



Caution: holding of tubing by hand is not recommended.

Tube End Chamfering Mills

The Chatterless™ design of the Tube End Chamfering Mills have cutting edges designed to provide a shearing action, yielding a smoothly machined surface. The standard tool produces a 30° angle on the tube inside diameter and 45° on the outside diameter. Other angles may be ordered as specials. This series of tools is offered in a range of sizes to accommodate pipe and tubing from 3/16" to 2-1/2" outside diameters. All models are adjustable for different wall thicknesses. The cutting teeth are developed as to preclude chatter and provide ample chip room for every operating condition. Moderate speeds of about 100 R.P.M. for 1-inch steel tubing to about 200 R.P.M. for 1/2-inch tubing are recommended for these cutters. It is advisable to start at a slower speed on any given material or size and increase until best results are obtained.

High Speed Steel

30° C/L inside diameter & 45° C/L outside diameter.

Std Pipe Size	Std. Tubing O.D. Size	Wall Thickness		Plug Dia.	Shank Dia.	Shank Length	Severance Tool Name	EDP Order Number
		Min.	Max.					
1/8"	3/16"	.022"	.045"	.152"	1/4"	7/8"	T-6	34960
	1/4"	.022"	.065"	.228"	1/4"	1"	T-8	34961
	5/16"	.022"	.095"	.290"	1/4"	1"	T-10	34962
	3/8"	.022"	.095"	.353"	3/8"	1"	T-12	34963
	7/16"	.028"	.095"	.409"	3/8"	1"	T-14	34964
1/4"	1/2"	.028"	.095"	.472"	3/8"	1"	T-16	34965
	9/16"	.028"	.120"	.534"	1/2"	1"	T-18	34966
3/8"	5/8"	.028"	.120"	.597"	1/2"	1"	T-20	34967
1/2"	3/4"	.028"	.120"	.722"	1/2"	1"	T-24	34968
	7/8"	.022"	.156"	.847"	1/2"	1"	T-28	34969
3/4"	1"	.035"	.156"	.965"	1/2"	1-5/16"	T-32	34970
	1-1/8"	.035"	.187"	1.090"	1/2"-20	-	T-36	34971
	1-1/4"	.035"	.187"	1.215"	5/8"-18	-	T-40	34972
	1-5/16"	.035"	.187"	1.280"	5/8"-18	-	T-42	34973
	1-3/8"	.035"	.187"	1.340"	5/8"-18	-	T-44	34974
1"	1-1/2"	.035"	.250"	1.465"	3/4"-16	-	T-48	34975
	1-5/8"	.035"	.250"	1.590"	3/4"-16	-	T-52	34976
	1-3/4"	.035"	.250"	1.715"	3/4"-16	-	T-56	34977
	1-7/8"	.035"	.250"	1.840"	3/4"-16	-	T-60	34978
	2"	.035"	.312"	1.965"	1"-14	-	T-64	34979
2"	2-1/4"	.058"	.312"	2.195"	1"-14	-	T-72	34980
	2-3/8"	.065"	.375"	2.310"	1"-14	-	T-76	34981
	2-1/2"	.065"	.375"	2.435"	1"-14	-	T-80	34982

Tool numbers T-36 thru T-80 require threaded shanks, priced separately. See pages 78-80 for available shank styles and sizes.