

UFO BACK BORING



PATENTED

Features

Available in
materials



Cost
200~300%
SAVING

Applicable
Machines
CNC Milling machine
Drilling M/C

Efficiency
400%
UP

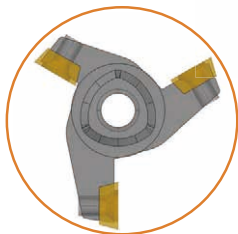
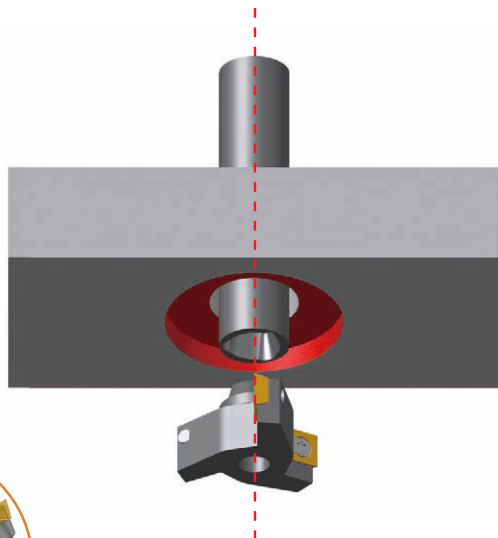
Durability
300%
UP

UFO
A Type
Back Boring
Cutter

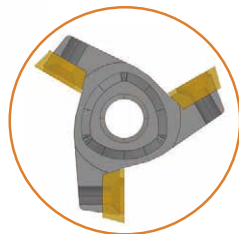
UFO



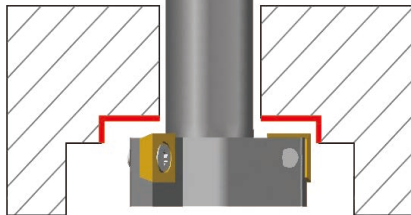
UFO Family



Inserts set at unequal distance from the center. Applicable with cutter $\varnothing 23$ - $\varnothing 60$ mm.



Inserts set at equal distance from the center. Applicable with cutter $\varnothing 18$ - $\varnothing 22$ mm

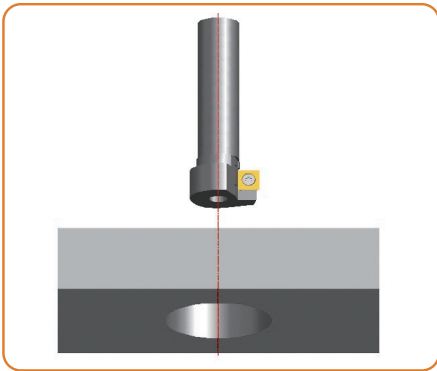


UFO
B Type
Back Boring
Cutter

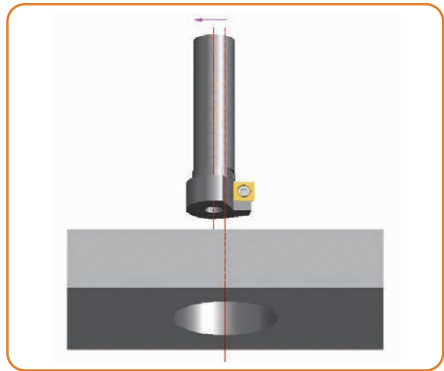
UFO



1. Centerline



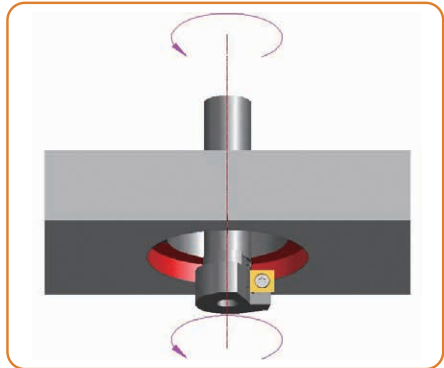
2. Tool displacement



3. Machining



4. Back to center line

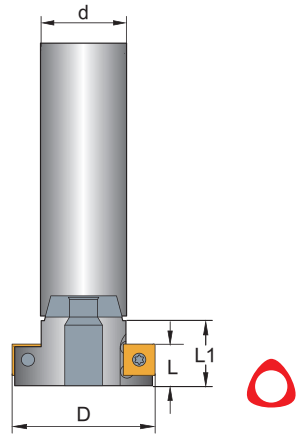


* The price and lead time are based on present conditions.

PRODUCT SPECIFICATIONS

UFO Back Boring Cutter - A Type

- Toolholders P. 26
- Insert P. 118
- Cutting Data P. 118



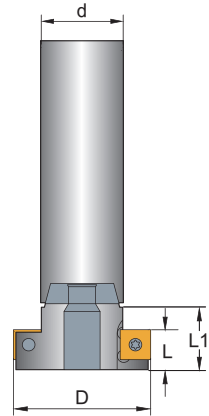
B3T

Order Code						Z	ZC	KG	MAX RPM	Inserts SDET	Screw	Key
Shank	Cutter	D	d	L	L1							
CB3-1010-80-20 CB3-1010-100-20	B3T-1018	18	10.4	9	14	2	1	0.04	14000	060208	C025045	T08P
	B3T-1018.5	18.5										
	B3T-1019	19										
	B3T-1019.5	19.5										
	B3T-1020	20				3						
	B3T-1020.5	20.5										
	B3T-1021	21										
	B3T-1021.5	21.5										
	B3T-1022	22										



UFO Back Boring Cutter - A Type

- Toolholders P. 27 - 28
- Insert P. 118
- Cutting Data P. 118

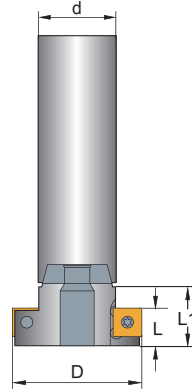


B3T

Order Code						Z	ZC	KG	MAX RPM	Inserts SDET	Screw	Key
Shank	Cutter	D	d	L	L1							
CB3-1212-90-25 CB3-1212-110-25	B3T-1223	23	12.4	9	14	3	1	0.04	13000	060208	C02506	T08P
	B3T-1224	24										
	B3T-1225	25										
	B3T-1226	26										
	B3T-1227	27						0.05				
	B3T-1228	28										
	B3T-1229	29										
	B3T-1230	30										
CB3-1616-120-30 CB3-1616-150-30	B3T-1631	31	16.4	12	17	3	1	0.06	12500	09T308	C04008	T15P
	B3T-1632	32										
	B3T-1633	33										
	B3T-1634	34										
	B3T-1635	35						0.10				
	B3T-1636	36										
	B3T-1637	37										
	B3T-1638	38										
	B3T-1639	39										
	B3T-1640	40							0.11			


UFO Back Boring Cutter - A Type

- Toolholders P. 29
- Insert P. 118
- Cutting Data P. 118



UFO Family

B3T

Order Code						Z	ZC	 KG	MAX RPM	Inserts SDET	Screw	Key
Shank	Cutter	D	d	L	L1							
CB3-2525-110 CB3-2525-170	B3T-2541	41	25.4	12	17	3	1	0.14	10000	09T308	C04008	T15P
	B3T-2542	42										
	B3T-2543	43										
	B3T-2544	44										
	B3T-2545	45										
	B3T-2546	46										
	B3T-2547	47										
	B3T-2548	48										
	B3T-2549	49										
	B3T-2550	50										
	B3T-2551	51										
	B3T-2552	52										
	B3T-2553	53										
	B3T-2554	54										
	B3T-2555	55										
	B3T-2556	56										
	B3T-2557	57										
	B3T-2558	58										
	B3T-2559	59										
	B3T-2560	60										



Recommended Insert Grades

• UFO Back Boring Cutter Insert Grade Selection

Material group	Recom. fz (mm/tooth)	Inserts		
		SDET.....ME	SDET.....E	
1	0.04-0.08	B100	-	-
2		B100	-	-
3		B100	-	-
4	0.04-0.07	B100	-	-
5		B100	-	-
6	0.04-0.06	B100	-	-
7		B100	-	-
8	0.04-0.08	B100	-	-
9		B100	-	-
10		B100	-	-
11	0.04-0.06	B100	-	-
12		F30	-	-
13	0.07-0.1	F30	-	-
14		F30	-	-
15		F30	-	-
16	0.1-0.2	-	-	-
17		-	-	-
18		-	-	-
19		B100	-	-
20	0.04-0.05	B100	-	-
21	0.03-0.04	B100	-	-
22	0.04-0.05	B100	-	-

Recommended Cutting Data - UFO Back Boring Cutter

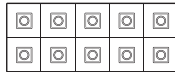
• Recommended Cutting Speed, Vc(m/min)

Material group	Grades											
	B100	C250	F20	CE60	CE	K10	F30					
	fz (mm/tooth)											
	0.04	0.06	0.08			0.08	0.10	0.12	0.08	0.10	0.12	
Cutting speed, v _c (m/min)												
1	16	18	20	-	-	-	-	-	-	-	-	
2	16	18	20	-	-	-	-	-	-	-	-	
3	14	12	10	-	-	-	-	-	-	-	-	
4	14	12	10	-	-	-	-	-	-	-	-	
5	12	10	8	-	-	-	-	-	-	-	-	
6	12	10	8	-	-	-	-	-	-	-	-	
7	8	-	-	-	-	-	-	-	-	-	-	
8	14	12	10	-	-	-	-	-	-	-	-	
9	14	12	10	-	-	-	-	-	-	-	-	
10	12	10	8	-	-	-	-	-	-	-	-	
11	12	10	8	-	-	-	-	-	-	-	-	
12	-	-	-	-	-	-	-	-	-	40	35	30
13	-	-	-	-	-	-	-	-	-	40	35	30
14	-	-	-	-	-	-	-	-	-	30	25	20
15	-	-	-	-	-	-	-	-	-	30	25	20
16	-	-	-	-	-	-	-	-	-	30	25	20
17	-	-	-	-	-	-	-	-	-	-	-	-
20	8	10	-	-	-	-	-	-	-	-	-	-
21	8	10	-	-	-	-	-	-	-	-	-	-
22	8	10	-	-	-	-	-	-	-	-	-	-



SDET

Tolerances (± mm)
L S



Inserts 10 PCS/Box

Code	Dimensions (mm)		
	L	S	B
0602	6.0	2.3	0.4
09T3	9.0	3.97	0.5

Inserts	Order Code	Grades										
		Carbide					Metal cermet			Uncoated		
		B100	C200	C250	F20	F30	CE25	CE100	CE60	K10	CE	
	SDET060208N-ME	⊙										
	SDET09T308TN-M	⊙										
	SDET09T308TN-ME	⊙										

- Steel Stainless Steel Steel/Stainless Steel/Super alloy Cast Iron Aluminum Steel/Cast Iron
- Steel/Stainless Steel/Cast Iron
- Prices and stocks are based on present conditions
- Please specify model numbers and the grade of inserts, ie.: SDET060208N-ME, B100