**Bit type Back Counter Bore Cutter!**

- Back Counter Bore processing are ensured without turning workpiece.
- Designed for Cap bolt sizes M6, M8, M10, and M12. Back Counter Bore Cutters are available.

### Cutting Conditions

<table>
<thead>
<tr>
<th>Material</th>
<th>General Steel</th>
<th>Alloy Steel</th>
<th>Stainless Steel</th>
<th>Aluminum, resin, brass</th>
<th>Cast Steel</th>
</tr>
</thead>
<tbody>
<tr>
<td>Feed per blade (Tz)</td>
<td>0.06 ~ 0.12</td>
<td>0.06 ~ 0.12</td>
<td>0.02 ~ 0.05</td>
<td>0.08 ~ 0.12</td>
<td>0.08 ~ 0.12</td>
</tr>
<tr>
<td>Cutting speed (m/min)</td>
<td>30 ~ 50</td>
<td>30 ~ 50</td>
<td>20 ~ 40</td>
<td>60 ~ 90</td>
<td>30 ~ 50</td>
</tr>
</tbody>
</table>

- Coating
  - None
  - Al2O3N

### Body

**Material**
- General steel
- Alloy steel
- Stainless Steel
- Aluminum, resin, brass

**Coating**
- None
- Al2O3N

**Material Model**
- Stainless Steel
- Coating
- None

**Blades**
- Number: 1
- Material: S50C
- Coating: None
- Cutting speed: 20 m/min
- Feed per blade: 0.03 mm/tooth
- Table Feed: 10 mm/min
- Tool Finish: 0.03 mm/tooth
- Hold diameter: 14 mm
- Cutting depth: 13 mm

**Dimensions (mm)**

<table>
<thead>
<tr>
<th>Model No.</th>
<th>φD</th>
<th>φdx</th>
<th>φDx</th>
<th>L</th>
<th>a</th>
<th>a-s</th>
<th>S</th>
<th>T</th>
<th>E</th>
</tr>
</thead>
<tbody>
<tr>
<td>UZHS-M6</td>
<td>5.6</td>
<td>11</td>
<td>20</td>
<td>106</td>
<td>80</td>
<td>26</td>
<td>20.5</td>
<td>5.5</td>
<td>15</td>
</tr>
<tr>
<td>UZHS-M8</td>
<td>8</td>
<td>14</td>
<td>25</td>
<td>113</td>
<td>80</td>
<td>33</td>
<td>25.5</td>
<td>7.5</td>
<td>20</td>
</tr>
<tr>
<td>UZHS-M10</td>
<td>10</td>
<td>17.5</td>
<td>32</td>
<td>140</td>
<td>100</td>
<td>40</td>
<td>30.5</td>
<td>9.5</td>
<td>25</td>
</tr>
<tr>
<td>UZHS-M12</td>
<td>13</td>
<td>20</td>
<td>32</td>
<td>152</td>
<td>100</td>
<td>52</td>
<td>40.5</td>
<td>11.5</td>
<td>35</td>
</tr>
</tbody>
</table>

- Inset is not supplied as standard accessory. Please order separately.
- Set screw and wrench are supplied as standard accessory.

### Processing Example

**Insert:** UZHS-M12

- Material: S50C
- Rotation speed: 320 rpm
- Cutting speed: 20 m/min
- Feed: 10 mm/min
- Blade feed: 0.03 mm/tooth
- Hold diameter: 14 mm
- Cutting depth: 13 mm

**How to use and Example**

**Figure**

- Insert
- Body: UZHS-M12
- Set screw

**Detailed Table**

<table>
<thead>
<tr>
<th>Figure</th>
<th>Model No.</th>
<th>D</th>
<th>L</th>
<th>Material</th>
<th>Coating</th>
<th>Usable corner</th>
<th>Quantity per box</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>UZHS-M6B</td>
<td>5.6</td>
<td>46</td>
<td>Fine particles Carbide</td>
<td>None</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>2</td>
<td>UZHS-M8B</td>
<td>8</td>
<td>53</td>
<td>Fine particles Carbide</td>
<td>None</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>3</td>
<td>UZHS-M10B</td>
<td>10</td>
<td>65</td>
<td>Fine particles Carbide</td>
<td>None</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>4</td>
<td>UZHS-M12B</td>
<td>13</td>
<td>80</td>
<td>Fine particles Carbide</td>
<td>None</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>5</td>
<td>UZHS-M12C</td>
<td>5.6</td>
<td>46</td>
<td>Fine particles Carbide</td>
<td>AICN</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>6</td>
<td>UZHS-M12C</td>
<td>10</td>
<td>65</td>
<td>Fine particles Carbide</td>
<td>AICN</td>
<td>1</td>
<td>1</td>
</tr>
<tr>
<td>7</td>
<td>UZHS-M12C</td>
<td>13</td>
<td>80</td>
<td>Fine particles Carbide</td>
<td>AICN</td>
<td>1</td>
<td>1</td>
</tr>
</tbody>
</table>