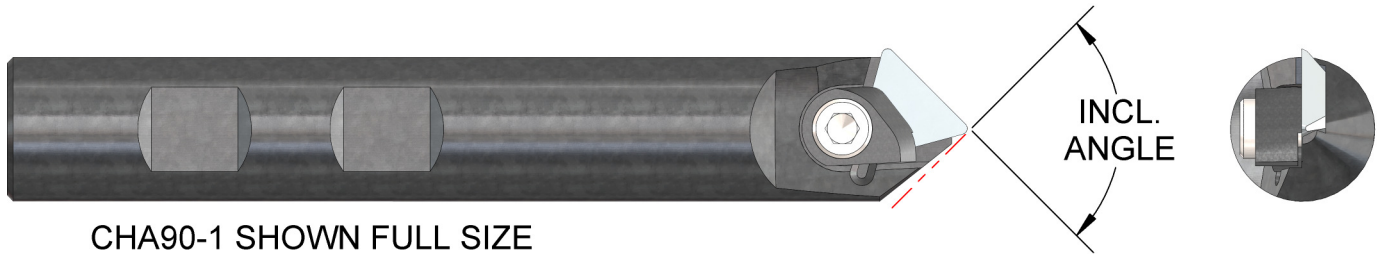


# The Single Flute Chamfer Hogs



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 have 3/4 shanks and are 5" overall.

All Single Flute Chamfer-Hogs, including inserts, are **\$205.** ea.

Number	Included Angle	Maximum Chamfer Diameter	Insert	Clamp	Insert Prices	
CHA90-1	90°	.800	TFG32-90	CL-4	TFG32-90	<b>\$13.75</b>
CHA82-1	82°	.730	TFG32-90	CL-4	TFG32-90T (TiN Coated)	<b>\$16.00</b>
CHA100-1	100°	.940	TFG32-90	CL-4	TD6P-120	<b>\$15.00</b>
CHA120-1	120°	1.00	TD6P-120	5-40		
CHA60-1*	60°	1.00	TFG32-90	CL-4		

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

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

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

TFG-322 and TD-6P are Industry Standard Inserts modified with a secondary facet near the point to prevent "heeling".



A. B. TOOLS, INC.  
1051 Aviation Blvd.  
Lincoln, CA 95648-9312

Phone 916 408-2442  
FAX 916 993-3949

www.abtoolsinc.com  
E-Mail: mail@abtoolsinc.com