

Center and Chamfer in one **CENTER BOY**



Accurate centering and chamfering can be obtained in a single operation.

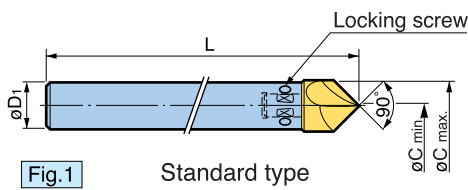
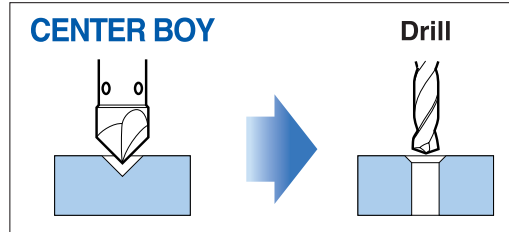


Fig.1 Standard type

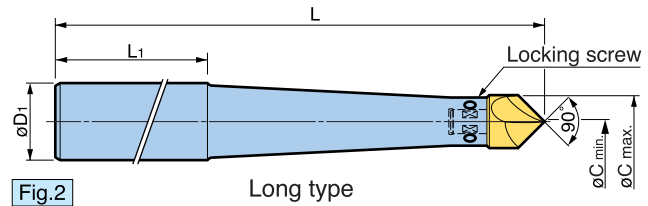


Fig.2 Long type

● in the table indicates Long Type

Chamfer		Model	Fig.	ϕD_1	L	L ₁	Insert Model	Spare Locking Screw
ϕC_{min}	ϕC_{max}							
0.9	10	ST10-CBY09010	1	10	150	-	CBY09010	H0403-5P
0.9	13	ST12-CBY09013		12				
1.0	16	ST16-CBY09016		16				
1.5	22	ST20-CBY09022		20				
0.9	13	ST20-CBY09013-220 ●	2	20	220	120	CBY09013	H0403-5P
		-260 ●		260				
1.5	22	ST32-CBY09022-260 ●		32	260		300	CBY09022
		-300 ●	300					

- 1. 2 pcs of Inserts are included as standard accessories.
- 2. 2 pcs. of Locking Screws are included. Spare Locking Screws are available in a packet of 5 pcs.

⚠ Hand feed is not recommended.

Insert



Model	CENTER BOY
CBY09010	ST10-CBY09010
CBY09013	ST12-CBY09013 / ST20-CBY09013
CBY09016	ST16-CBY09016
CBY09022	ST20-CBY09022 / ST32-CBY09022

- 1. Inserts are available in packages of 5 pcs.
- 2. Insert Grade is HSS with TiN coating.



Highly accurate
Replaceable Insert

Recommended cutting condition

Work Material	Cutter Type	Chamfering		Centering	
		Vc (m/min)	f (mm/rev)	Vc (m/min)	f (mm/rev)
General steel Alloy steel	Standard	20-35	0.10	25-50	0.08
	long	20-35	0.08	20-50	0.08
Stainless steel	Standard	15-30	0.08	20-40	0.08
	long	15-30	0.06	15-30	0.06
Cast iron	Standard	20-40	0.12	30-45	0.10
	long	20-40	0.10	30-45	0.10
Aluminum	Standard	45-60	0.15	50-65	0.15
	long	40-60	0.12	40-60	0.12

Vc: Cutting speed (m/min.) f: Feed per revolution (mm/rev.)

- 1. The table is just a reference to determine cutting conditions. It should be adjusted according to the condition of the machine tool and workpiece.
- 2. In case vibration occurs, reduce cutting speed V.
- 3. Tool extension should be as short as possible.