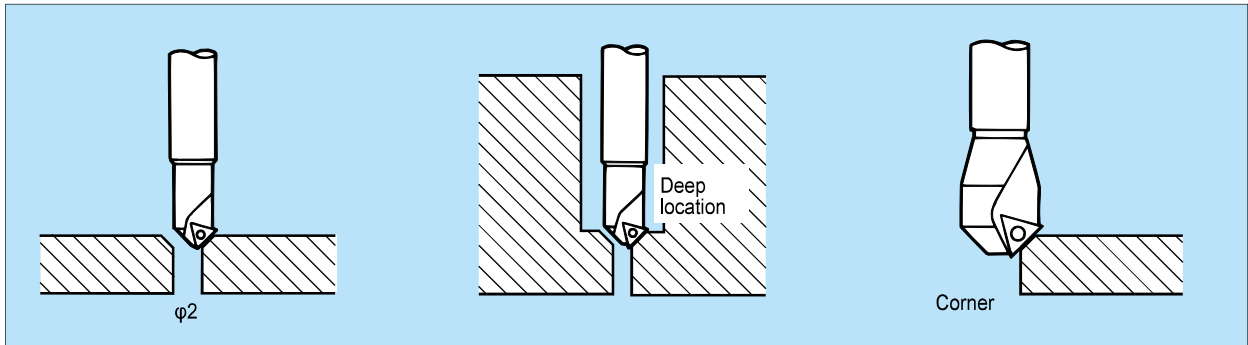


Chamfering Cutter Series

FM BM BZ

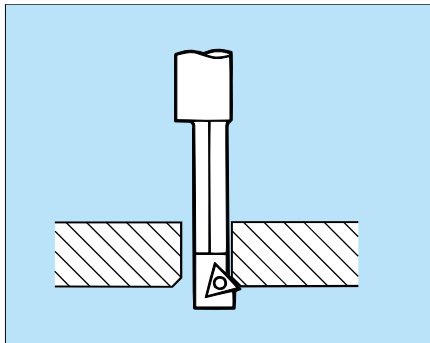
Chamfering cutter FM



Application

Chamfering, countersinking and corner rounding with machining center and milling machine.

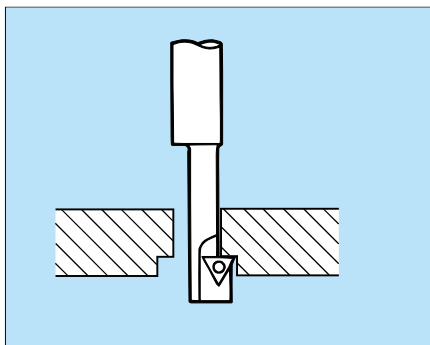
Back chamfering BM



Application

Back chamfering with axially adjustable machines such as machining center and milling machine.

Back spot-facing BZ

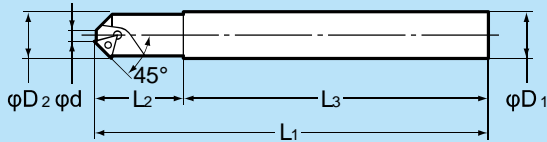


Application

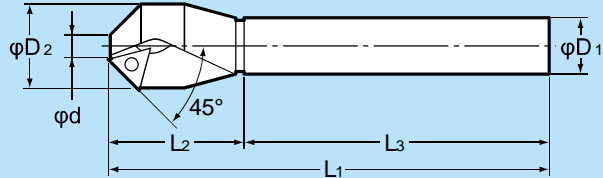
Back spot-facing with axially adjustable machines such as machining center and milling machine.

Chamfering Cutter FM

Type1



Type2


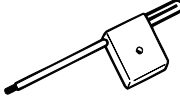




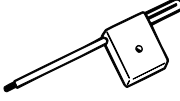

Model	Type	Chamfering dia	φD ₁	φD ₂	L ₁	L ₂	L ₃	kg	Insert No.
FM 0209	1	2~ 9	12	12	140	40	100	0.12	No.520
FM 0514	1	5~14	16	16	160	60		0.23	
FM 1030	2	10~30	20	32	167	47	120	0.41	No.504

*Indexable inserts are sold separately.
Wrench and screw are included.

● All dimensions shown in millimeters.

Accessories

Insert	Wrench	Clamp screw
 No.520	 LT-6	 CB1-20043-T6

Insert	Wrench	Clamp screw
 No.504	 LT-15	 CB1-3507

*Indexable inserts 10pcs / set.

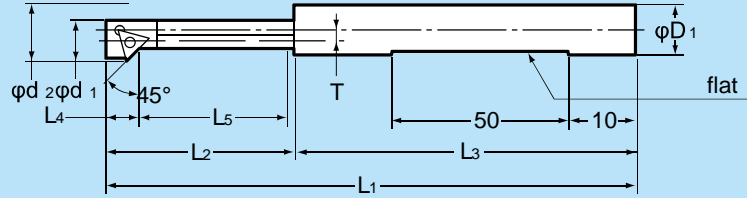
Recommended cutting conditions

Workpiece Cutter	S45C		FC250		A2017 (Aluminum)	
	Revolution (min ⁻¹)	Feed/rev. (mm/rev)	Revolution (min ⁻¹)	Feed/rev. (mm/rev)	Revolution (min ⁻¹)	Feed/rev. (mm/rev)
FM 0209	2100	0.1	2100	0.1	3000	0.1
FM 0514	1300	0.1	1300	0.1	1800	0.1
FM 1030	1000	0.15	1000	0.15	1300	0.15

Ordering Example

FM0209

Back Chamfering Cutter BM



Model	ϕd_1	ϕd_2	T	ϕD_1	L1	L2	L3	L4	L5	kg	Insert No.
BM 068095	6.8	9.5	1.8	12.0	109	39		5	32	0.07	TBGT060102 R
BM 085115	8.5	11.5	2.1		119	49			42		
BM 100140	10.0	14.0	2.8	16.0	131	61	70	7	52	0.13	TPMT09020 2
BM 120160	12.0	16.0			136	66			57	0.14	
BM 140185	14.0	18.5	3.2	20.0	142	72		8	62	0.21	TPGT110202 R
BM 160205	16.0	20.5			152	82			72	0.24	

*Indexable inserts are not included.
Wrench and clamp screw are included.

• All dimensions shown in millimeters.

Accessories

 Wrench	Model	Insert No.
	LT-6	TBGT060102 R
	LT-7	TPMT09020 2
	LT-8	TPGT110202 R

 Clamp screw	Model	Insert No.
	CB1-20043-T6	TBGT060102 R
	CB1-22046-T7	TPMT09020 2
	CB1-25048-T8	TPGT110202 R

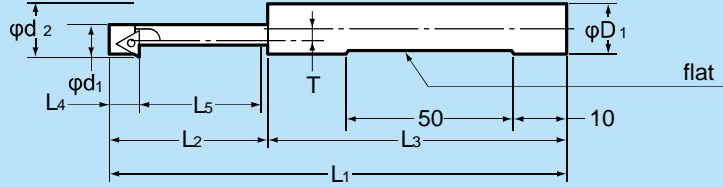
Recommended cutting conditions

Cutter \ Workpiece	S45C		FC250		A2017 (Aluminum)	
	Revolution (min ⁻¹)	Feed/rev. (mm/rev)	Revolution (min ⁻¹)	Feed/rev. (mm/rev)	Revolution (min ⁻¹)	Feed/rev. (mm/rev)
BM 068095	1450	0.05	1450	0.05	1450	0.10
BM 085115	1250	0.05	1250	0.07	1250	0.10
BM 100140	1250	0.07	1250	0.07	1500	0.10
BM 120160	1000	0.07	1000	0.10	1300	0.10
BM 140185	750	0.07	750	0.10	1100	0.10
BM 160205	670	0.15	670	0.15	1000	0.15

Ordering Example

BM068095

Back Spot-facing Cutter BZ



Model	ϕd_1	ϕd_2	T	ϕD_1	L ₁	L ₂	L ₃	L ₄	L ₅	kg	Insert No.
BZ 070110	7.0	11	2.6	12	106	36	70	7	27	0.07	EPGT040102R
BZ 085140	8.5	14	3.3		111	41		8	32	0.07	TBGT060102R
BZ 105170	10.5	17	3.8	16	116	46		9	37	TPGT080202R	
BZ 130190	13.0	19			122	52		12	52		TPGT110202R
BZ 170250	17.0	25	4.8	20	135	65			72		
BZ 210310	21.0	31	5.8	25	155	85					

*Indexable inserts are not included.
Wrench and clamp screw are included.

● All dimensions shown in millimeters.

Accessories

 Wrench	Model	Insert No.
	LT-6	EPGT040102R
		TBGT060102R
		TPGT080202R
LT-8	TPGT110202R	

 Clamp screw	Model	Insert No.
	CB1-20033-T6	EPGT040102R
	CB1-20043-T6	TBGT060102R
		TPGT080202R
CB1-25048-T8	TPGT110202R	

Recommended cutting conditions

Cutter \ Workpiece	S45C		FC250		A2017(Aluminum)	
	Revolution (min ⁻¹)	Feed/rev. (mm/rev)	Revolution (min ⁻¹)	Feed/rev. (mm/rev)	Revolution (min ⁻¹)	Feed/rev. (mm/rev)
BZ 070110	1160	0.03	950	0.06	1400	0.05
BZ 085140	830	0.05	750	0.08	1350	0.06
BZ 105170	750	0.05	750	0.08	1100	0.08
BZ 130190	670	0.07	600	0.12	1000	0.10
BZ 170250	550	0.08	550	0.12	760	0.12
BZ 210310	400	0.11	400	0.16	600	0.16

Ordering Example

BZ070110