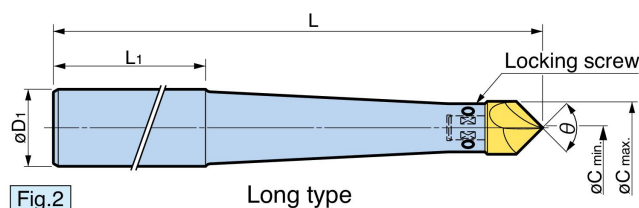
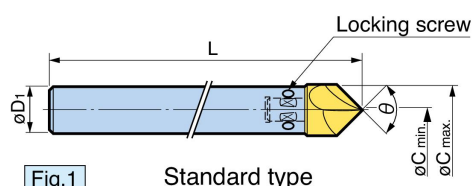
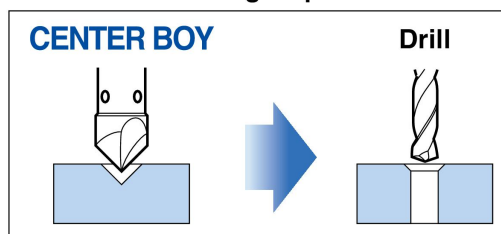


Center and Chamfer in one

CENTER BOY

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



● in the table indicates Long Type

Chamfering Angle θ	Chamfer		Model	Fig.	ϕD_1	L	L ₁	Insert Model	Spare Locking Screw
	ϕC_{min}	ϕC_{max}							
90°	0.9	10	ST10-CBY09010	1	10	150	-	CBY09010	H0403-5P
	0.9	13	ST12-CBY09013		12			CBY09013	
	1.0	16	ST16-CBY09016		16	180		CBY09016	H0504-5P
	1.5	22	ST20-CBY09022		20			CBY09022	H0505-5P
	0.9	13	ST20-CBY09013-220 ●	2	20	220	120	CBY09013	H0403-5P
			-260 ●			260			
	1.5	22	ST32-CBY09022-260 ●		32	260	120	CBY09022	H0505-5P
			-300 ●			300			
120°	0.9	13	ST12-CBY12013	1	12	150	-	CBY12013	H0403-5P

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

Chamfering Angle θ	Model	CENTER BOY
90°	CBY09010	ST10-CBY09010
	CBY09013	ST12-CBY09013 / ST20-CBY09013
	CBY09016	ST16-CBY09016
	CBY09022	ST20-CBY09022 / ST32-CBY09022
120°	CBY12013	ST12-CBY12013

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	
		V (m/min)	f (mm/rev)	V (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

V: 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. Projection length should be as short as possible.