

Back spot facing cutter of optimal design that matches the cap bolt size.

- Easy programming, simply offset the machine spindle and starting hole centers before inserting into the hole.



We recommend the **BIG** NEW Hi- POWER MILLING CHUCK for holders/chucks.

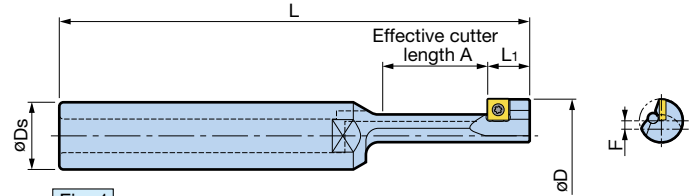


Fig. 1

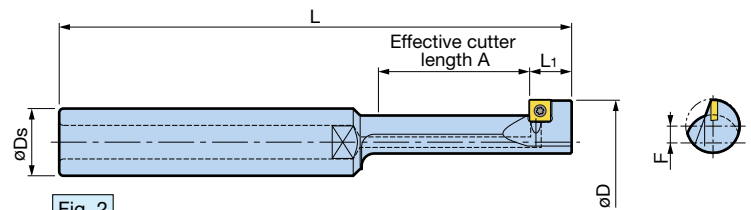


Fig. 2

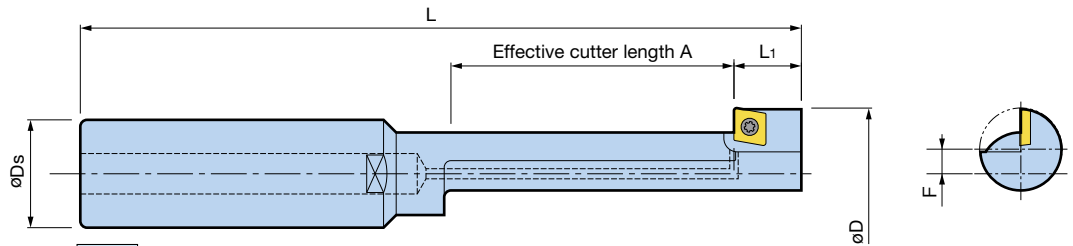
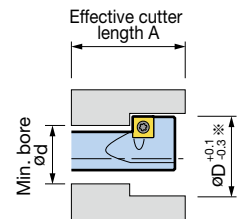


Fig. 3



● Model Description

ST16 - **BF** **M6** / **11** - **12**

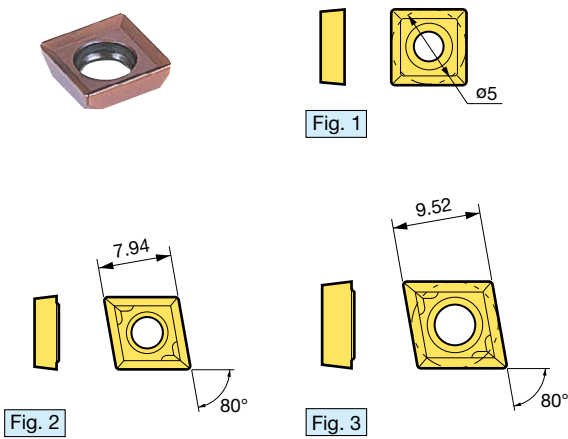
- Shank diameter
- Back spot facing
- Cap bolt size
- Spot facing diameter
- Effective cutter length

Model	Fig.	Spot facing diameter ϕD	ϕD_s	Min. hole ϕd	L	A	L ₁	Offset amount F	Insert Model	
ST16-BFM 6/11 - 12	1	11	16	6.5	102	12	9	2.40	CM0502	
-BFM 8/14 - 20		14		8.5	108	20		2.90		
-BFM10/17.5- 25		17.5		10.5	112	25		3.65		
-BFM12/20 - 36	2	20	20	13	122	36	3.65			
ST20-BFM14/23 - 49		23		15	136	49	4.15			
-BFM16/26 - 56	26	17	142	56	4.65	15	5.7			
ST32-BFM18/29 - 63	3	29	32	19	188			63		5.2
-BFM20/32 - 70		32		21	195			70		6.2
-BFM22/35 - 77		35		23	202			77		7.3
-BFM24/39 - 84		39		25	214			84		6.8
-BFM27/43 - 95		43		30	225	95	7.8			
-BFM30/48 - 105	48	33	235	105		20	7.8	CC□□09...		

1. A wrench and screws are included. Inserts must be ordered separately.

2. The tolerance marked with ※ is only for reference, as the actual diameter varies depending on rigidity of the machine or workpiece, as well as the cutting conditions.

<Insert> (Optional)



Model	Fig.	Nose radius	Material	Insert grade
CM0502	1	0.2	General Steel	ACP200
CM0502			Stainless Steel	ACM250F
CM0502			Aluminum/Non-ferrous	DS20
CCGP070204EFM	2	0.4	General Steel	T1500A
CCMP070204EFM				AC820P
CCMP070204EFM				AC830P
CCMP070204ESM			Stainless Steel	AC630M
CCMP070204EFM			Cast Iron	AC700G
CCMP070204EFM			Cast iron/Aluminum/Non-ferrous	AC410K
CCGA070204FN	3	0.8	General Steel	H1
CCGM090308EFM				T1500A
CCMM090308EFM				AC820P
CCMM090308EFM			AC830P	
CCMM090308ESM			Stainless Steel	AC630M
CCMM090308EFM			Cast Iron	AC700G
CCMM090308EFM	Cast iron/Aluminum/Non-ferrous	AC410K		

1. Inserts are available in packets of 10 pcs.
Please specify the insert model number and grade when ordering.

Insert Grade Description

ACP200	ACM250F	DS20	T1500A	AC820P
For general steel	For stainless steel	For aluminum/non-ferrous	For general steel	For general steel
PVD-coated carbide with superior wear resistance due to its nanometer-level thickness ultra-multilayered TiAlN and AlCrN film.	PVD-coated carbide with excellent smoothness and resistance to welding and chipping, due to the ultra-multilayered thin film structure made of AlTiN and TiAlCrN.	DLC-coated carbide exclusive for aluminum and non-ferrous metals, ultra-smooth with a low wear coefficient and superior welding resistance.	General purpose cermet for applications in regions from finishing to roughing. Special technology improves the material's resistance to thermal shock, allowing safe use even for wet machining.	The newly developed CVD method allows for a dense yet smooth coating that achieves outstanding versatility and consistency as the main material for steel.
AC830P	AC630M	AC700G	AC410K	H1
For general steel	For stainless steel	For cast iron	For cast iron/aluminum/non-ferrous	For cast iron/aluminum/non-ferrous
The tough substrate and the peel-resistant, dense and smooth coating deliver high reliability for interrupted cutting of steel.	The extremely smooth thin film coating gives this material great sharpness. Ideal for stainless steel or other materials that are easily work hardened.	Heat resistant carbide alloy is coated with multiple layers of mainly tough alumina, with additional surface smoothing treatment, to produce a highly reliable material for machining cast iron.	The hardest material for cast iron. Use if not satisfied with the wear resistance of AC700G. Note that this type is not suitable for heavy duty interrupted cutting.	With slightly higher wear resistance than K10 material, this material is a best selling type of carbide that can be used across a wide range from roughing to finishing.

<Spare Parts>

Cutter size	Insert Clamping Screw Set	Cutter size	Insert Clamping Screw Set
BFM 6 / 11	S2SS-T6	BFM18 / 29	S3S
BFM 8 / 14		BFM20 / 32	
BFM10 / 17.5		BFM22 / 35	
BFM12 / 20	S2TS-T6	BFM24 / 39	S4S-T15
BFM14 / 23		BFM27 / 43	
BFM16 / 26		BFM30 / 48	

1. The insert clamping screw set contains 10 screws and 1 wrench.

Cutting Conditions

Workpiece material	Cutting speed Vc (m/min)	Feed f (mm/rev)
Carbon Steel, Alloy Steel	30	0.03
Cast Iron	30	0.03
Aluminum/Non-ferrous	30 - 50	0.03