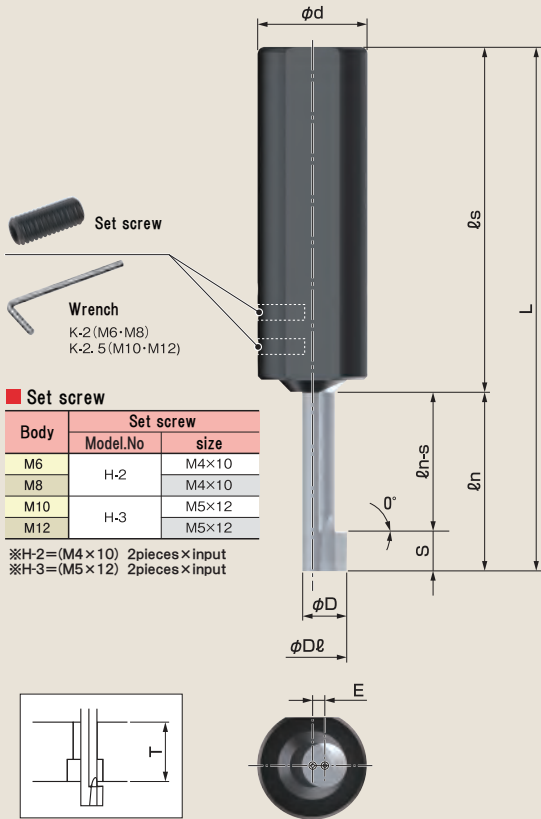


## Bit type Back Counter Bore Cutter!

- 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



### Set screw

Body	Set screw	
	Model.No	size
M6	H-2	M4×10
M8		M4×10
M10	H-3	M5×12
M12		M5×12

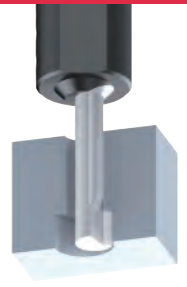
※H-2=(M4×10) 2pieces×Input  
※H-3=(M5×12) 2pieces×Input

### Cutting Conditions

Material	Material Model	Coating	
		None	AlCrN
General steel	0.08~0.12	—	30~50
Alloy steel	0.08~0.12	—	30~50
Stainless Steel	0.02~0.05	—	20~40
Aluminum, resin, brass	0.08~0.12	60~90	—
Cast steel	0.08~0.12	30~50	—

● Coolant will be recommended

### Back Counter Bore processing



### Body

Model. No.	Blades	Dimensions (mm)									
		$\phi D$	$\phi D\ell$	$\phi d$	L	$\ell_s$	$\ell_n$	$\ell_{n-s}$	S	T	E
NEW UZHS-M6	1	5.6	11	20	106	80	26	20.5	5.5	15	2.7
NEW UZHS-M8	1	8	14	25	113	80	33	25.5	7.5	20	3
NEW UZHS-M10	1	10	17.5	32	140	100	40	30.5	9.5	25	3.75
NEW UZHS-M12	1	13	20	32	152	100	52	40.5	11.5	35	3.5

※ Inset is not supplied as standard accessory. Please order separately.

※ Set screw and wrench are supplied as standard accessory.

### Processing Example

#### [Eccentric Back Counter Bore Cutter-TEST]

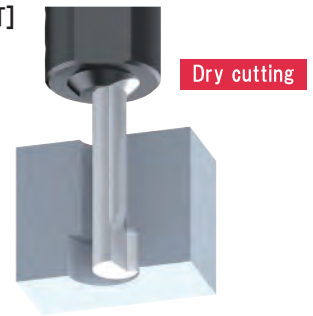
● Body : UZHS-M12

● Inset : UZHS-M12B

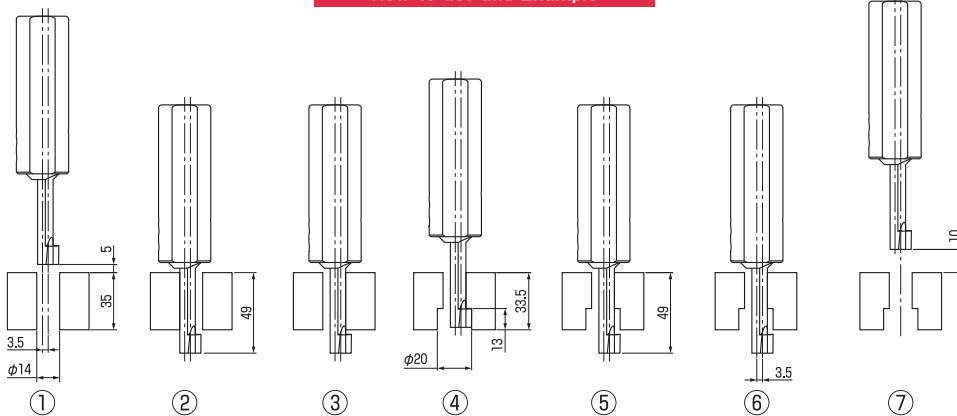
- Material ..... S50C
- Rotation Speed ... 320r.p.m.
- Cutting Speed .... 20m/min
- Table Feed ..... 10mm/min
- Blade Feed ..... 0.03mm/tooth
- Hole diameter .... 14mm
- Cutting Depth .... 13mm

#### 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 [UZHS-M12]

- N10
- G90 G00 G54 X-3.5 Y0 M19
- G43 Z5.0 H3 T11.....①
- Z-49.0 F200.....②
- X0.....③
- M3 S320
- M8
- G01 Z-33.5 F22.....④
- Z-49.0 F200.....⑤
- M19
- G00 X-3.5.....⑥
- Z10.0.....⑦
- G91 G30 Z0

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

### Insert

Figure	Model.No.	D	L	Material	Coating	Usable corner	Quantity per box
	UZHS-M6B	5.6	46	Fine particles Carbide	None	1	1
	UZHS-M8B	8	53	Fine particles Carbide	None	1	1
	UZHS-M10B	10	65	Fine particles Carbide	None	1	1
	UZHS-M12B	13	80	Fine particles Carbide	None	1	1
	UZHS-M6BC	5.6	46	Fine particles Carbide	AlCrN	1	1
	UZHS-M8BC	8	53	Fine particles Carbide	AlCrN	1	1
	UZHS-M10BC	10	65	Fine particles Carbide	AlCrN	1	1
	UZHS-M12BC	13	80	Fine particles Carbide	AlCrN	1	1