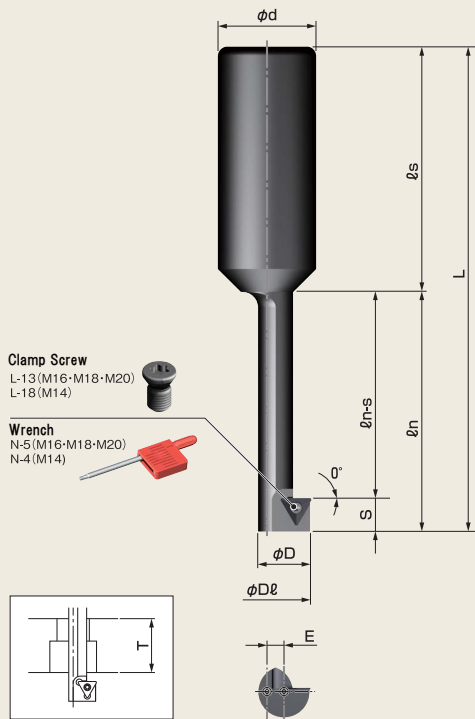


TA type Back Counter Bore Cutter!

- Back Counter Bore processing are ensured without turning workpiece
- Designed for Cap bolt sizes
- M14, M16, M18 and M20 Back Counter Bore Cutters are available



Cutting Conditions

Material	Material Model	AC15N	ZA10N
		Feed per blade (fz)	Cutting speed (m / min)
General steel	0.03~0.05	15~20	—
Alloy steel	0.03~0.05	15~20	—
Aluminum, resin, brass	0.03~0.05	—	35~80
Cast steel	0.03~0.05	30~40	—

● Coolant will be recommended

Back Counter Bore processing



Body

Model. No.	Blades	Dimensions (mm)									
		φD	φDl	φd	L	ls	ln	ln-s	S	T	E
NEW UZH25-16T-M14CS	1	14	23	25	133	80	53	45	8	40	4.55
NEW UZH25-18T-M16CS	1	16	26	25	146	80	66	55	11	50	5.04
NEW UZH32-20T-M18CS	1	18	29	32	158	80	78	67	11	61	5.54
NEW UZH32-22T-M20CS	1	20	32	32	168	80	88	77	11	71	6.03

※ 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 Cutter-TEST]

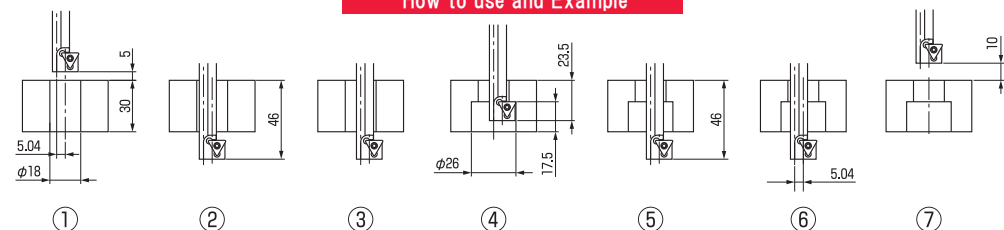
- Body : UMZH25-16S-M14CS
- Insert : SPET06T104 NK2020
- Material : S50C
- Rotation Speed : 415r.p.m.
- Cutting Speed : 30m/min
- Table Feed : 12.45mm/min
- Blade Feed : 0.03mm/tooth
- Hole diameter : 16mm
- Cutting Depth : 15.2mm



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 [UZH25-18T-M16CS(M16)]

- N10
- G90 G00 G54 X-5.04 Y0 M19
- G43 Z5.0 H3 T11.....①
- Z-46.0 F200.....②
- X0.....③
- M3 S415
- M8
- G01 Z-23.5 F12.....④
- Z-46.0 F200.....⑤
- M19
- G00 X-5.04.....⑥
- Z10.0.....⑦
- G91 G30 Z0

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

Insert

Figure	Model.No.	Material	Blade Shape	Coating	Usable corner	Quantity per box
● M14 	TXMT080206 ZA10N	Carbide K10	Sharp edge	None	3	12
	TXMT080206 AC15N	Fine particles Carbide	Honing edge	AlCrN	3	12
● M16-M18-M20 	TXMT110306 ZA10N	Carbide K10	Sharp edge	None	3	12
	TXMT110306 AC15N	Fine particles Carbide	Honing edge	AlCrN	3	12