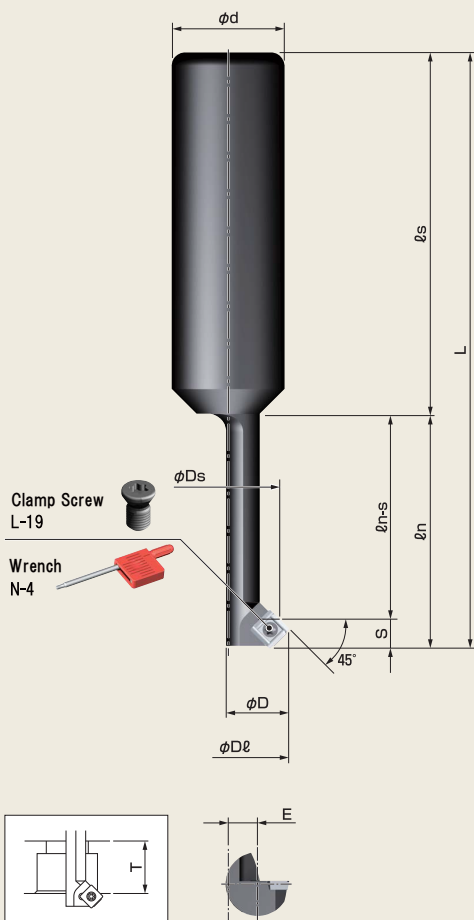


## Exclusive Cutter for Back Counter Bore processing!

- Chamfering can be done for Counter Boring mouth
- Designed for Cap bolt sizes
- M14, M16, M18 and M20 Back Counter Bore Cutters are available

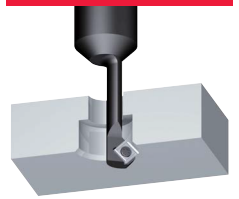


Clamp Screw L-19

Wrench N-4

Model. No.	Hole diameter	Capacity
		Bore chamfering
UMZH25-16S-M14CS	φ16mm	φ23mm~φ27mm
UMZH25-18S-M16CS	φ18mm	φ26mm~φ30mm
UMZH32-20S-M18CS	φ20mm	φ29mm~φ33mm
UMZH32-22S-M20CS	φ22mm	φ32mm~φ36mm

Reverse chamfering



### Cutting Conditions

Material	Material Model	NK1010	NK2020	NK6060
General steel	0.03~0.05	—	25~30	25~30
Alloy steel	0.03~0.05	—	25~30	25~30
Stainless steel	0.03~0.05	—	20~25	25~30
Aluminum, resin, brass	0.03~0.05	30~40	—	—
Cast steel	0.03~0.05	10~30	—	—

● Coolant will be recommended

### Body

Model. No.	Blades	Dimensions (mm)										
		φD	φDℓ	φDs	φd	L	ℓs	ℓn	ℓn-s	S	T	E
NEW UMZH25-16S-M14CS	1	14	27	23	25	132	80	52	45.5	6.5	40	6.52
NEW UMZH25-18S-M16CS	1	16	30	26	25	142	80	62	55.5	6.5	50	7.01
NEW UMZH32-20S-M18CS	1	18	33	29	32	154	80	74	67.5	6.5	61	7.51
NEW UMZH32-22S-M20CS	1	20	36	32	32	164	80	84	77.5	6.5	71	8.01

※ Inset is not supplied as standard accessory. Please order separately.  
※ Clamp screw and wrench are supplied as standard accessory.

### Processing Example

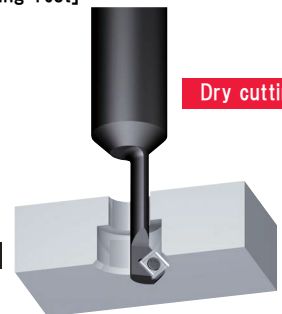
#### [Eccentric Back Counter Bore mouth Chamfering-Test]

- Body : UMZH25-16S-M14CS
- Inset : SPET06T104 NK2020

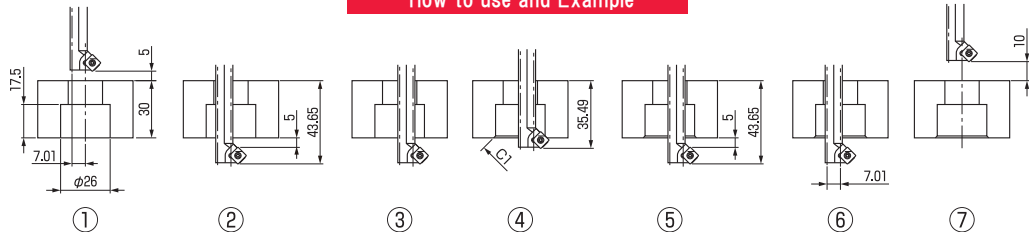
- Material ..... 50C
- Rotation Speed ... 420r.p.m.
- Cutting Speed .... 30m/min
- Table Feed ..... 21/min
- Blade Feed ..... 0.05mm/tooth
- Hole diameter .... 23mm
- Cutting Depth .... 1mm

Result

Good!  
Without secondary burrs and chattering



### How to use and Example



※ Correction will be necessary according to the specification of the machines to be used when using this cutter

### Example program [UMZH25-18S-M16CS(M16)]

- N10
- G90 G00 G54 X-7.01 Y0 M19
- G43 Z5.0 H3 T11.....①
- Z-43.65.....②
- X0.....③
- M3 S370
- G01 Z-35.49 F19.....④
- Z-43.65 F200.....⑤
- M19
- G00 X-7.01.....⑥
- Z10.0.....⑦
- G91 G30 Z0

Max. processing thickness: T  
Chamfer amount: C Z = -(T+S-C)

### Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
<p>(SPET06T104)</p>	SPET06T104 NK1010	Carbide K10	Sharp edge	None	4	12
	SPET06T104 NK2020	Carbide M20	Honing edge	None	4	12
	SPET06T104 NK6060	Carbide M20	Honing edge	TiAlN	4	12